

MANUFACTURING SPECIFICATIONS

WAUKEGAN

PLANT

RIGID SHINGLES

DEPT.

PRODUCT:

New Colorboston Process Siding Shingles

DIVISION

LP

SPEC. NO.

423-2.22

PAGE NO.

PLAINTIFF'S
EXHIBIT
JM-2435

FORMULAS

"B" Type

Formula No.	1	2	3	4	5	6	7	8
6D20 Fibre *	300	300	300	300	300	300	300	300
Portland Cement	501	501	501	501	501	501	501	501
Silica Flour	333	333	333	333	333	333	333	333
Shingle Scrap (Note 1, 2)	550	525	500	475	450	425	400	375
Min. Batch Weight	1684	1659	1634	1609	1584	1559	1534	1509
Other Scrap (Note 3)	100	125	150	175	200	225	250	275

NOTES:

1: (a) Shingle Scrap should be blended 1 part normal cured to 2 parts uncured.

From 0 to 100 lbs. of the Shingle Scrap may be replaced by any of the following approved Mineral Fillers: Mastie Filler, Limestone Dust, Limestone Aggregate, Ground Trap Rock, Graystone and Terrazo Pipe Scrap and Rock Wool Shot.

When surplus fibre is used in the base furnish of 100 Siding Shingles, an additional 10% (total of 20%) of Dolomite may be used to replace Shingle Scrap.

(b) Rock Wool Shot must be introduced at the Shingle Scrap producers and must be evenly distributed throughout the scrap.

2: At Waukegan Plant, when the Liberator is in operation, an additional 100% of Shingle Scrap may be added to the formulas above.

3: (a) Wet Machine Scrap, Corrugated Transite Scrap or Transite Pipe Scrap may be added to the formula above up to the amounts shown.

(b) Also up to 75% of material from the Dust Collectors and/or 75% of Machine Drop from the same or other machines producing similar stock may be added to the above formulas.

Caution: The use of scrap should be planned so that it will not be necessary to shift more than two successive formulas at any time. Violent shifts should not be made.

* 6DAX-2498 Fibre may be used as an alternate in all base formulas. It is to be used on the basis of a lb. for lb. replacement for both 6D20 Fibre and 6D20 Surplus Fibre.

RETURN TO

J-M RESEARCH

FILE ROOM

X—INDICATES CHANGE—REASON: General revision

AUTHORITY FOR CHANGE

Various - refer to Enactment Letter 12-3-57

FILE-HOLDERS

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SUPERSEDES:

Page 1 of RS-F-2 dated 2-11-57

MT-000265

DATE ISSUED

JUN 30 1958

