

MANUFACTURING SPECIFICATIONS

PRODUCT:

DIVISION IP

SPEC. NO.

Waukegan

PLANT

Transite Pipe, Fibre Blends
and Standard Furnish Batch

72.1

PAGE NO.

Transite Pipe

MAY 28 1956

3

I. FORMULA 13' Machine

A. Fibre Blend

-1, -2, or -3 Basis

M-482

	Lbs.	%
Blue	300	29.7
47	160	15.8
42AX	550	54.5
	1010	100.0
Scrap	200	
	1210	

M-489

	Lbs.	%
Blue	300	30.0
47	400	40.0
42AX	300	30.0
	1000	100.0
Scrap	200	
	1200	

M-492

	Lbs.	%
Blue	300	28.2
47	400	37.7
42AX	300	28.2
C&G	62.5	5.9
	1062.5	100.0
Scrap	210	
	1272.5	

Use blend M-472 on swing mandrel production until stocks of BC4-T & N-479-4T fibre are depleted.

M-472

	Lbs.	%
S Blue	100	
Inst. Blue	88	31.5
HC 300 Blue	125	
47	280	28.2
42	150	15.1
4T	250	25.2
	993	100.0
Scrap	200	
	1193	

M-490

	Lbs.	%
S Blue	300	29.3
47	100	9.8
42AX	500	48.7
C&G	125	12.2
	1025	100.0
Scrap	200	
	1225	

M-491

	Lbs.	%
S Blue	300	28.6
47	400	38.0
42AX	300	28.6
	50	4.8
	1050	100.0
Scrap	210	
	1260	

NOTE: Add 100# Reprocessed per batch - 1 blend, 200# per batch - 2 blend, 300# per batch - 3 blend

Fiber and scrap shall be thoroughly mixed in the mixer, willow fibre blend at rate which will insure a proper buoyance. Batch size may be varied provided batch proportions are maintained.

On hand stocks of 47T may be used as a substitute for, or in conjunction with, BC4T and Normandie 4T in Blend M-472. Also as in case of previous blends, C&G may be substituted for Blue when available.

New Mill 42AX may be substituted for 4220

New Mill 6DAX may be substituted for 6D20

RETURN TO
J-M RESEARCH
FILE ROOM

X - INDICATES CHANGE - REASON: To show Blends M-489, M-490, M-491, M-492 as Authorized Blends.

AUTHORITY - M-489 T.R. Turnbull's wire of 4-23-56 M-490 & M-491 Verbal Authority of T.R. Turnbull 5/3/56
FOR CHANGE M-490 T.R. Turnbull's wire of 4-19-56

FILE HOLDERS I.E. MVL. LAB. FOREMAN DEPT. CHIEF PLANT PLANT OFFICE RESEARCH LAB. CHIEF

SUPERSEDED Page 3 issued 1-19-56 and Notice of Deviation #10 dated 5-1-56 DATE REVISED