

copy made for
 1. J. J. K.
 2. Ron Weedon
 9/15/67

RAYBESTOS-MANHATTAN, INC.

PACKING DIVISION
 Bridgeport, Conn.

D. E. G.		M. D. B.
J. C. M.		W. W. R. J. J. K.
M. H. K.		S. M. L.
SECTION	SEP 18 1967	INFO
GASKET ENGINEERING		
Hard	OF	Soft

September 15, 1967

File
 outside

Pls note &
 take steps
 to correct the
 blanking operation

Mr. M. H. Kapps
 Victor Manufacturing & Gasket Company
 5750 West Roosevelt Road
 Chicago, Illinois 60650

CAT 75 5741
 VICTOR RD 35161-02
 d/c R 239 896
 Cat order MAA 84.50

Cutting
 bands replaced
 Dies to be
 sharpened
 16

Dear Harry:

Subject: R/M A-56, 1/32", AS for Caterpillar

In reviewing the problem concerning the initial rejection of 235 sheets on your purchase order #124102, you reported 10,100 psi in the machine direction and 4,030 psi in the cross direction. The specification requirements were 11,000 and 5,000 psi. We, as well as Caterpillar, checked the tensile strength and Caterpillar results were 13,500 psi and 4,470 psi. Raybestos results were 11,970 psi and 4,357 psi. In addition, Raybestos ran all of their other tests in the Caterpillar specification IE 678 and found everything else to be within the specification limits. Due to the severity of the application at Caterpillar, we agreed to take this material back and replace it with material which also passed the cross grain tensile requirement. From the work which we have done on the second shipment, we believe the low tensile might be one sheet of the original shipment. We plan to run further checks on the first shipment which you returned.

On the replacement order of this material, which Caterpillar urgently needed, we shipped 170 sheets on August 17, and 66 sheets on August 21. You also rejected this material because of low cross grain tensile. We reported that the manufacture of this material was closely supervised by the production and quality control departments. We were able to find two sheets which Quality Control had retained and the following results were obtained at Raybestos, Caterpillar, and Victor.

see p. 2

	Sheet 1	Sheet 2
Original Test, 8/16/67	5075 **	4960 *
Re-Check, 9/8/67	5502 **	5146 *
Caterpillar	5520	5362
Victor	5042 *	4530 * 4654 on 4

ALL PRICES ARE SUBJECT TO CHANGE IN RESPECT OF DUTIES, EXCISE TAXES OR OTHER CHARGES, HEREFTER IMPOSED BY ANY FEDERAL, STATE, OR MUNICIPAL AUTHORITY, OR BECAUSE OF INCREASES IN COST OF MANUFACTURE, PROCESSING, OR SALES, RESULTING FROM OPERATIONS OF ANY FEDERAL, STATE, OR MUNICIPAL LAW, OR REGULATORY MEASURE HEREFTER ADOPTED.

VPD-81-0000610

DANA-078

* Width of the test specimen was 0.485". 0.500" was used as width in the calculation. Therefore, results with an asterisk (*) should be 150 lbs. higher.

It is interesting to note that the Caterpillar and the re-check results of Raybestos are quite similar while the Victor results run 500 to 800 lbs. lower. It is evident that Victor results run consistently lower than the Caterpillar and Raybestos results.

Victor has run 15 checks on 7 different sheets. They cut samples from an adjacent area to these sheets and sent them to Raybestos for test. Raybestos results ran from 300 lbs. to 2,100 lbs. higher than the Victor results.

In attempting to understand the very large difference in results which are listed below, we believe that it is due to a very poor cutting job of the tensile specimens. We have never seen samples cut so poorly and it has even caused the fracture of some of the sheets and delaminated them. As a gasket cutter, you should know how to cut cleanly. A-56, even though it is tough, cuts cleaner than the K-68. In examining these tensile specimens, which we pulled and are retaining, not enough pressure was used in cutting. They were cut cleanly a half to three quarters of the way through and the rest of the area was just pulled and not cut.

The Raybestos results, with one exception, in the 15 tests were above minimum. We question the low tests as this could be a defective sample.

The following are the results:

		Victor	R/M	Victor	R/M	Victor	R/M
Carton 1		4380	5090	4125	5000		
"	2	4680	6160	4470	5240		
"	3	4125	5100	4250	6300		
"	4	4300	5050	4160	5020		
"	5	4180	5230	4380	5155	4550	4870
"	6			4420	6225	4380	5100
"	7			4650	6060	4960	5880

After discussing the above results with Lou Crystal and Crawford Ellis, the shipment you have is satisfactory and meets the requirements of the IE 678 specification which Raybestos certifies.

VJL
NOTE
CORRECT
what the
cutting is very
true.
In spite of
he still got
results than we
did.

Mr. M. H. Kapps
Page 3
September 15, 1967

When we were discussing the above on the phone, you raised the question of eight or nine weeks delivery on A-56, .008". In sheets 50 x 50 with a tolerance of .0015, we ship in three to four weeks and much faster if needed as an emergency shipment by Caterpillar. We have had this delivery time stated on other materials by Victor to end users which is most disturbing. This should be straightened out immediately.

Very truly yours,

Unsigned

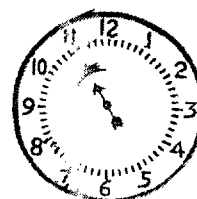
George D'Olier
Chief Engineer, Gasket Materials

GDO:jb

cc: L. Crystal - Caterpillar
E. Schlifke - R/M Chicago

VPD-81-0000612

SEP 20 '67



RESEARCH LABORATORY

VPD-81-0000613

10/11

TO:

OFFICE

FROM

OFFICE

SUBJECT

DATE

MESSAGE:

JTH
PC 1H
Materials Development Lab

9/26/67

Re Sample Cutting.

During the recent hassle with R/M
over 956 Tensile, we put dumbbells
here and sent them to R/M
Note their comments in the attached
and initiate whatever action is
necessary to correct.

Thanks,

SIGNED

REPLY

New cutting Board - Jm
received today - 9-26-67
Vigilante would do it -
CA.

DATE

SIGNED

C O P Y

B. R. Basile

September 15, 1967

W. J. Sheehan

Effective September 8, 1967, we reduced supervision in the
Hard Gasket operation by one foreman L.G. 8 (John Cohoon).

W. J. Sheehan

rab

VPD-91-0002364

C O P Y

September 15, 1967

TO: W. D. Neathery

cc: R. H. Burns

R. McGranahan

FROM: R. H. Bates

B. R. Basile

R. Myland

W. J. Sheehan

J. Struzina

G. Schuppe

D. Novak

SUBJECT: DEPARTMENT 14 - PRECOTE OVEN
PRODUCTION & UTILIZATION

R. DeFilippis

P. Aughney

WEEK OF: September 5, 1967 through September 8, 1967
4 Day Week - No Saturday Work

<u>Shift</u>	<u>Total Hours</u>	<u>Total Hours Down</u>	<u>Total Hours Running</u>	<u>Total Pieces Processed</u>	<u>Total Pieces Rejected</u>	<u>Total Pieces Good</u>	<u>Utilization</u>
B	32.0	6.9	25.1	92,096	5,389	86,707	78%
C	32.0	8.8	23.2	35,808	4,637	31,171	72.5%
Totals:	64.0	15.7	48.3	127,904	10,026	117,878	75%

Reasons for Down Time Hours:

Clean Oven	2.0
Removes slugs from parts	.5
Jam-ups	3.0
Clean Belt	.3
Maintenance & Breakdown	9.5
Water Problem	.4
	<u>15.7</u>

R. H. Bates

RHB/slk

VPD-91-0000441