

MANUFACTURING  
SPECIFICATION

Fiberglass Asphalt  
Asbestos Shingles

SPEC NO.

4455-19-1

PAGE NO.

1

Colors

See Finished Product Specification for current colors produced at this location.

Formula

Composition per square - 144 Sq. Ft. - 96 Shingles

| Spec #    | Material              | #/100 Sq. Ft. | #/Sq.  | %      |
|-----------|-----------------------|---------------|--------|--------|
| MS4411-1  | 12# Asbestos Felt-36" | 12.0          | 17.5   | 10.5   |
|           | Roll Saturant         | 7.2           | 10.3   | 6.3    |
|           | Filled Coating-Face*  | 32.0          | 46.1   | 28.1   |
|           | Filled Coating-Back*  | 4.5           | 6.5    | 4.0    |
| MS4455-1  | Granules - #8         | 54.2          | 78.0   | 47.6   |
| PS-BP1268 | Fine Sand             | 4.0           | 5.8    | 3.5    |
|           | Totals                | 113.9#        | 164.0# | 100.0% |

\*Filled Coating

7 Grade Fibra - %

.5 To 1.0

Limestone Dust

50.0 To 59.5

Unfilled Coating

40.0 TO 50.0

PLAINTIFF'S  
EXHIBIT  
JM-2446

Manufacturing Procedure

1. See Manufacturing Specifications 4455-0 for general instructions.
2. Maintain saturation above 55% minimum.
3. Set granula applicator to apply blends in 11" bands. Total blend cycle should be 66".
4. Check searing between pairs periodically for assurance that individual shingles are separating cleanly.

Packaging

Package in accordance with Finished Product Specifications.

MT-000309

PLEASE RETURN TO

J-M RESEARCH

LIBRARY (MM)

X— INDICATES  
CHANGE —REASON:

New Product

AUTHORITY  
FOR CHANGE

PLC 048-5-68 Issued 2/22/68

SUPERSEDES:

None

MGR.  
S.C.C.

MGR.  
Q.C.

SUPR.  
O.C.

PROD.  
SUPT.

PLNT.  
FIN.

REV.  
CHK

J.C. Jones

LA

Insp.

DATE  
ISSUED

MAR 15 1968

