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NAVY DEPARTMENT

BUREAU OF CONSTRUCTION AND REPAIR

DB

WASHINGTON, D. C.

March 28, 1938

Refer to No.

MEMORANDUM FOR FILE

Subject: Bureau C&R Specification 33G8 (INT)
Gaskets; Asbestos-Metallic Cover,
Rubber Core (For Flame-Resistant Hinged
Closures).

Reference:

- (a) Philadelphia Yard, 3rd end. 4 March, 1938, No. CA45/S72(JJ33(C-11)) filed on Bucon file No. (NSA) 344-38/NY4.
- (b) Puget Sound 2nd end. 4 May, 1937 No. JJ33-Gaskets, filed on Bucon file No. L2/JJ-33G8.
- (c) Garlock Packing Co. let. 25 March, 1937.

1. The proposed revision of the specification was made in order to provide competition and make available gaskets without seam, such as braided construction, which are just as satisfactory as the gaskets covered by the present specification.

2. Philadelphia Navy Yard and Puget Sound Navy Yard, reference (a) and (b), recommend that the present specification be amended to include, as an alternate product, the type of cover manufactured by the Garlock Packing Company. The deficiencies mentioned in reference (b) have been eliminated in the product of the Garlock Packing Company and it is believed that the revised specification will insure procurement of a product equal to, if not superior than, the product obtainable under the old specification.

3. Asbestos-Metallic braided cover, rubber core gasket, is manufactured by the Garlock Packing Company and the Anchor Packing Company, whereas, the asbestos-metallic cloth cover, rubber core gasket is available, insofar as is known, only from Johns-Manville Company.

Theodore A. Munkwitz

This job done under the number 33G8 (INT) and the date 4/1/38.

G.H. Cross

CRMC-M&S-003267

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19-287-104 Specs for Gasket Asbestos-Metallic Cover, Rubber Core

BSA002

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F-3. Heat Resistance.-A specimen of the gasket, when placed with any face across the hottest portion of the flame of an ordinary Bunsen burner for 15 seconds, and cut at the exposed section, shall not show any melting of the rubber core.

G. Packaging, Packing, and Marking for shipment.

G-1. Packaging.-Unless otherwise specified, commercial packages are acceptable under this specification.

G-2. Packing.-Unless otherwise specified, gaskets shall be delivered in standard commercial containers so constructed as to insure safe delivery by common or other carrier to the point of delivery at the lowest rate. Wooden boxes or cases, when used as containers, shall be well made of substantial material and shall weigh not in excess of 250 pounds gross when packed for shipment. Corrugated paper or solid fiberboard cartons shall comply with Consolidated Freight Classification rules in effect at the time of shipment. Containers made of corrugated paper or solid fiber, when packed for shipment, shall weigh not in excess of approximately 60 pounds gross.

G-3. Marking.

G-3a. Packages.-Each package shall be marked with the name of the material and the quantity contained therein, as defined by the contract or order under which shipment is made, and the name of the manufacturer.

G-3b. Shipping containers.-Shipping containers shall be marked with the name of the material and the quantity contained therein, as defined by the contract or order under which shipment is made, the name of the contractor, the number of the contract or order, and the gross weight.

H. Notes.

H-1. Gaskets shall not be lubricated with graphite or other material.

H-2. Copies of Navy Department specifications and any other specifications forming a part thereof may be obtained upon application to the Bureau of Supplies and Accounts, Navy Department, Washington, D. C. Except that naval activities should make application to the Commandant, Navy Yard, New York, N. Y. When requesting, refer to specification by both title and number (or symbol).

H-2 Gaskets are intended for use on hinged closures and are required to be flame resistant

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C-1c. Adhesive.-The adhesive used between the inner and outer cover and between the inner cover and the rubber core shall be such that it shall not be possible to strip the inner and outer asbestos metallic cloth or braid cleanly from each other or from the rubber without the use of solvents.

C-2. Workmanship.-Gaskets shall be free from defects.

D. General Requirements.

See Section E.

E. Detail Requirements.

E-1. Gaskets shall consist of a rubber core, $\frac{1}{2}$ " square, covered with either (a) two plies of asbestos metallic cloth, or (b) two successive asbestos metallic braids, making in either case a gasket $\frac{3}{4}$ inch square. The finished gasket may have a plus tolerance of $\frac{1}{16}$ inch but no minus tolerance. The minimum distance measured diagonally across the corners of the gasket shall be $\frac{15}{16}$ ".

E-2. Gaskets shall be not less than 11 feet nor more than 23 feet in length, unless otherwise specified in the contract or order.

F. Methods of Sampling, Inspection, and Tests.

F-1. Sampling.-A sample 5 feet long shall be taken by the inspector from each lot of 200 pounds or fraction thereof.

F-1a.(1) Asbestos-Metallic Cloth.-The weight of the cloth shall be determined on a sample or samples selected by the inspector and guaranteed by the manufacturer to be from the material which was used for covering gaskets. The remaining tests on the cloth shall be made on covers stripped from the sample referred to in paragraph F-1.

F-1a.(2) Asbestos-Metallic Braid.-The weight of the asbestos-metallic yarn shall be determined on a sample or samples selected by the inspector and guaranteed by the manufacturer to be from the yarn which was used for covering gaskets. The remaining tests on the yarn shall be made on sections of braid cut from the sample referred to in paragraph F-1.

F-1b. Rubber.-Specimens for physical tests shall be cut from the sheet from which the rubber strips are cut. Samples for chemical analysis shall be taken from the sample referred to in paragraph F-1.

F-2. Flame resistance of cloth.-A specimen of asbestos-metallic cloth or braid, approximately 3 inches square, when held horizontally in the hottest portion of the flame of an ordinary Bunsen burner for $1\frac{1}{2}$ minutes, shall not carry flame nor shall the compound have been consumed, when it is removed from the Bunsen flame.