H. L. Hubbard - M.O.
P. G. Benigmus - Roberts
D. B. Hosmer

Anniston, Alabama

July 16, 1956

Mr. J. E. Crouch

Anniston

TRANSALL, INC.
LUBRICATING STICKS CONTAINING AROCLOR 1248

On Tuesday, July 11, 1956, I visited the Transall, Incorporated Plant at 106 North 11th Street, Birmingham, Alabama. This memo is to report on techniques they use in the manufacture of railway lubricating sticks, containing Aroclor 1248. Mr. R. O. Smith, Assistant Manager, was my guide through the plant.

Composition of the Sticks:

Sulfur
Graphite
5% Aroclor 1248, and
a gray white powder

Equipment:

Their equipment is very inexpensive and simple. It consists of a mix tank and some molds. The mix tank is an old aluminum army cooking kettle (of 40-50 gallon capacity) with the flat bottom removed and welded back in on a slant. Around the kettle is welded a steel jacket. The contents of the kettle are agitated with an air driven lightening mixer.

The aluminum molds are built in two sections for easy removal of the sticks. They have 13 molds. Each mold would make 12 sticks about 1" x 1" x 6". An exhaust fan and hood is provided to remove the fumes.

I was told the total cost of the equipment was less than $500.

Operations:

Sulfur is added to the mix tank and melted by circulating hot oil through the tank jacket. Rework material (pieces of broken sticks) from the previous molding batch and three or four 2½ lb. scoops of graphite and 1½ scoops of a gray white powder are added to the mix tank. This mixture is agitated for about 15 minutes and the Aroclor 1248 poured in. The temperature is adjusted to 300°F and the material drawn out in the molds.

After cooling for about 5 or 10 minutes, the molds are broken open with a screw driver and the sticks, more or less, snapped out.

Mr. Smith said they had produced as many as 1500 sticks in one day.

R. L. Hedworth

RLH:md

0361305

TOWOLDMON0057664