

MANUFACTURING SPECIFICATIONS

PRODUCT:

DIVISION BP

SPEC. NO.

RS-72

MANVILLE

DEPT.

Veneer for Smoothgrain
Permatone Shingles

PAGE NO.

RIGIL SHINGLES

PLANT

1

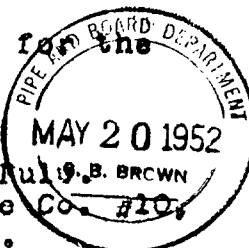
FORMULA:

CANCELLED

P.S. No.	Material	Batch Size	
		Standard	Alternate
-	7FO4 Fibre	100# 7.0%	100# 7.0%
61001	White Portland Cement*	376 26.4	376 26.4
61281	J-M Special Silica Flour**	300 21.0	300 21.0
-	#281 or #263 Celite	50 3.5	50 3.5
63385	Dry Ground Whiting***	500 35.1	500 35.1
61296	Veneer Sand (#75)****	100 7.0	- -
61296	Veneer Sand (O Grade)****	- -	100 7.0
		1420# 100.0%	1426# 100.0%

Notes: Following are the approved sources of supply for the raw materials shown:

- * New Mill Atlas Cement
- ** Use Penn. Pulv. only. Do not use N.J. Pulv.
- *** Thompson Weinman Co. #10, Georgia Marble Co. #10, R. C. Carroll Inc. Grade "R" York White.
- **** Michigan Silica Co. is the vendor for #75 Grade, Ottawa Silica Co. for "O" Grade.

X MANUFACTURING INSTRUCTIONS:

1. Charge the top mixer with Fibre and follow with the balance of the materials shown in the formula.
2. Mix for approximately 20 minutes depending on shingle machine speed.
3. Drop batch into the bottom mixer at a rate which will not jam the machine.
4. Feed Continuously through the Rietz Disintegrator to the Selectro Screen and apply to the moving sheet.
5. When not used immediately, store in metal drum keeping the mixture thoroughly dry until used.

X- INDICATES REASON: Revise Formula and Mfg. Instructions.

AUTHORITY FOR CHANGE Product Proposal Av. 1410-FF-215 Summarized 4/25/52

FILE-HOLDERS	Ind. Eng.	Wkg.	SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DIR. QUAL. CONTR.
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SUPERSEDES: Page 1 of same Spec issued 9/14/51

DATE ISSUED

PLAINTIFF'S
EXHIBIT
JM-2460

RETURN TO
J-M RESEARCH
FIF ROOM

~~RIGID SHINGLES~~ DEPT.RS-72

PAGE NO.

MANVILLE PLANTVeneer for Smoothgrain
Permatone Shingles 4231FORMULA:

<u>P.S. No.</u>	<u>Material</u>	<u>Batch Size</u>	
-	7FO4 Fibre	100#	7.0%
61001	White Portland Cement*	376	36.4
61281	J-M Special Silica Flour**	300	21.0
63386	No. 10 Dry Ground Whiting***	550	38.6
61296	Veneer Sand (#75 or 0 Grade)****	100	7.0
		1426#	100.0%

Notes: Following are the approved sources of supply for the raw materials shown:

- * New Mill Atlas Cement
 ** Use Penn. Pulv. only. Do not use N.J. Pulv.
 *** Thompson Weinman Co. #10, Georgia Marble Co. #10, R. E. Carroll Inc. Grade "R" York White.
 **** Michigan Silica Co. is the vendor for #75 Grade, Ottawa Silica Co. for "0" Grade.

MANUFACTURING INSTRUCTIONS:

1. Charge the top mixer with Fibre and follow with the balance of the materials shown in the formula.
2. Mix for approximately twenty minutes depending on shingle machine speed.
3. Drop batch into the bottom mixer at a rate which will not jam the machine
4. Feed continuously through the Rietz Disintegrator to the Selectro Screen and apply to the moving sheet.
5. When not used immediately, store in metal drum keeping the mixture thoroughly dry until used.



MT-000425

X- INDICATES CHANGE - REASON: Revise formula to eliminate Celite and replace with Dry Ground Whiting.

AUTHORITY -
FOR CHANGE

Product Proposal Waukegan 440-537 Summarized 3/16/53

FILE-HOLDERS

Ind. Eng.

Wkg.

SUPR.
QUAL.
CONTROLPROD.
SUPT.PLANT
FINANCE
OFFICERESEARCH
LAB.MGR.
QUAL.
CONTROLDIR.
QUAL.
CONTROL

SUPERSEDES: Page 1 of same Spec issued 5/16/52 and Deviation #929 issued 6/21/52

DATE ISSUED
APR 17 1953

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