BULLETIN

[illegible]
April 15, 1955

To All District Managers

High Temperature Insulation
~~Fitting Covers~~
Fabrication Shop

Our

~~The Johns-Manville~~ Industrial Contract Department has ~~developed, in very complete detail, the~~ design for a Fabrication Shop ~~intended solely for the purpose of fabricating covers of Magnesia, Thermobestos and Superex for valves, tees, tube turns and bent pipe.~~ to produce [illegible]

A complete shop, in accordance with the above design, has been constructed at the Manville Research Center. This shop is not a model but an actual full-scale installation of the design recommended. Many groups of our people including some of our Technical Service Units have ~~been invited to~~ view this Fabrication Shop and their reactions ~~generally~~ have been very favorable.

We are accordingly making all information necessary to the construction of such a shop available to all of our Technical Service Units. It is estimated that the cost of setting-up ~~this~~ a shop, exclusive of cost of floor area or building, would approach the neighborhood of $4,500. We cannot give an exact total cost figure since many of the items required may be built of scrap materials or may be already available at the ~~job~~ site. Variation in freight charges will also have a bearing on shop installation costs.

All costs incurred in the construction and outfitting of the subject shop shall be assumed by our Technical Service Units.

All of the facilities recommended within this Fabrication Shop fall into one of two groups:

Group A:

Items which will be supplied by Johns-Manville to the Technical Service Unit at Johns-Manville's cost upon receipt of a Purchase Order or LETTER from the Technical Service Unit.

Group B:

Items to be procured by the Technical Service Units from vendors of their own choice.

Following is a list of items which will be included in Group A:

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1. Two (2) specially fabricated wood and metal sliding table tops and jigs, including storage cabinet.

2. Steel foundations for table tops and bandsaw.

3. Lock-on canvas cover for bandsaw.

4. Assorted charts.

Total Cost to Technical Service Units (Johns-Manville Cost) $1,900.00

Following is a list of items which will be included in Group B:

1. One (1) Do-All Model HSH-16" Bandsawing Machine arranged for 20" work height, without table, including 3/4 H.P. - 3 phase - 60 cycle - 220 volt motor.
(Approximately $865.00)

2. One (1) No. 12 Do-All Butt Welder (for blades) with grinder and blade shear installed and wired into machine.
(Approximately $130.00)

3. One (1) Dust Collection System similar to The Torit Dust Separator No. 19-FP with 2 H.P. motor - 3 phase - 60 cycle - 220 volt and starter.
(Approximately $800.00)

4. One (1) all wood transfer table 48" x 36" x 37½" high with swivel casters and two (2) removable plywood tray tops with handles.

5. Two (2) all wood tables 96" x 36" x 37" high with galvanized sheet metal work surfaces (no casters).

6. Two (2) all wood tables 36" x 24" x 19¼" high with galvanized sheet metal surfaces for holding dipping pans (no casters).

7. Two (2) all wood double-decked material feeding tables 72" x 24" x 73" high on swivel casters - 24" wood decks.

8. One (1) stand-up metal desk with drawers (approximately 36" x 30" x 45" high).

9. Two (2) metal clothes lockers.

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10. One (1) Industrial type [illegible] clean... storage facilities for [illegible]

11. One (1) platform approximately 10" high covering immediate work area of benders.

12. Rough wood shelving approximately 1½ ft. deep 5 tiers high. Recommended minimum total shelf area - 400 sq.ft.

13. One (1) dozen small master-keyed padlocks.

14. Trash can - large.

15. Two (2) galvanized iron trays for adhesive.

16. Sufficient dust respirators (Dust Foe No. 55 or equal) and [illegible] (American Optical or equal) as required for shop personnel.

17. Electrical switches, wiring, etc., to connect saw, dust collection system, etc.

18. Miscellaneous ductwork to Dust Collection Unit.

It is recommended that 1,500 sq. ft. (approximately 30' x 50') be allocated for the Fabrication Shop operations. This figure is, however, very flexible as our Industrial Contract Department will assist in making a survey of existing facilities with an eye to fitting the shop to existing conditions.

Our Industrial Contract Department will personally assist, in addition to the laying out of a floor plan for a shop, in the supervising of the [illegible] and planning of all facilities. Our Industrial Contract people will also [illegible] to make their services available after the shop has been completed for the purpose of training designated personnel in its proper use.

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