

Johns-Manville MANUFACTURING SPECIFICATION	PRODUCT: CEDARBESTOS - INTERLAY, UNDERLAY	PLANT & DIV.	Waukegan BP
		SPEC NO.	441.7
		PAGE NO.	1 of 2

FORMULA	Percent Dry	Lbs. Beater Batch	
		Dry	*Charging Formula
<u>Raw Materials</u>			
6-19, 6-22 or 6-25	92.46	1850.0	1850.0
Hercules S1451	1.0	20.0	50.0
Santowhite 6924	0.1	2.0	4.2
Daxad 30	0.4	8.0	32.0
Neoprene 736	4.0	80.0	232.0
Aquablak B	0.04	0.8	2.3
Alum	2.0	40.0	40.0
	100.0	2000.8	2210.5

*All materials listed under Charging Formula, with exception of fibre and alum, shall be mixed with three (3) parts water prior to being charged into the beater. Fibre will be charged in the normal manner and alum shall be mixed with ten (10) parts water).

All diluted additives - Hercules S1451, Santowhite 6924, Daxad 30, Neoprene 736, Aquablak B and Alum are to be charged in the below order across surface of stock as it approaches beater roll.

1. Charge fiber and water and bring up to desired 6% solids asbestos-water slurry. Mix thoroughly with beater roll down. Brush with beater roll down for 15 minutes while heating stock to 120 - 130°F.
2. Raise beater roll and add proper amount of diluted Hercules S1451 and diluted Santowhite 6924.
3. Mix diluted Daxad 30 and diluted Neoprene 736 binder together and charge.
4. Charge diluted Aquablak B.
5. Charge diluted Alum.
6. Mix beater batch well, approximately 20 - 25 minutes, with beater roll raised then drop. Dry broke may be added at the beaters and properly processed.
7. Insert 4, #150 - 1/0 Glass Threads per linear inch on 1/4" centers into the sheet. Ends in the sheet should show four threads to the inch in at least 95% of the sheet.
8. Run product to the physical characteristic requirements of the Finished Product Specifications. Slit 37" wide by approximately 3500' long.
9. All splices must be plainly marked and with not over two splices per roll. Splices must not be less than 12" to the core and not less than 6" from outside edge of the roll.
10. It is preferred to wind on metal-end cores; if not available use paper cores.

MT-000156

X- INDICATES CHANGE —REASON: X - Show current Jeffrey 6 Grade Fibres.

AUTHORITY FOR CHANGE: Fibres currently available from Mines.

SUPERSEDES: Page 1 of same spec issued 6/24/70.

MR. MGR. SUPR. PROD. PLNT. Insp. Q.C.

DATE 1/26/71

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