cc: ~~Mr. Johnston~~
~~Mr. Potter~~

MEMORANDUM
SHREVEPORT

In Reply to _____ Date 7-18-55 From B.P.Soward To Mr. Chamberlain - EW

Subject _____

I am enclosing report written by Dick Potter covering the trial run of dry felt using the auxiliary spray on Masterbilts for the first and second shift and then running the companion rolls of dry felt on both shifts the following day with the auxiliary spray off.

It is important to note that we were unable to obtain proper saturation with the auxiliary spray off and, too, we were unable to run over 150 volts or 270 feet per minute. Whereas with the auxiliary on we ran between 225 and 240 volts, or 405 to 432 feet per minute. This is a tremendous difference in speed and also at the 405 to 432 feet per minute with the auxiliary on we obtained much better saturations.

In order that the test be as fair and accurate as possible, I spent a good deal of time on the machine with Potter. He was there continuously during the test so that accurate information could be given you. Both Potter and I feel as though this is as fair a test as we could run.

It seems when the sheet is properly doctored at the saturator to dry sufficiently at the coater that much of the saturation is removed from the sheet. The auxiliary allows the excess saturation to strike in and then be re-scraped by allowing "hot stuff" to cover the surface of the sheet.

In your memo of 7-6-55 you asked for further comments regarding asphalt used in the month of May. We are not satisfied with the average percent saturation on 15 pound or 30 pound saturated felt. As a matter of fact, we have difficulty obtaining 140% saturation. We do feel that if we were able to apply a hotter saturation material at the auxiliary spray that we could use it on 15# felt and do an excellent job. We might, however, need doctor blades on the balance of our bottom strike-in rolls to dry the edges.

At the present time we are not using the auxiliary spray on 15# and 30# felt because of wet edges. We also feel that a hotter application of saturation at the auxiliary spray would help on heavier weight dry felt for all products.

To us this test indicates that on 15# and 30# felt we are actually doctoring the saturation from the sheet in order to properly dry it.

It also indicates that when we are not using the auxiliary that we do not substantially increase percent saturation by slowing down the machine. We have had reports of this from our machine men running 15# and 30# felt. We have also checked with them many times to substantiate their statements.

During May our actual vs standard was as follows:

111.92	tons under on saturation
89.47	tons under on coating
201.39	tons under on asphalt saturation & coating
284.82	tons over on filler
83.43	tons over on asphalt saturation, coating and filler

Also as mentioned in my memo of 5-27-55:

PLAINTIFF'S EXHIBIT
BIR-1033

MEMORANDUM
SHREVEPORT

In Reply to_____ Date_____ From_____ To_____

Subject_____ -2-

"As to the actual vs standard - I do not believe the individual items of saturation and coating used to standard can be analyzed properly unless the filler is taken into consideration. What we do at Shreveport is to figure as follows:

The Accounting Department takes the amount of saturation used per standard and the amount of coating used per standard. These two are totalled and the percent of the total of saturation and coating is figured. This percent is then used to break down the amount of actual saturation and amount of actual coating used from the asphalt department after actual inventories are taken and total actual asphalt used is determined. Therefore, the more actual filler used the less asphalt would be used in proportion.

"We have constantly for the last ten years talked and preached using the proper amount of filler, as it seems very easy to not use what is necessary."

In addition to this the accounting shows asphalt flux and saturation as one total received asphalt figure each month and shows on all asphalt a 4% shrink due to blowing loss. However, about 60% of the saturation used is purchased as straight saturation and already blown. Therefore, there would be no shrink to be deducted. At the present time about 25% of all asphalt purchased is straight saturation. This would increase the saturation use some.

BPS:lb

BIRD 014176

MEMORANDUM
SHREVEPORT

~~MS~~
~~PLC~~

In Reply to _____ Date 7/18/55 From PSL-Potter To Mr. Chamberlain - E.W.

Subject FS % SATURATION WITH AUXILIARY SPRAY ON AND OFF

The following report is on the runs of companion rolls of 50x48 dry felt from the same reels run on FSPM-1 on 7/12/55 and 7/13/55. All rolls run on 7/12/55 were saturated with all sprays on in the saturator and run out of the saturator wet into the auxiliary spray, which was on, then scraped so that the sheet was dry or slightly mottled into the coating rolls. All rolls run on 7/13/55 were companion rolls of those run 7/12/55. In this case the rolls were saturated with all sprays on in the saturator and run out of the saturator as wet as could be and still be approximately as dry into the coater rolls as the rolls run 7/12/55. Neither the auxiliary spray nor the auxiliary scraper was used on these latter rolls.

It was originally planned to run the rolls used on 7/13/55 as fast as the ones run on 7/12/55. However, it was found that we could not run this fast since the material would not saturate at the speeds that were run on 7/12/55. As a result we started each roll on 7/13/55 into the machine at 150 volts or approximately 270 feet a minute. After obtaining a saturated sample at this speed we would increase the machine speed to 200 volts or approx. 350 feet a minute for 2½ minutes, take another saturated sample, and then revert back to the 150 volt speed. In all rolls but 3 we found small 1/32" - 1/16" spots of unsaturated felt at the 200 volt speed so did not attempt to run any higher for samples. It was necessary to hold at this speed for 2½ minutes to allow time for the sample to go all the way thru the saturator and strike-in section before getting samples.

We tried running the machine both days so that we would get at least the minimum % saturation of 165% on machine checks. In the case of the 7/12/55 run there were two rolls, run on the nite shift, where we had to slow down and take additional samples to get this 165% saturation. In both cases we maintained this lower speed for the balance of the roll.

In the case of the 7/13/55 run we had to take as many as 3 samples and even then were not too successful in obtaining 165% minimum samples.

After the two runs extractions were taken on all samples and % saturations were computed, The following figures are compiled to show companion rolls and the resulting % saturations. The attached work sheet shows this same data, plus roll kerosenes, PSL kerosenes on extracted samples, machine saturations, PSL saturations by extraction, and machine speeds.

Condition of sheet into coater	DSPM-1 Date Tour Roll	% Sat. by Extr.-Aux On	% Sat by Ext.-Aux. Off	DSPM-1 Date Tour Rl	Condition of Sheet Into Coater
Mottled	3/7/7/55 24 C	180	136	3/7/7/55 24 A	N-dry, S-6"-9" wet streak
Mottled	3/7/7/55 25 B	174	138	3/7/7/55 25 A	N-dry, S-2"-3" wet streak
Mottled	3/7/7/55 26 B	165	133	3/7/7/55 26 A	N-dry, S-6"-9" wet strea
Slightly mottled	3/7/7/55 27 C	177	160	3/7/7/55 27 B	N-dry-S-3" wet strea
Mottled	3/7/7/55 28 C	187	160	3/7/7/55 28 B	N-dry-S-2"-3" wet strea
Slightly mottled	3/7/7/55 30 B	191	157	3/7/7/55 30 A	N-dry-S-6" wet strea
Mottled	1/7/8/55 5 C	167	144	1/7/8/55 5 A	N-dry, S-3½-6" wet strea

ION 12-54 D1870

MEMORANDUM
SHREVEPORT

In Reply to _____ Date _____ From _____ To _____

Subject _____

Condition of sheet into coater	DSPM-1 Date Tour Rl.	% Sat. Extr-Aux. On	% Sat. Extr-Aux. Off	DSPM-1 Date Tour Rl.	Condition of Sheet Into Coater
Slightly mottled	1/7/8/55 6 B	169	140	1/7/8/55 6 A	N-dry,S-12"-15" wet streak
Slightly mottled	1/7/8/55 8 C	181	132	1/7/8/55 8 A	N-dry,S-6" wet streak
Slightly mottled	2/7/8/55 21 B	182	146	2/7/8/55 21 A	N-dry,S-6"-7" wet streak
Slightly mottled	3/7/8/55 25 A	161	137	3/7/8/55 25 C	N-dry,S-2" wet streak
Mottled	3/7/8/55 26 B	178	141	3/7/8/55 26 C	Dry
Slightly mottled	3/7/8/55 27 C	193	133	3/7/8/55 27 A	N-dry,S-9"-12" wet streak
Mottled	3/7/8/55 28 C	186	139	3/7/8/55 28 A	N-dry,S-6" wet streak
Mottled	1/7/9/55 1 B	171	139	1/7/9/55 1 C	N-dry, S-3" wet streak
Slightly mottled	1/7/10/55 5 C	178	151	1/7/10/55 5 B	N-dry,S-6" wet streak

In describing the condition of the sheet into the coater it was possible when using the auxiliary scraper to control the condition of the sheet from a slightly mottled sheet - approx. 5% of sheet with small spots of surface saturation to a mottled sheet - approx. 10% of sheet with small spots of saturation. On 7/13/55 where we were not using the auxiliary spray or scraper we had more difficulty drying the sheet and therefore almost the entire run had a streak on the far south side of the sheet which was wet into the coater. All samples were taken from the north (aisle) side of the sheet and no sample, from either day, had any excess saturation on it. In addition all mottling and streaking was on the top surface of the sheet with none on the back.

RMP/gf

BIRD 014178

MILL - FS

DATE - 7/13/55

DRY FELT STUDY

[redacted] E. WAL. - MR. CHAMBERLAIN

Tag Data SIZE - 50 X 48 - #21 M.B. Mill Data Laboratory Data

Machine	Date	Tour	Reel	K	Zylol	Scott	Percent Moisture	% Sat.	Sat. Temp.	% Sat. by Desat.	Lab K Dry Felt	Scott
DSPM-1	7/10/55	1	5	182	18	42	5.0	141	460	151	193	30
	7/9/55	3	28	178	20	36	6.0	165	460	139	187	34
	7/9/55	1	1	183	17	34	5.0	164	450	139	190	32
	7/8/55	3	25	184	20	33	3.0	162	450	137	193	32
	7/8/55	3	26	180	22	36	4.0	147	450	141	189	37
	7/8/55	3	27	175	18	34	6.0	167	450	133	175	34
	7/8/55	1	8	182	18	35	7.0	167	450	132	187	30
	7/9/55	2	21	185	17	34	4.0	184	450	146	190	30
	7/8/55	1	5	179	15	36	3.0	166	450	144	178	28
	7/8/55	1	6	175	16	37	4.0	171	460	140	183	30
	7/7/55	3	30	197	18	32	3.0	161	460	157	195	33
	7/7/55	3	28	193	17	32	4.0	164	460	160	192	30
	7/7/55	3	27	188	18	30	5.0	173	460	160	204	30
	7/7/55	3	25	189	20	36	4.0	150	450	138	183	30
	7/7/55	3	24	175	18	36	4.0	154	450	136	185	33
	7/7/55	3	26	180	20	32	7.0	171	450	133	182	32

NOTE - All 16 rolls - 8 pm on 1st shift, 8 pm on 2nd shift - were run without the auxiliary spray being turned on. This was per Mr. Chamberlain's request.

Ref?

BIRD 014179

Date Run	Shift	Auxiliary Spray On	% S	PSL Extracted Ker.	Machine % Saturation	PSL % Sat By Extraction	Machine Speed
1. 7/12/55	A	7/12/55	3/	75	185	154	136 150 137 150 121 200
2. "	A	7/12/55	3/	87	183	150 138 150 143 165 143	150 150 150
						119	200
3. "	A	7/12/55	3/	80	182	171 133 125	150 200
4. "	A	7/12/55	3/	88	204	173 160 139	150 200
5. "	A	7/12/55	3/	93	192	164 160 155	150 200
6. "	A	7/12/55	3/	97	195	161 157 138	150 200
7. "	A	7/12/55	1/	79	178	166 144 129	150 200
8 "	A	7/12/55	1/	75	183	171 140 124	150 200
9. "	1	7/12/55	1/	82	187	167 132 141	150 200
10. "	1	7/12/55	2/	85	190	184 146 142	150 200
11. "	1	7/12/55	3/	84	193	162 137 144	150 200
12. "	1	7/12/55	3/	80	189	147 141 145 138	150 150 200
13. "	1	7/12/55	3/	75	175	167 133 132	150 200
14. "	1	7/12/55	3/	78	187	165 139 138	150 200
15. "	1	7/12/55	1/	83	190	164 139 135	150 200
16. "	1	7/12/55	1/	82	193	141 151 144 148	175 200 150

BIRD 0141