

Bulletin 228

PLAINTIFF'S EXHIBIT

MAR-382

MAR

002377

MAREMONT REMANUFACTURING DIVISION ENGINEERING BULLETIN		Bulletin No. 228
		Supplement No.
Product: Unlined Brake Shoes	Date September 29, 1964	
Subject: Rust Preventative Dip	Page 1 of 1	
Reference:	Superseding No.	

General - As soon as possible, after grit blasting, shoes should be dipped in a rust proof solution. Blasted shoes tend to start rusting very quickly, especially in damp humid weather. The rust may not always be visible to the naked eye, but it starts to form as soon as the shoes come out of the blasting machine. Clean shoes are very essential to good bonding and you cannot assume, because they haven't turned red, that rust hasn't started to form.

Procedure - The rust proof solution consists of approximately one part approved Thermo-setting Phenolic Resin to four to five parts of approved Solvent. Mix Union Carbide No. BLS 2117 concentrate and Isoprophyl Alcohol (99%) solvent and maintain a hydrometer consistency of 0.830 to 0.844. (A hydrometer with a specific gravity of 0.800 to 0.910 such as shown in Fischer Scientific Company's Catalog No. 11-510B is recommended.) To maintain consistency check the dip solution daily. The shoes should be loaded loosely in baskets, convex side up, and baskets dipped in tank of solution; agitated, removed and allowed to drain and dry. 100 to 200 shoes may be loaded per basket.

Problems can arise from this method as shoes do not drain evenly, some accumulation occurring near the ends of the shoes, especially on the bottom layers. This accumulation tends to blister when subjected to bonding heat, which detracts from the appearance of the product. This condition can be improved by draining old solution from the tank, cleaning tank and putting in a new mixture periodically. The old solution tends to accumulate undissolved particles of varnish in addition to becoming contaminated with dust, undissolved resin and moisture.

The normal drying time after dipping is 15 to 20 minutes. This may have to be increased during poor drying weather.

Safety - The Isoprophyl Alcohol Solvent presents toxic dangers and Safety Regulations recommend a minimum exposure to inhalation. Fumes should be controlled by appropriate exhaust systems. The solvent has a closed cup flash point of 54° to 57°F.

Distribution: Standard	Issued By: J.D. Kody	Approved By: <i>J.D. Kody</i>