PLAINTIFF'S EXHIBIT 1262.00

PLAINTIFF'S EXHIBIT WV-05539

SPRAYED "Limpet" ASBESTOS

MACHINE OPERATING INSTRUCTIONS

Armstrong
CONTRACTING AND SUPPLY CORPORATION

DEFENDANT'S EXHIBIT A0and557

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1. OPERATING EQUIPMENT

The equipment normally required for the application of "Limpet" is as follows:

1 Spray Machine
1 Multijet Spray Gun (6 Jet or 9 Jet)
1 Fiber Blowing Hose
1 Hose for Air (to the gun)
1 Hose for Air (from the gun)
1 Hose for Air (to the regulator)
1 Hose for Water (to the gun)
1 Air Regulator
1 Fluid Regulator
1 Fluid Filter
1 Set of Pressing Tools for Tamping and Finishing

Additional equipment may be necessary depending on the job location and requirements.

If compressed air is not readily available, a compressor is necessary to supply air with which to atomize the fluid and to operate the spray machine. The compressor must be one which can supply at least 5.5 cubic feet per minute with a displacement of 8.8 C. F. M. and an operating pressure of 50-80 pounds per square inch. One such compressor would be model 33-1128 as manufactured by the Binks Manufacturing Company, Chicago, Illinois.

Occasionally, the applicator may find it necessary to spray to porous surfaces or toughen up the surface of the "Limpet" application by using TS.2. When this condition occurs, a pressure tank with an additional fluid hose and a two-way valve at the gun will be necessary. It is recommended that the pressure tank have at least a ten (10) gallon capacity, a double regulator, and an agitator to keep the emulsion in suspension.

All the above auxiliary equipment, with the exception of the pressing tools, are available from Armstrong. A sketch of the suggested tools and their dimensions is shown in Exhibits 8 and 9.

It is strongly recommended that each member of the spray crew wear a dust respirator at all times during the application process. Respirator must have U. S. Bureau of Mines approval.

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2. PROCEDURES

A. Organization

Proper organization is necessary. The following should be thoroughly investigated before workmen arrive to start the operation.

1. Is water available nearby? Will it be sufficient in pressure and volume?

   A volume of .5 gallon per minute and a pressure of at least 10 pounds per square inch is necessary for each machine.

2. Is compressed air available? Will it be constant?

   If compressed air is available at the job site, make sure the delivery is 5.5 cubic feet per minute at a pressure of 50 to 80 pounds per square inch for each machine in use. If compressed air is not available, a compressor capable of delivering the required air is necessary.

3. What voltage electricity is available and how many machines are being carried on one supply line?

   While most machines are equipped with 115-230 volt single phase motors, make certain the motor on the spray machine is wired to match the voltage supplied. Where only 440 volt power is available, a three phase motor must be installed on the spray machine. Caution must be exercised to avoid overloading the power available or there will be overheating and possible shutdown.

4. Will any scaffold be needed? If so, what kind and how much?

   If the unit or units to be sprayed are easily accessible, scaffolding may not be necessary. If the surfaces to be sprayed are above the average height and not within easy reach, see that adequate scaffolding is provided.

5. Is the material and spray equipment on the job site? If not, will it be there in time?

Not getting material and equipment to the job site can prove very costly especially when several machines and men are involved.

It is good practice for the foreman or job superintendent to have all the equipment assembled and have a trial run made before job start-up.

B. Assembly and Connection of Equipment

A sketch with the operational hookup arrangement is shown in Exhibit 10. Identification of the different connections are as follows:

1. Air Connection at the Gun - The male fitting on the gun is a 7/16", 20 thread to the inch. The red hose (Binks 71-105) to be connected at this point should have a 9/16", 20 thread female fitting (Binks 72-318).

2. Fluid Connection at the Gun - The male fitting for the fluid connection is a 9/16", 20 thread also. The water regulating valve which is connected at this point should be equipped with 9/16", 20 male and female connections.

2A. Fluid Connection with the Two Way Valve - The two way valve called "C-22" in the parts section is used whenever another material such as TF.2 is used in connection with the application of "Limpet". This whole unit is installed in place of the regulating valve used when water only is being used. The male fittings on the two way end are ¾" straight pipe thread.

The black fluid hoses (Binks 71-203) come equipped with a Binks 72-326 female 9/16", 20 on one end and a Binks 72-328 3/8" straight pipe thread on the other. Care should be exercised when using the two way valve since a Binks 72-48 adapter must be used to change the fitting from ½ St. P to 9/16", 20 thread.

3. Air Connection at the Gun - This connection with the slip-on fitting is used to connect the clutch control unit on the spray machine with the gun. The air hose (Binks 71-110) has no fittings on either end.

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4. Air Connection at the Compressor or Air Supply Line - Depending on the source of compressed air (either the compressor or plant supply) this 71-105 air hose has a Binks 72-317 ¾" straight pipe thread connection on this end. It should be connected to the outlet end of the air regulator (Binks 85-101) which is attached to the air supply.

5. Air Connection (Pressure Tank Inlet) When TS.2 Is Used In Connection With The "Limpet" Application - A supply of compressed air is needed for the pressure tank as well as the gun and machine. Use a hose (Binks 71-108) with (72-333) 3/8" straight pipe thread fittings to connect the air supply with the tank. The pressure tank has a double air regulator (Binks 85-104) which controls the pressure in the tank and permits individual regulation of air to the gun and machine. The pressure in the tank (the regulator on the left) is the same as that for the water.

6. Air Connection Outlet (Second Regulator on the Pressure Tank) - The hose fitting should be a ¾" straight pipe thread in order to connect with the spray gun by means of the same hose (Binks 71-105), previously noted in Connection 1.

7. Fluid Connection Pressure Tank - The fluid outlet has a 3/8" straight pipe thread fitting, and it is connected to the second black or fluid hose previously noted in 2A.

8. Air Connection - Clutch Control - The hose (Binks 71-110) with no fittings leading from the slip-on connection at the gun is connected to the machine at this point. Sufficient air must pass through it at all times in order to operate the machine properly.

9. Fiber Hose Connection - Gun - The 2" fiber hose slips over the end of the gun and over the outlet tube at the fan unit (10).

10. Fiber Hose Connection - (10) - same as # 9

11. Water Inlet Connection - Fluid Regulator - The fluid regulator with a 3/8" female fitting is connected to the water supply point.

12. Water Outlet Connection Fluid Regulator - The outlet fitting of the fluid regulator is 3/8" straight pipe male and it is connected to the black fluid hose (Binks 72-208) with a (Binks 72-325) used in No. 2.

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C. The Machine

To apply Sprayed "Limpet" Asbestos successfully, the asbestos fibers must be delivered to the spray gun in a constant stream and at a constant speed. The specially designed machine licensed by Armstrong Contracting and Supply Corporation assures uniform application. It is the only machine which can be used to apply Sprayed "Limpet" Asbestos economically.

The basic operation involves an endless belt with spikes called the creeper sheet (noted as part A-45, Exhibit 2), which lifts asbestos fibers from a hopper and passes beneath an adjustable revolving brush (noted as A-57, Exhibit 3). This control brush regulates the amount of fiber permitted to pass through the machine by increasing or decreasing the distance between the creeper sheet (A-45) and the brush (A-57). This is done by turning the control wheel (part A-60, Exhibit 3, shown by part A-53, Exhibit 2). The control wheel operates on a cam principle, and when the wheel is turned to the left, the fiber flow is decreased. When the wheel is turned to the right, the fiber flow is increased. Any excess fiber is thrown back into the feed hopper due to the counterclockwise motion of the control brush (A-57). The fiber is then carried forward and stripped from the creeper sheet by the front or stripping brush. (Noted as part A-48, Exhibit 3, located by A-46, Exhibit 2). Dropped down the fan chute (A-52, Exhibit 2) and on through the fan (A-67) to the gun.

D. The Spray Gun

The spray gun is operated by a single trigger having three working positions. (See Exhibit 11). When the trigger is pushed to the full forward (#3) position, it permits air to flow to the clutch control (part A-107, Exhibit 4) shown near parts A-126 and A-127, Exhibit 2, which pushes down the plunger (part A-109, Exhibit 4) into the output disc (part A-39, Exhibit 5) starting up the creeper sheet (A-45) and the flow of fiber to the fan and, eventually, through the gun.

As the asbestos fibers leave the gun nozzle, they are intercepted by an atomized spray of water from the jets on the gun. This interception takes place approximately nine (9) inches away from the gun. In order to apply the coating properly, the gun should be held 18 to 20 inches from the surface and at an angle of approximately 45 degrees. The operator should seek to achieve the desired thickness as soon as possible rather than in thin laminations. Each advancing layer of "Limpet" should overlap the preceding layer slightly as the strength of the applied "Limpet" depends as much on the interlacing or felting of the fibers as upon the bonding materials it contains. A slight excess of 3/8" thickness is sprayed on, and the surface is pressed to the

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specified thickness. A final overspray of plain water will toughen the surface.

E. Preparation of Surfaces

All surfaces should be thoroughly cleaned to remove dust, dirt, grease, rust, or loose paint. "Limpet" will adhere to the surface to which it is sprayed; if the surface is loose, the "Limpet" coating will also be loose.

F. General Cleanliness

Failure to keep the end of the spray gun clean results in the fiber being blown out of the main air stream and adversely affects the appearance of the finished spray application.

Careless handling of spray equipment can create the erroneous impression that a "Limpet" application is not a clean one. If, for instance, the gun is held too far from the surface sprayed, the results are not satisfactory.

Bags of fiber should be stacked neatly out of the way of usual plant or other traffic.

At the end of each day's spraying, all excess damp fibers should be cleaned from surrounding surfaces. If allowed to set, the material cannot be brushed off but can be removed only with difficulty.

G. Identification of Improper Application

In the application of Sprayed "Limpet" Asbestos, conditions may develop in the mechanical operation of the spray machine which must be quickly identified and corrected by the operator to assure a high quality finished job.

To assist the operator in recognizing such conditions and to enable him to make the necessary adjustments, the following check list will be found helpful:

FAULTS	CORRECTION
Fiber Too Wet	
1. Water pressure too high	Reduce pressure to 5 PSI plus 1 PSI per each 2 feet above level of machine (Avg. 12 PSI).

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2.	Fiber stream too weak	Check amount of fiber in hopper - should be 1/3 full.
3.	Wrong setting on control brush	Rotate control wheel (A-60) to the right.

Fiber Too Dry

1.	Water pressure too low	Increase PSI to 5 PSI plus 1 PSI per each 2 feet above level of machine (Avg. 12 PSI).
2.	Water jet or jets choked	Clean out jets with small piece of wire. If this does not work, remove nozzle and blow air through front of jets.
3.	Fiber stream too heavy	Check hopper--may be overfilled or reduce flow of fiber by turning control wheel (A-60) to left.
4.	Gun held too near to surface being sprayed	Gun should be 18-20 inches away.

Fiber Too Slow

1.	Wrong setting of control brush	Increase fiber feed by adjusting control wheel (A-60).
2.	Belt slipping	Shorten belt by cutting and clipping together.
3.	Hose choked	Straighten hose, check for kinks, loosen fiber by shaking hose, clear hose by blower action of fan.
4.	Fan Speed too low for length of hose	Increase motor pulley to 7" or reduce fan pulley to 1-3/8".
5.	Too many bends in fiber hose	Straighten hose so there are no bends.
6.	Fan impeller or casing worn	Replace.

Fiber Too Fast

1.	Wrong setting of control brush	Reduce by turning control wheel (A-60) to left.

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2. Fan speed too high for length of hose	Reduce motor pulley to 6"/50 ft. fiber hose, or increase fan pulley to 2½" P.C.D.
3. Too much fiber in hopper	Take out excess--should be 1/3 full.

Fiber Erratic

1. Belt skipping	Shorten belt.
2. Hose choked	Clean out as noted above.
3. Hose crushed	Either repair or cut out damaged end and reconnect by 2" O.D. tube no less than 1-7/8" I.D.
4. Too much fiber in hopper	Remove excess--should be 1/3 full.
5. Pneumatic control not working properly	Check control cock at gun or check clutch control (A-107).

Fiber Stream Distorted

1. Gun end blocked	Turn off fiber and water supply at gun. Run finger around inside diameter of gun end.
2. Gun end distorted	Repair--face mat must be circular
3. Air pressure to gun too high	Reduce air pressure (maximum 35 PSI).
4. Air or water jets choked	Remove nozzle and clean.

Fiber Flying About

1. Gun held too far from surface	Should be no more than 18-20" away.
2. Fan speed too fast	Reduce motor pulley diameter. Increase fan pulley diameter.
3. Air pressure too high	Reduce to 30-35 PSI.
4. Gun end blocked	Clean out as above.
5. Gun being waved about	Spray in straight uniform pattern.

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No Fiber Issuing from Gun

1.	Fan duct or hose choked	Shut off machine--clean out by hand before starting up.
2.	Foreign body in fan or hose	Same as above.
3.	Creeper sheet loose or jammed	Correct by adjusting belt at adjusting screw. (A-24, Exhibit 2)
4.	Pneumatic clutch control not working	Check and repair.

Uneven Surface on Sprayed Coating

1.	Each row of fiber not carefully overlapped	Spray so that rows are overlapping.
2.	Gun pointed at right angles to surface	Should be 45°
3.	Gun not moved at even rate	Move gun slowly and evenly.
4.	Fiber too fast	Check control brush setting, fan speed and amount of fiber in hopper. Make proper adjustment.
5.	Fiber erratic	Check belting, condition of hose, fiber in hopper or clutch-control. Make prope adjustment.
6.	Gun too near surface	Move gun back so that nozzle is 18" to 24" away.
7.	Gun too far from surface	Move gun so that nozzle is 18" to 24" away or closer when spraying with crosswind.
8.	Fiber too wet	Reduce amount of water or increased amount of fiber.

H. Pressing

All Sprayed "Limpet" Asbestos must be pressed. Pressing links the fibers to form a monolithic coating and assures good contact with the surface sprayed.

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The amount of pressing required should be even and firm enough to integrate hanging fibers. Too much pressing reduces the thickness, and additional fiber must be applied. An uneven pressure will produce marks on the pressed surface. Proper pressure is achieved only with practice.

On exposed work, appearance is important, and the "Limpet" surface should be pressed twice. The first pressing should be done parallel to the line of spray. The second pressing should be made perpendicular to the first as shown below. It is sometimes necessary to overspray sections to attain a straight smooth surface. Straightness should be checked with the straightedge described in Exhibit 9.

Pressing is the final phase of the "Limpet" application; therefore, it is most important that it be done with utmost care. It must be remembered that the "Limpet" spray must be constant and the fibers applied in a uniform coat. No amount of pressing can, in itself, compensate for faulty spraying.

I. Pressing - Hand Tools

Pressing tools should be so designed that they are easily handled. Much of the pressing is done overhead so a good tool has to be lightweight; it should be correctly balanced and should fit the hand comfortably.

Spray operators should have the following working tools:

Flat surfacing tool	-	1
Hand surfacing tool or floater	-	2
Plasterer's steel finishing trowel	-	1
Corner pressing tool	-	1
Steel pointing trowel	-	1
Straightedge	-	1

All tools should be kept clean.

It is recommended that each presser carry a small whisk broom in his pocket and use it frequently to clean tools and the areas around the sprayed surface.

Regulating Thickness

The gauging of thickness is a factor which must be gained through time and experience. Thickness can be measured with a simple tool made from

a piece of wood and a finishing nail driven into the wood to the desired length. From time to time the presser can check the thickness by pushing the nail into the "Limpet".

J. Safety Precautions

See that machine is properly grounded.
Stop machine before making adjustments.
Keep all hoses free from kinks and bends.
Do not point gun at another person.
Do not look down the gun while machine is running.
Do not tamper with compressed air.
Always wear a respirator; see that the man feeding the machine also wears one.
Do not remove fiber from the feed hopper while the machine is running.
Do not remove belt guards unless absolutely necessary. Replace before starting machine.

K. Cleaning of the Spray Machine

1. Clean-Out Door. Every few hours during operation, the hinged door at the rear of the machine near the floor should be opened and surplus fiber cleaned out after first disconnecting the power. Use a stick (do not use hands).

2. Drum Faces. Disconnect power - The hinged door at the sides of the machine should be opened every day and any loose fiber on the inside of the spiked belt (creeper sheet) or against the drum face should be removed by hand. If this is not done, the packed fiber building up on the drum face can cause the belt to be stretched out of alignment. When using white surface fiber, special attention should be given to this cleaning operation, since this finer fiber works down the belt more readily.

3. Guide Strips. Above the side doors there is a metal guide strip for the spiked belt. These strips should be inspected for fiber dust and kept clean by running the hand along them from the underside of the spiked belt. Please disconnect machine before cleaning.

4. Spiked Belt or Creeper Sheet. This belt should be kept free from water or wet fiber.

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5. Fan Impeller Blades. These blades should be cleaned of any fiber sticking to them by lifting the flap to the fan air inlet and reaching the blades with the hand. Always be certain the machine is shut down for this job. Disconnect power.

6. Rear Control Brush. This brush is kept clean of fiber by an adjustable comb attached to the frame of the machine. The comb is set so that its teeth just enter the brush. The rear control brush can be used to clean the fiber from the spiked belt simply by turning the control knob to the left (counterclockwise) for a few seconds while the belt is moving. Such action brings the brush against the spikes and clears the fiber which is then discharged through the fan.

7. Front Stripping Brush. This brush strips or clears the fiber from the spiked belt and throws the fiber into the fan duct. The brush should enter the spikes but should just clear the belt fabric. Permanent setting is made at the factory. Side brackets, however, permit adjustments which may be necessary to compensate for wear from continued use.

I. Maintenance of Spray Machine

Daily Maintenance

Remove waste fiber from underneath front of Creeper Sheet. (Blow air through side doors.)

Check grease cup on housing of fan bearings.

Check tension of both fan and driving drum belts. Adjust if necessary. Belts that are too tight will place an overload on motor, fan bearings, and oilite bushings of driving drum assembly. Flush T. S. 2 line with water.

Weekly Maintenance

Check condition of impeller blades. This can be done by looking into the fan outlet with the help of a flashlight (or match) and turning the impeller slowly at the same time. If the blades show wear, replace entire fan impeller assembly. Make sure machine is disconnected.

Dismantle pneumatic control cylinder and check condition of its component parts. Replace all worn parts. Before reassembling, clean cylinder carefully. Oil the cup washer lightly with castor oil. Thoroughly dry all other parts.

Check tension of creeper sheet. Adjust if necessary--it should be just enough to move the creeper sheet at a regular speed without slipping.

Remove belt guards and check condition of chains and chain sprockets. Clean chain and sprockets with solvent. Lubricate and replace guard.

Check multi-jet spray gun for air and water leaks. Replace rubber joint and other parts if necessary. Rub graphite on interior surface of fan chute to prevent fiber accumulation.

Monthly Maintenance

Observe operation of all oilite bushings carefully. If noticeably worn they should be replaced. (Note: Oilite bushings do not require lubrication.)

Check:

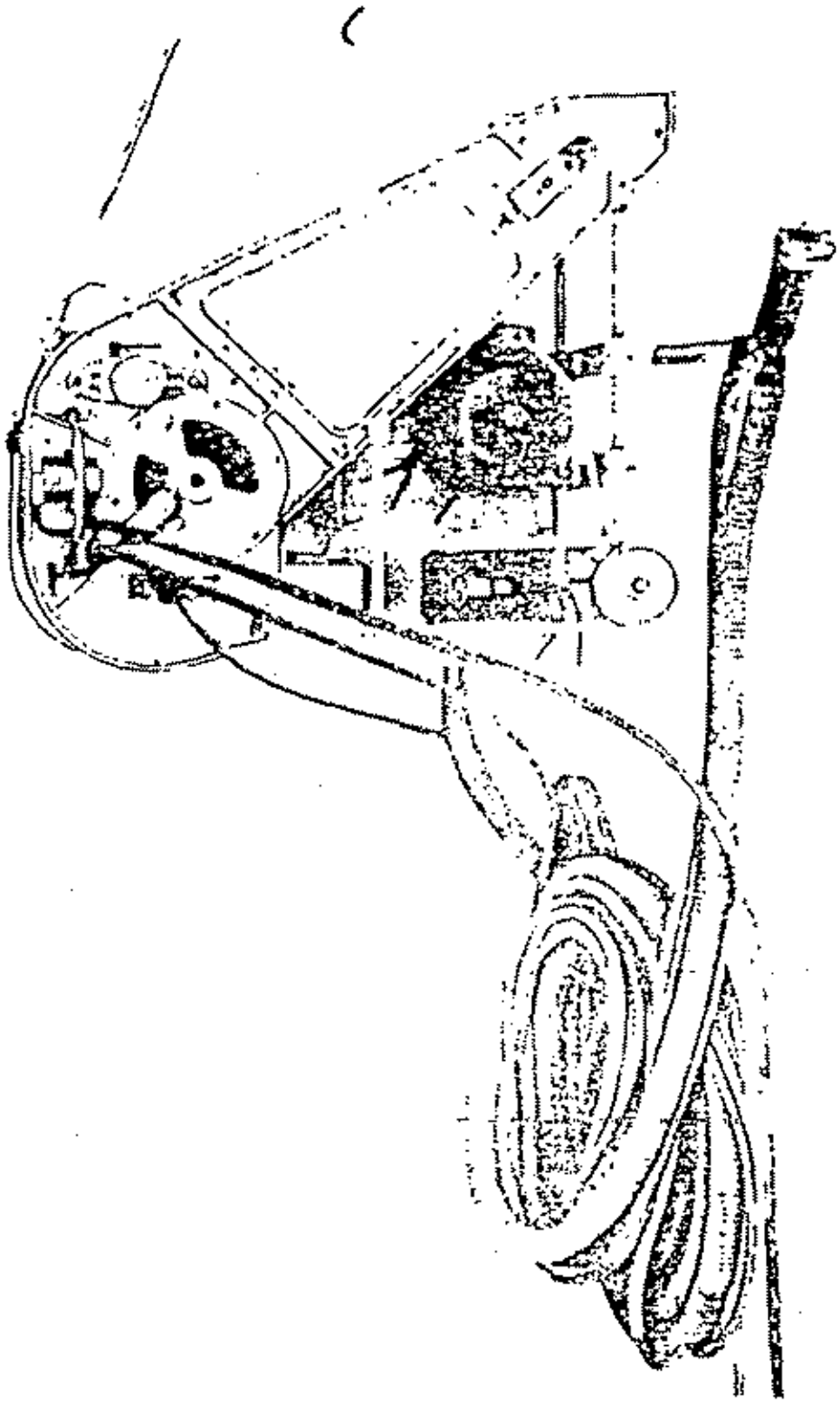
The front stripping brush should be checked periodically to note any wear. Any uneven surfaces will result in an uneven spray. The rear controlling brush also must be checked to observe the amount of fiber being fed to the fan impeller. When either is worn it must be replaced.

Check multi-jet spray gun and replace nozzle, back plate and control cock assembly, should this be required. Careful handling of the spray gun will assure its trouble-free, efficient operation.

Check fiber hose for leaks, breaks and general condition. Also check air and water hoses for leaks--fittings and joints for efficiency.

Check condition of pressure tanks and performance and operation of pressure regulators and gauges.

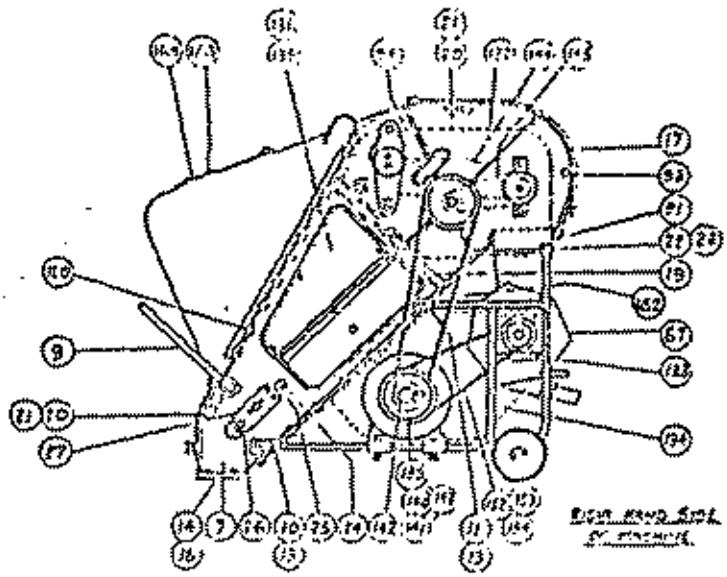
M. Main Drum Reduction Gear. There are three plugs--one for filling, one for oil level, and one for draining. Inspection should be made every 2 to 3 weeks to see that oil flows from the middle or oil level opening. At the end of each 6 months, oil should be drained and refilled with S.A.E. 30 or winter grade motor oil until the level is reached.

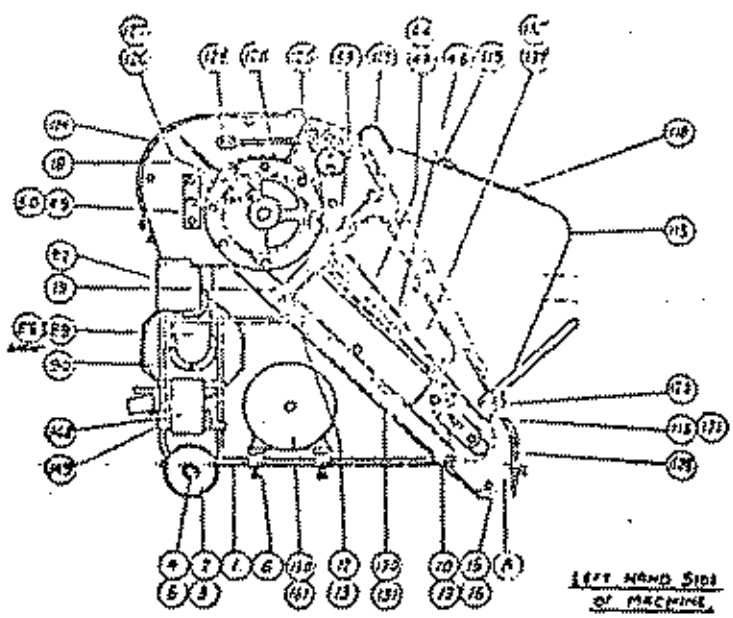


BA TYPE SPRAY MACHINE

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IIA TYPE SPRAY MACHINE.

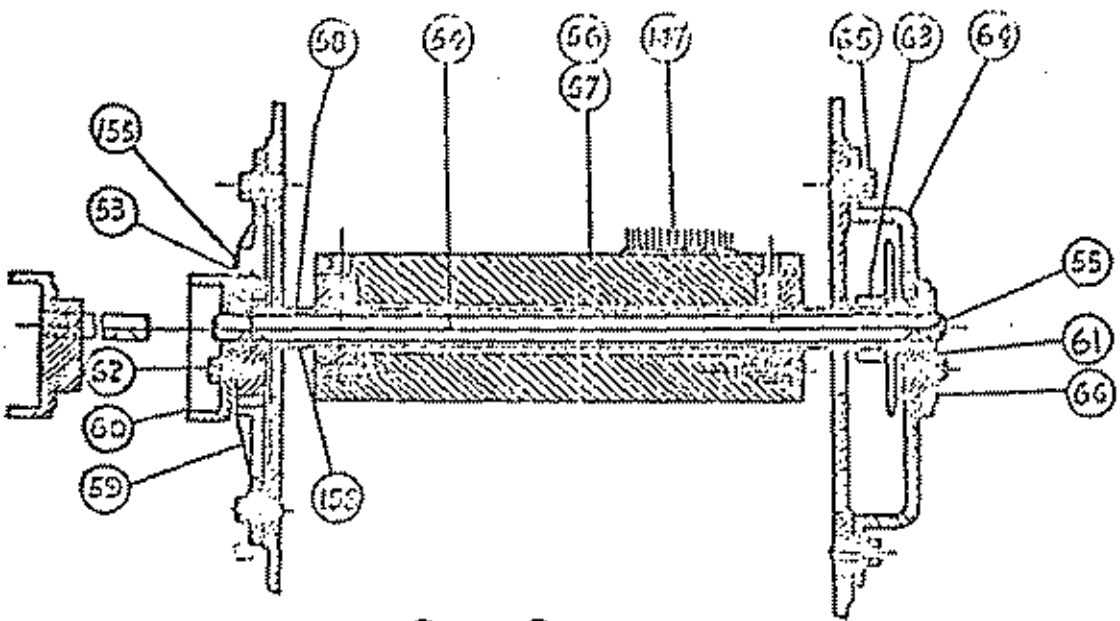




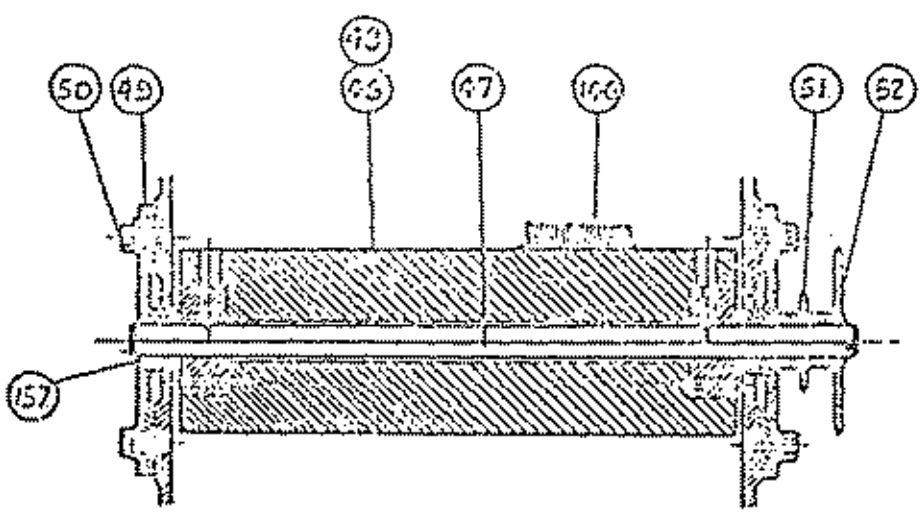
USE PREFIX LETTER "A" WITH PART NUMBERS

EXHIBIT 2

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REAR BRUSH.

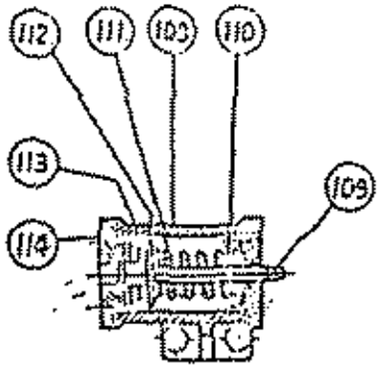


FRONT BRUSH.

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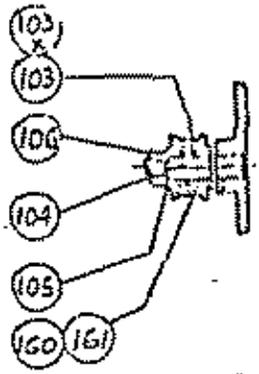
EXHIBIT 3

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COMPLETE ASSY PT. Nº 107.

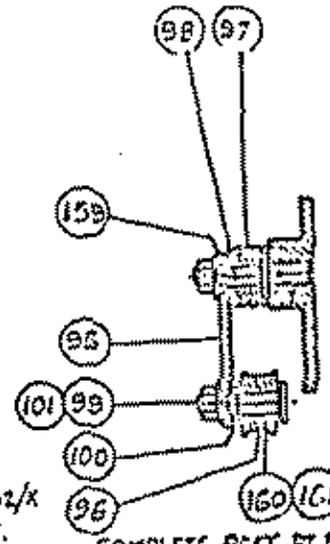
PLUNGER ASSEMBLY.



PT Nº 102/X

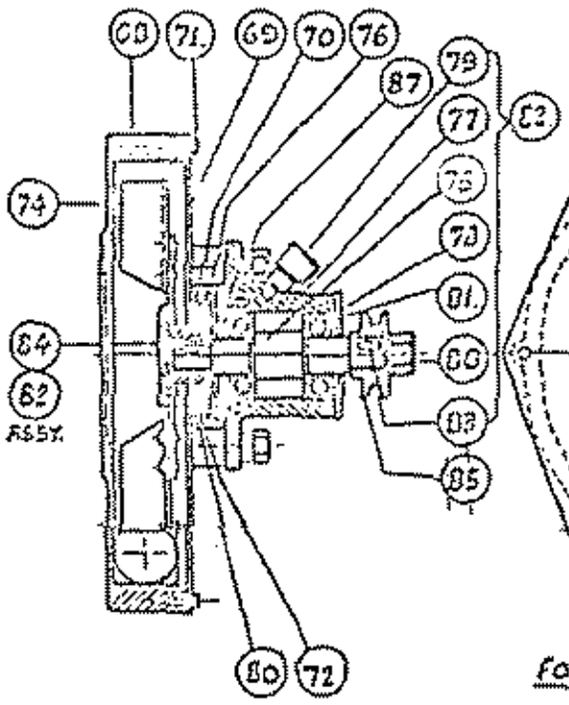
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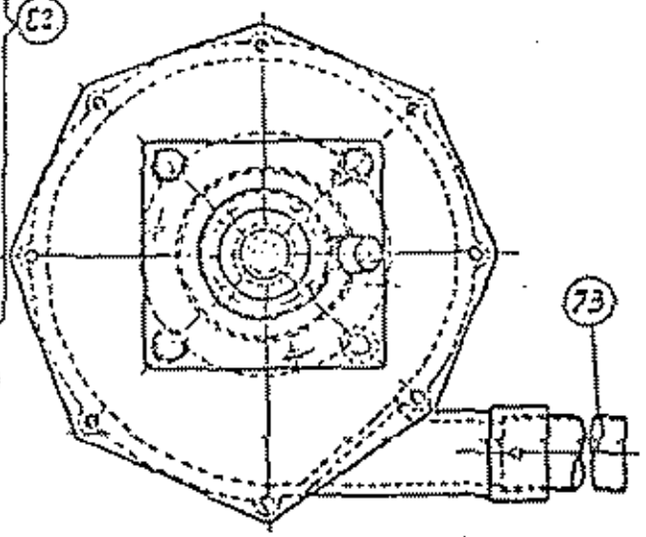
ROLLER ASSEMBLY.



COMPLETE ASST PT Nº 94.

JOCKEY LEVER ASSEMOLY.





FOR FAN UNIT COMPLETE PT. Nº R.67.

FAN UNIT.

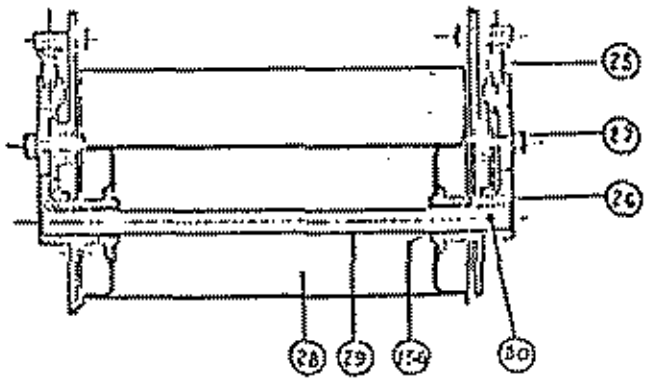
USE PREFIX LETTER "A" WITH PART NUMBERS

EXHIBIT L

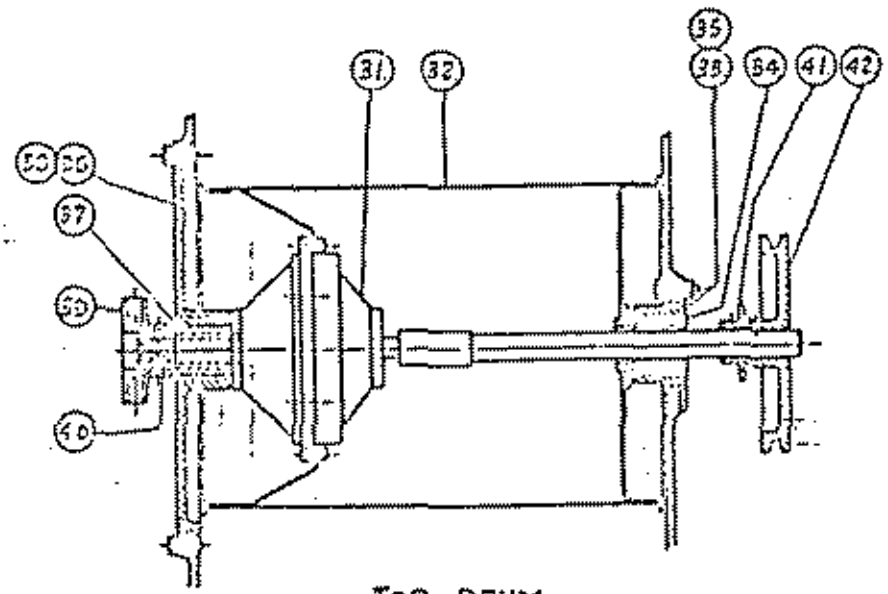
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HA TYPE SPRAY MACHINE

- CONTINUED -



BOTTOM DRUM.

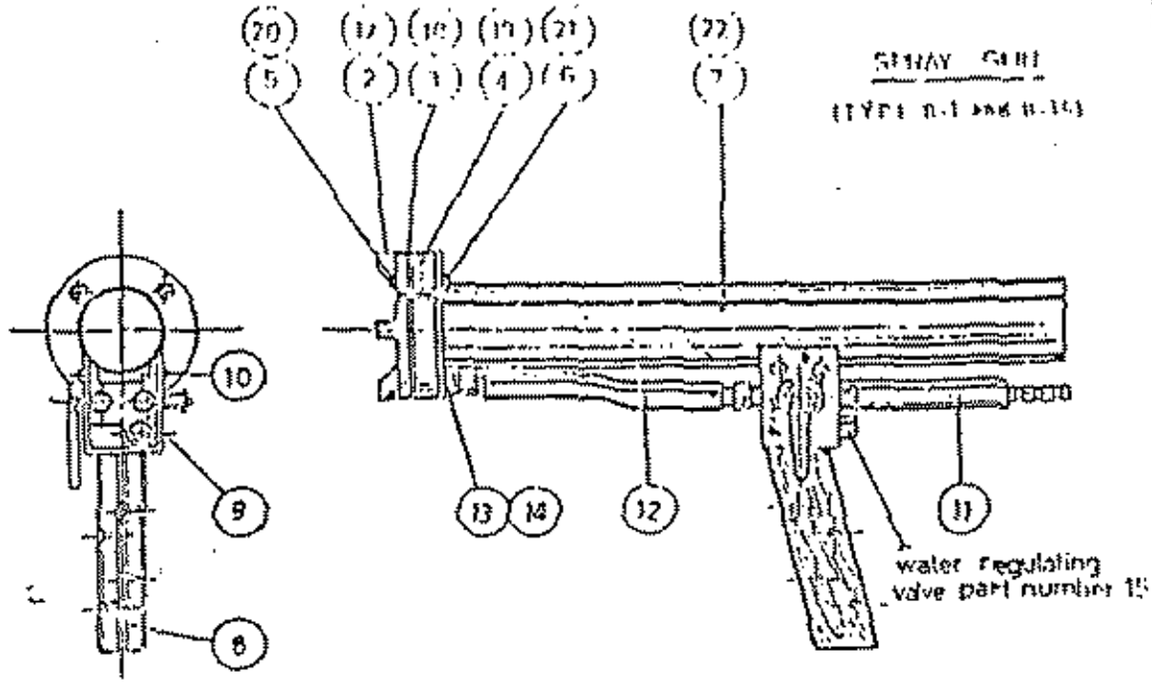


TOP DRUM.

USE PREFIX LETTER "A" WITH PART NUMBERS

EXHIBIT 5

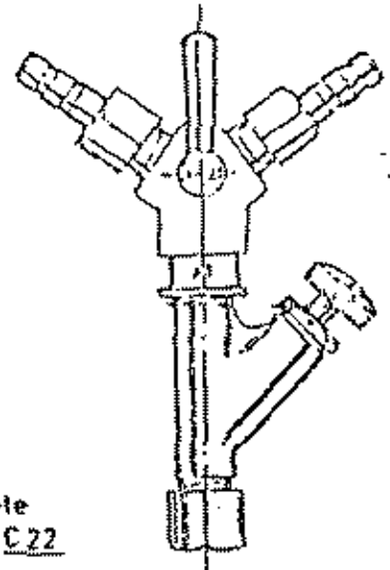
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2" spray gun complete part number 1

1¼" spray gun (made only to special order) complete unit number 16

Use Prefix Letter 'B' With Part Number



Item complete
part number C 22

N° 43 TWO WAY CONNECTION

Use prefix letter 'C' with part number

EXHIBIT

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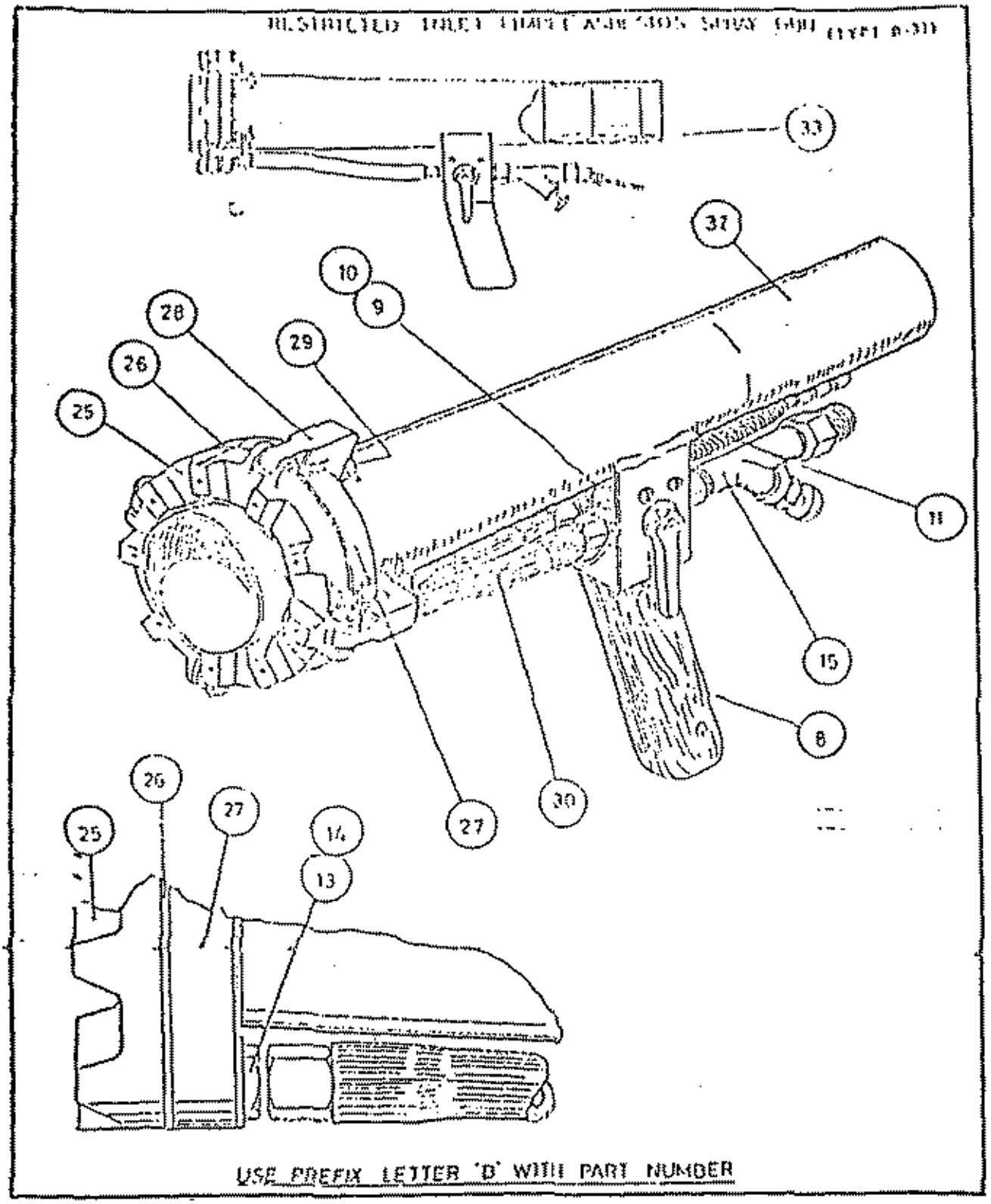
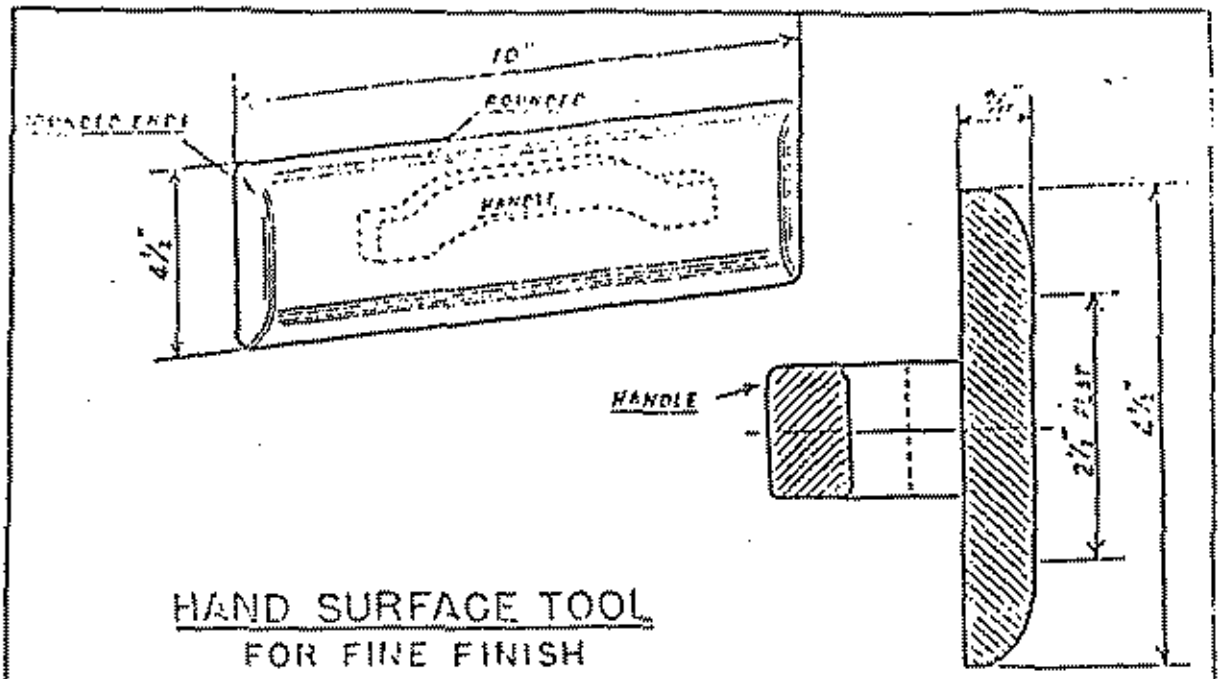
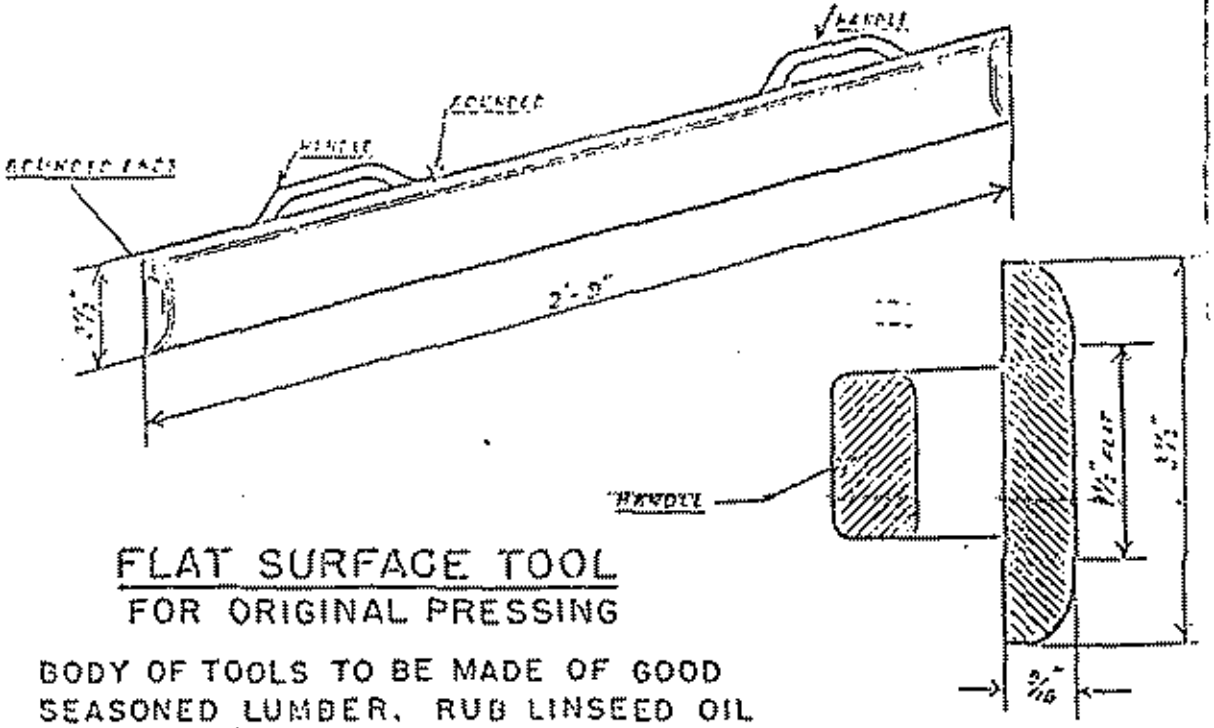


EXHIBIT 7

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HAND SURFACE TOOL
FOR FINE FINISH



FLAT SURFACE TOOL
FOR ORIGINAL PRESSING

BODY OF TOOLS TO BE MADE OF GOOD SEASONED LUMBER. RUB LINSEED OIL INTO THE FACE ONCE A MONTH.

EXHIBIT 8

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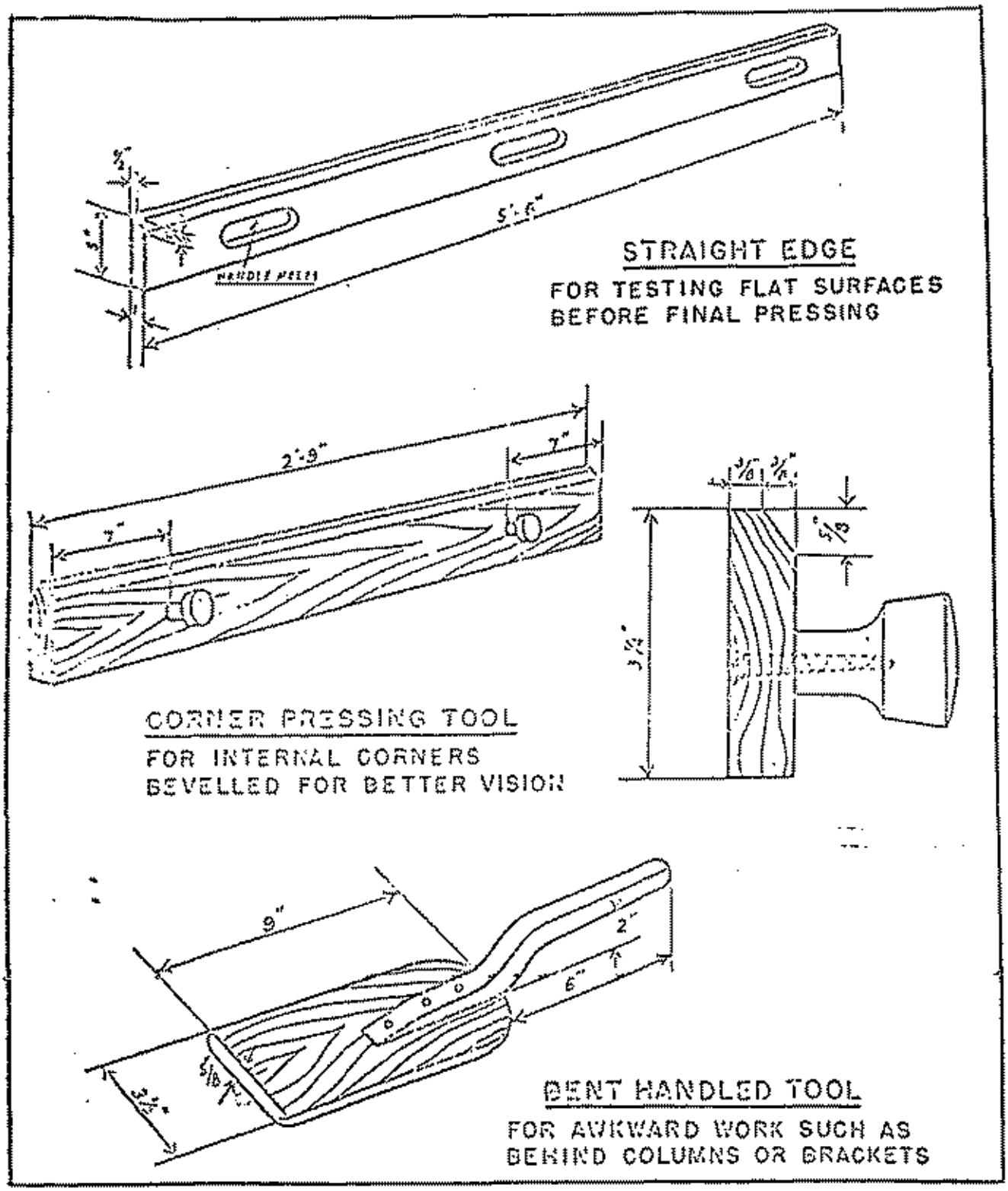
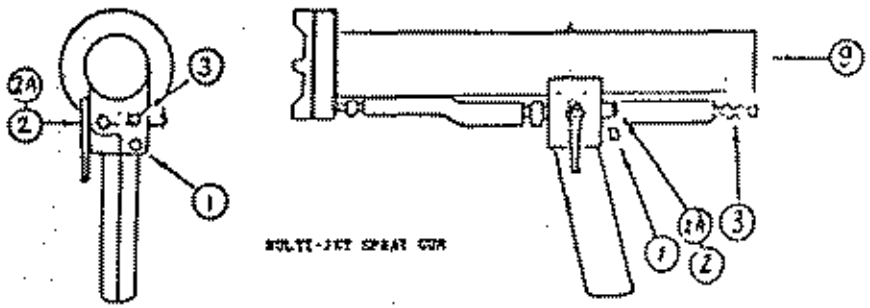


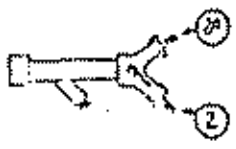
EXHIBIT 9

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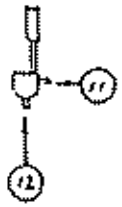
Armstrong Contracting and Supply Corporation: Sprayed "Limpet" Asbestos Machine Operating Instructions
ACL Doc 24016 · Page 24 of 25
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MULTI-JET SPRAY GUN



3 WAY VALVE



FUSED REGULATOR

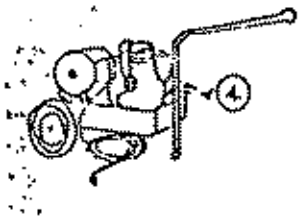
FORMAL WITHOUT T. S. 2

CONNECT 1—4, 2—12, 3—8, 9—10

SPECIAL WITH T. S. 2

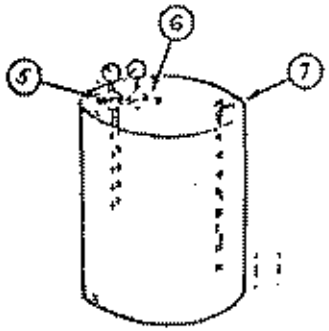
CONNECT 1—6, 2—12, 1A—7, 3—8, 4—5, 9—14

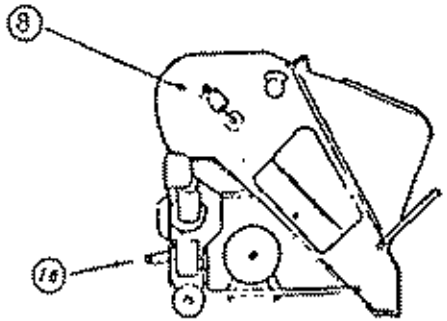
3-WAY VALVE CONNECTED IN TO PLUGS



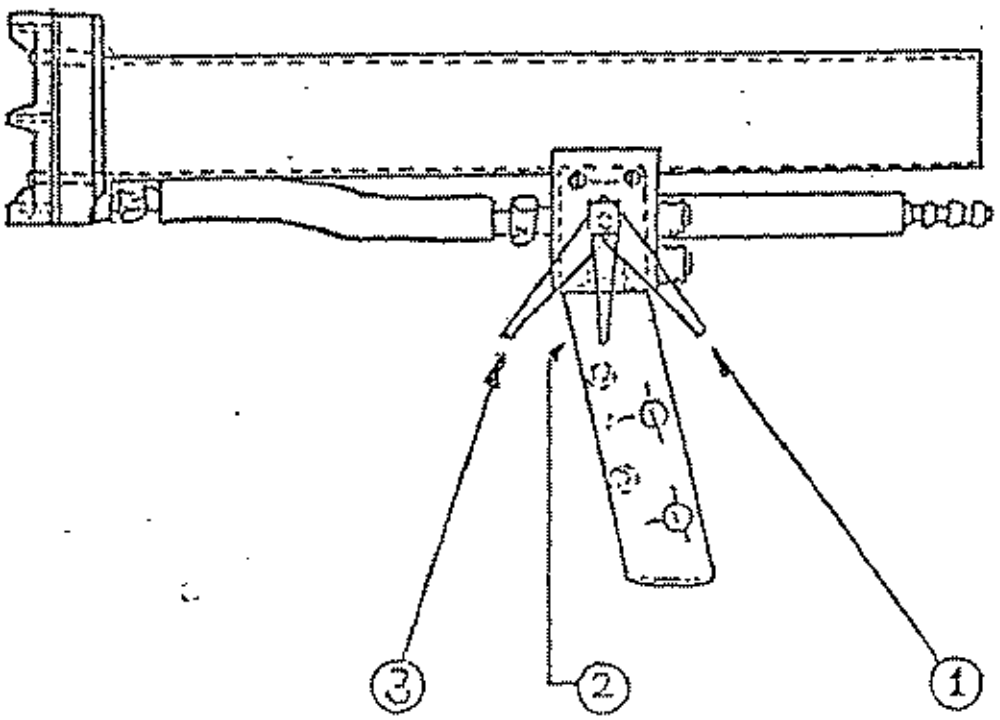
COMPRESSOR

PRESSURE TANK





AS TYPE RACHINE



Position 1 The trigger is in the off position. No water or fiber will be propelled from the gun.

Position 2 When the trigger is in position 2, depending upon setting of the two-way valve, only water vapor or T.S. -2 solution can come from the gun.

Position 3 When the trigger is in position 3, "LIMPET" and water are propelled from the gun.

When shutting off the gun, the trigger should not be moved from position 3 to position 1 in a quick movement as this causes dry fiber remaining in the hose to be blown into the air. Correctly, the trigger should be moved from position 3 to position 2 and held there for a few seconds, then moved to position 1. This hesitation allows the residue fiber to be carried the full length of the fiber hose and dispensed.

EXHIBIT 11

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