PLAINTIFF'S EXHIBIT
WH-816

PROCESS SPECIFICATION
APPLICATION OF SHEET INSULATION

CHANGED 1/6/59 3

GENERAL:

IN ORDER TO PROVIDE THERMAL INSULATION AND TO PREVENT THE TURBINE HEAT FROM BURNING THE PAINT FROM THE OUTSIDE SURFACE OF GAUGE BOARDS, A SHEET INSULATION LINING SHALL BE APPLIED TO THE INSIDE SURFACES THEREOF. THE DETAILED PROCEDURES NECESSARY TO APPLY THE SHEET INSULATION LINING ARE DESCRIBED IN THIS SPECIFICATION.

OPERATIONS:

(1) FITTING FLEXIBLE ASBESTOS SHEET MATERIAL 7791.
(2) APPLYING ADHESIVE CEMENT MATERIAL 7792.
(3) APPLYING SHEET STEEL RETAINING STRIPS MATERIAL 1516-1.
(4) FINISHING.

(1) FITTING FLEXIBLE ASBESTOS SHEET MATERIAL 7791.

FLEXIBLE ASBESTOS SHEET MATERIAL 7791, STOCKED IN ONE INCH THICK SHEETS, MAY BE CUT ON POWER SHEARS, BY HAND SAW OR BY POWER SAW. WHEREVER POSSIBLE, COVER AN AREA WITH ONE PIECE OF SHEETING. WHERE JOINTS ARE NECESSARY, FIT THE PIECES IN A MANNER SO THAT ALL JOINTS WILL BE UNDER RETAINING STRIPS. ARRANGE THE JOINTS SO THAT THE RETAINING STRIPS WILL, WHEN APPLIED, FORM AS SYMMETRICAL A FRAME AS PRACTICAL.

ALL INSULATION JOINTS SHALL BE BUTTED AND FITTED IN SUCH A MANNER THAT GOOD CONTACT SHALL EXIST BETWEEN SHEET METAL AND INSULATION SURFACES, AND BETWEEN INSULATION JOINTS.

(2) APPLYING ADHESIVE CEMENT MATERIAL 7792.

HIGH TEMPERATURE ADHESIVE CEMENT MATERIAL 7792 IS STOCKED IN DRUMS.

APPLY WITH A STIFF BRISTLE BRUSH A THICK, GENEROUS COATING TO ALL INSIDE GAUGE BOARD SURFACES TO WHICH INSULATION WILL BE SECURED.

WHEN ALL SURFACES HAVE BEEN COVERED WITH THE ADHESIVE, PRESS THE VARIOUS SECTIONS OF SHEETING INTO THE RESPECTIVE POSITIONS FOR WHICH EACH SECTION WAS CUT.

THE JOINT FACES OF THE ASBESTOS SHEETING SHALL ALSO BE COATED WITH ADHESIVE BEFORE BEING BUTTED TOGETHER.

(3) APPLYING SHEET STEEL RETAINING STRIPS MATERIAL 1516-1.

CUT FROM 1/8 INCH SHEET STEEL MATERIAL 1516-1 STRIPS 1 INCH WIDE TO FORM A FRAMEWORK TO SECURE THE INSULATION TO THE INSIDE OF THE GAUGE BOARD.

STRIPS SHALL BE STRAIGHT AND SHALL BE SPACED APPROXIMATELY 12 INCHES APART IN LENGTH AND WIDTH DIRECTIONS ON THE INSULATION SURFACES OR IN A MANNER TO FORM A SUPPORTING FRAMEWORK WHICH SHALL SECURE AND HOLD THE INSULATION FIRMLY TO THE INSIDE OF THE INSULATED PART. WHERE STRIPS JOIN OR INTERSECT, THEY SHALL BE LAP JOINED AND FILLET WELDED.

AT THE EDGES OF THE INSULATED SURFACE, THE STRIPS SHALL BE BENT AT 90° OVER THE INSULATION EDGE AND THE END OF THE STRIP SHALL BE FILLET WELDED TO THE INSULATED SURFACE. SEE FIG. 1.

(4) FINISHING

WHEN ALL RETAINING STRIPS HAVE BEEN WELDED IN PLACE, ALL EXPOSED EDGES AND JOINTS OF THE ASBESTOS SHEETING SHALL BE COVERED WITH A THICK COATING OF MATERIAL 7792 ADHESIVE CEMENT.

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PROCESS SPECIFICATION
APPLICATION OF SHEET INSULATION

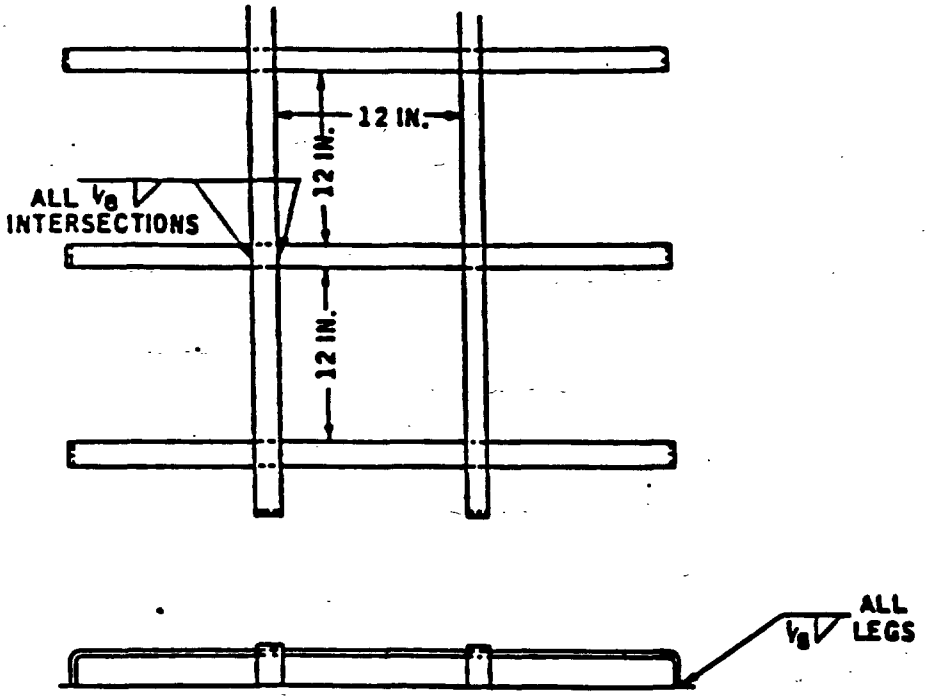

FIG. 1

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