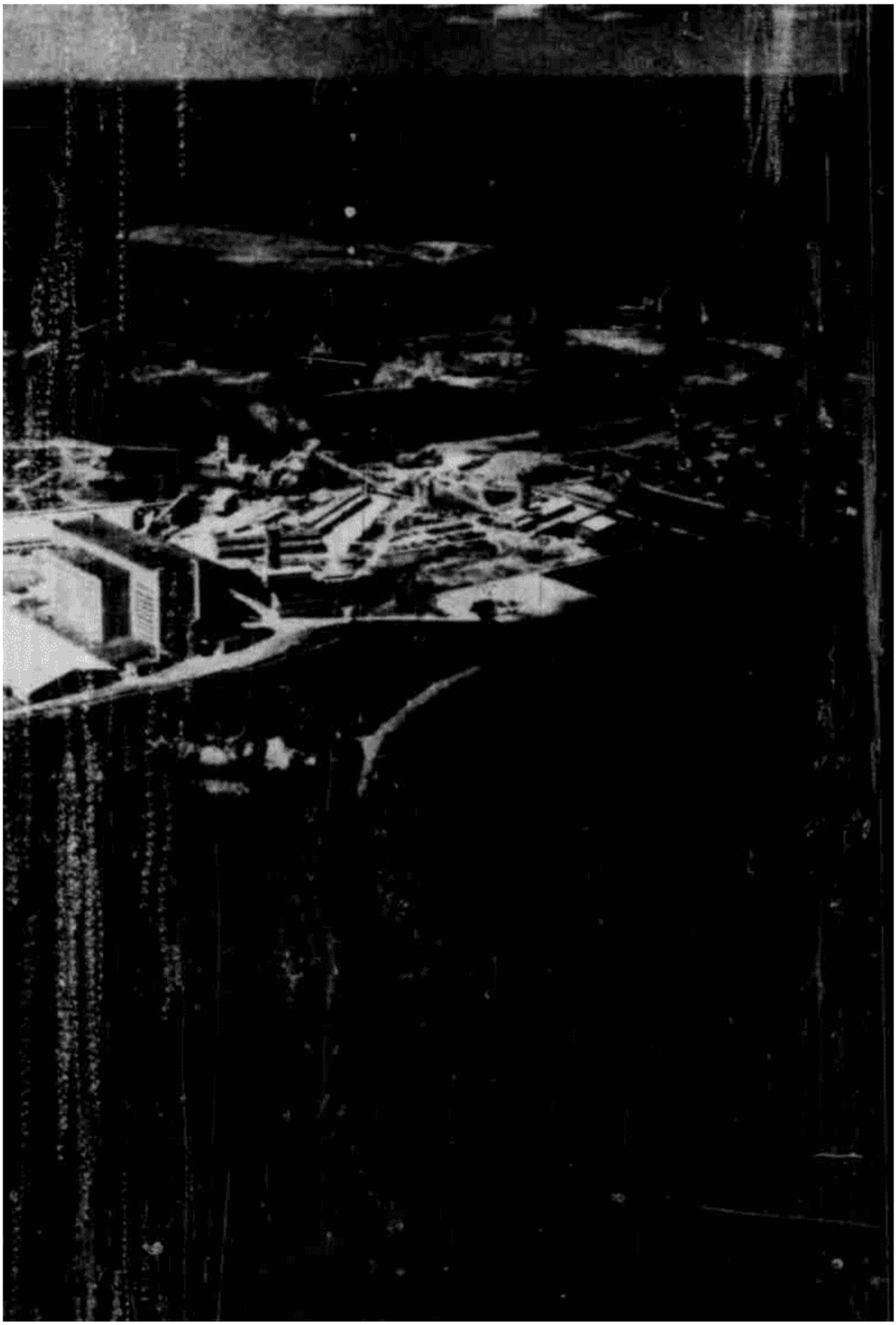
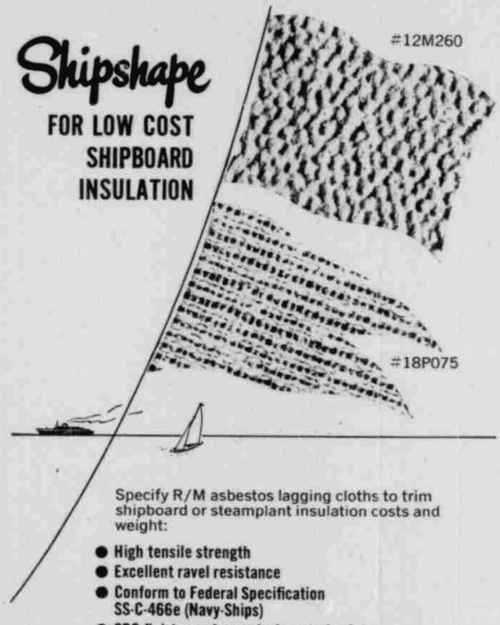


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ASBESTOS

VOLUME 47 JULY 1965 NUMBER 1

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MODERN WAYS OF PRE-CURING ASBESTOS-CEMENT PRESSURE PIPES

(This article was submitted by Dr. Klaus E. Bohnemann, Engineer, Asbestos-Cement Machinery Department, GEBR. WEHRHAHN, Linoleumstrasse 3, (P.O. Box 209), Delmenhorst, Germany.)

Our modern pipe machine with automatic control, pressure variation and automatic recording instruments makes it possible to actually form the pipe in extremely short periods of time. These heavy duty pipe machines are equipped with an up-to-date mandril feed that will, by one single motion and in only one direction, pull the formed and wet asbestos-cement pipe together with its mandril out of the press section and at the same time introduce a bare mandril into the machine. With this modern equipment, the WEHRHAHN system allows mandril changing within 6 seconds and even less.

This ingenious mandril feed and the pipe machine itself actually constitutes a technological unit, thus making it possible to momentarily adapt the complete unit to any required pipe diameter by simply pressing a button. This will enable an uninterrupted production of small, medium and large diameter pipes.

In this way, pipe production is guaranteed best possible conditions, not only with regard to the output of the machine and the quality of the asbestos-cement pipes but also with regard to an economical mixture. The latter is due in particular to quick mandril changing that will keep pipe machine stops down to a minimum. Such stops, if they are too long, cause vacuum to be applied on one point of the felt for too long, and a standstill of the sieve cylinder. This will affect the quality of the pipes.

Pipe plants which now achieve high outputs need an economic, trouble-free and quick method of pre-curing the wet asbestos-cement pipes; i.e., a method by which a quick crystallization and hardening of the cement can be obtained without affecting the final strength of the pipes.

Regardless, after forming, whether the pipes are placed into water basins for about 6 to 15 days, whether they are douched for the same period of time, or whether they are hardened in an autoclave, there will always be the problem of how to most economically arrive at a strength that will

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allow the pipes to be transported and stacked without danger of deformation.

Principally, there are two different methods of pre-curing: without mandril, with or without supporting cores; and, on the mandril.

PRE-CURING WITHOUT MANDRIL

The Simple Method of Letting the Pipes Dry on Platforms at Room Temperature

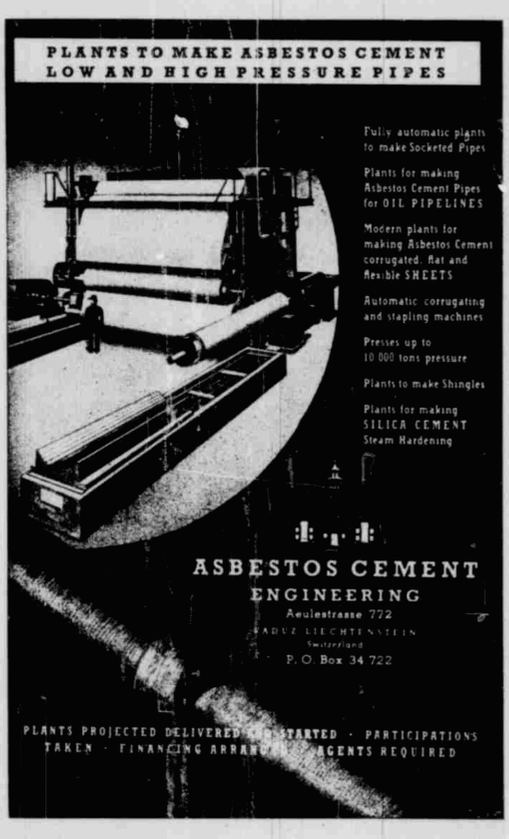
In the case of smaller plants located in areas with a hot climate or in countries where labor is cheap, the wet pipes are placed on platforms and then supporting cores of wood, light metal or plastics are introduced. These cores may be long, to support the whole pipe, or short, to support only the pipe ends. This will help maintain the roundness of the pipes, or at least their ends. As soon as the solidification point of the cement in the pipe is surpassed, the supporting cores can be removed and used for other pipes. After a total pre-curing time of about 5 to 8 hours (depending on the cement quality and the temperature), the asbestos-cement pipes are placed into water basins. If the cement contains silicate, the pipes require about 24 hours before they can be brought to the autoclave for steam hardening.

This method of pre-curing the pipes on the platforms has the advantage of being very simple and economical. All one needs is an appropriate number of supporting cores, a quick and alert crew, and space enough to deposit the pipes during the pre-curing period.

Pre-Curing on a Roller Conveyor at Room Temperature

This method has been developed mainly on Russian initiative and consists of a driven chain system that drags rotating rollers of steel or asbestos-cement (7-9 feet in diameter) along guide rails and supporting elements placed in the center. Each wet asbestos-cement pipe hereby turns on to two of the rollers dragged along by the endless chain conveyor. The advantage of this method is a good ventilation of the asbestos-cement pipe also from the inside, as well as the very simple construction of the conveyor from the engineering point of view.

A disadvantage is undoubtedly the great amount of space required for such an installation because, for 8 hours



of pre-curing, the conveyor would have to be about 80 to 150 m (265 to 500 feet) long, depending on the output of the pipe machine and the diameter of the manufactured pipes. However, the complete length of this pre-curing installation could be reduced by distributing the required conveying space onto two or three stories.

In spite of its very simple construction, this installation still requires relatively a lot of care, as every individual conveyor roller must be mechanically worked and straightened in order to keep the asbestos-cement pipes round and straight.

Pre-Drying on a Roller Conveyor in a Kiln

This method is a modification of the one mentioned above and consists of a shortened conveyor moving inside an insulated drying chamber. The complete length of this pre-curing installation is generally about 35 to 55 m (120 to 185 feet). For speeding up curing, the drying chamber is equipped with an air conditioner that will produce temperatures between 40° and 70° C. (100° and 160° F.) and an air moisture of 100%. In about 1¾ to 3 hours (always dependent on the quality of the employed cement and the temperature and moisture inside the drying chamber), the pipes will have hardened to such an extent that they may be transported for further treatment. The pre-curing methods described so far represent no technical problem whatsoever and this can be regarded as an advantage. Nevertheless, the disadvantages should not be overlooked. These show, in particular, when working with a fully automatic heavy duty plant, and are described below.

Immediately after forming and calendering, the wet asbestos-cement pipes are drawn off their mandril. This drawing-off procedure of the still plastic asbestos-cement pipe already endangers the valuable product to a certain extent, despite the employment of a variety of auxiliary means and precautionary measures.

Introducing a supporting core (if this method is employed) will cause danger of deforming the pipe, no matter how apt the workman may be.

The supporting cores must be introduced by hand and this will require one man constantly on the job. This

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means an increase in personnel.

On the roller conveyor, the asbestos-cement pipe has only two linear bearing surfaces and these must take up the whole weight of the pipe. Since the distance between the conveyor rollers remains invariable, the angle of the two bearing surfaces will vary according to the diameter of the asbestos-cement pipes. The smaller the diameter of the pipe, the greater this angle will be.

In practice, this means that an asbestos-cement pipe of small diameter will lie far between the two supporting rollers of the conveyor and its bearing surfaces will form an angle of approximately 120°; whereas, pipes of a very large diameter will lie further up and their bearing surfaces will form an angle of only about 40°. During transportation on the roller conveyor, the bearing forces will cause a constant deformation of the pipe, although not visible to the eye. This fulling effect on the asbestos-cement pipe will interfere with the forming of a firm structure during solidification of the cement and will, as every asbestos-cement specialist knows, prevent preservation of the original firm structure of the pipe. A better mixture can make up for this deterioration of structure, but this will mean higher raw material costs.

In spite of their simple construction, the roller conveyors will still be very expensive because they consist of a great number of individual pipes that all have to be worked. In practice, not even half of the rollers are actually used for conveying asbestos-cement pipes; all others return idle.

However, with this method the number of mandrils required for production can be kept very low.

Due to the corrosive effect of the wet steam inside the enclosed and heated kiln, the steel rollers will get rusty and will have to be cleaned, ground with emery and oiled repeatedly, if a smooth outer surface of the asbestos-cement pipes is to be maintained. This will require a considerable amount of additional time and money.

PRE-CURING OF ASBESTOS-CEMENT PIPES ON THE MANDRIL

Pre-curing of asbestos-cement pipes while still on their

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mandril is undoubtedly the best and most careful method of pipe hardening today. WEHRHAHN has already included this knowledge in the construction of their heavy duty pipe plants.

The kiln arrangement, the WEHRHAHN pipe machine, and the mandril feed with its calender and pipe control station form a technological and constructional unit. The mandrils are equipped with especially constructed studs. In the press section of the pipe machine, the mandrils take up the material and the asbestos-cement pipe is formed. The mandril together with the asbestos-cement pipe is then automatically brought to the calender and control station and finally placed on a special chain on which it runs through the kiln. The mandril rotates constantly during this procedure and this will effect a particularly uniform drying of the asbestos-cement pipe.

Such kilns are very economic in operation. The firm GEBR. WEHRHAHN has already built kilns with two to five traveling stories inside.

These kilns may be of varying construction:

(a) The asbestos-cement pipe is separated from its mandril after the second or fourth story; i.e., when it again arrives at the front. The hardened pipe then travels through the kiln for a third or fifth time, but this time on a cup-shaped conveyor and without mandril. The pipe finally leaves the kiln on a path at the rear;

(b) this system is the same as above, only the hardened asbestos-cement pipe leaves the kiln at the side and rolls onto a roller bed for further treatment; and,

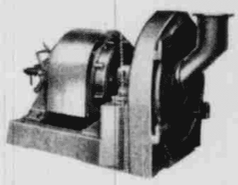
(c) the asbestos-cement pipe is separated from its mandril after the third or fifth story and leaves the kiln at the rear, as in (a). The bare mandril is brought back to the pipe machine by a high speed conveyor.

Types (a) and (b) are the ones most frequently employed.

The distance between the individual mandrils inside the kiln can continuously vary according to their diameter, thus achieving a maximum utilization of the available space. A kiln length of 10 to 15 m (33 to 50 feet) should be sufficient for even heavy duty pipe plants.

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The special features of these kilns are summarized as follows:

(a) curing takes place on the mandril; i.e., the mandril is drawn out only after the pipe has hardened. This makes it impossible for the pipe to be damaged;

(b) no fulling effect can deform the asbestos-cement pipe during the curing process;

(c) the length of the kiln is kept extremely short by employing more stories inside. The distances between pipes can be adapted to their diameters;

(d) favorable utilization of the caloric power, due to the reduced volume of the kiln;

(e) natural temperature increase from story to story; i.e., the asbestos-cement pipes are pre-heated on the first story and then receive more and more heat as they go up. In this way a temperature increase of about 20% to 30% is obtained; and,

(f) the mandrils coming from the kiln are brought back to the press section of the pipe machine still warm, thus also slowly warming the asbestos-cement material. This will help speed up hardening of the cement and will also prevent too great a difference in temperature when the pipe enters the kiln.

The great number of mandrils required is often brought up as an argument against the method of curing on the mandril. However, if one considers the number of rollers needed for the conveyor described previously, one will easily understand that the capital expense for a kiln plus the necessary mandrils is no higher than that required for a roller conveyor. The running charges and the waste, however, are considerably lower. Furthermore, it should be considered that generally the production program of every asbestos-cement factory contains pipes of various diameters so that if production is changed at certain intervals from one diameter to another, the need of mandrils may be reduced considerably and the asbestos-cement pipes can still be cured on their mandril.

The advantages of curing on the mandril have been shown in many large asbestos-cement factories all over the world and will undoubtedly lead to a constantly increased use of this method.



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Automatic Mill Control System

An automatic mill control system including remotely operated feeders, automatic sampling of fibre being processed and a closed-circuit television system has gone into operation in the mill of *National Asbestos Mines Limited*. The main purpose of the control system, located in its own room on the main floor of the mill, is to control automatically the fourteen vibrating feeders that supply the ore from the dry rock storage building, 100 yards from the mill itself. The entire system was designed, assembled and installed by National Asbestos employees. Each of the feeders can be set to deliver a precise tonnage of ore each hour. Also from the room-size, diagrammed panel that includes an impressive array of red and green warning lights, switches and dials, fibre technicians can accurately check and control the grading of fibre by altering the blending of different grades.

Every five minutes, another automatic device supplies a sample of each grade that is being processed. When combined, six of these samples make up a composite sample of every order that is being produced. Should the composite sample show that the grade being processed is slightly off specification, the fibre technician can swiftly and simply make the necessary adjustments on his panel to put the material back on grade.

Another piece of equipment in the National Asbestos control room is a television monitor just like a wall-mounted television set but limited to one channel. The closed-circuit system shows what is taking place in a gyrating crusher building, 150 feet from the mill. Its purpose is to aid safety—to show if men working on the crushers or their controls have properly reset switches, to find out if the building is occupied and to check for ore blockages and spillages.

MARINITE LIMITED will be demonstrating, at the Heatex Exhibition, the efficiency of one-inch thick Marinite as an external tank insulation to Temgas heated tanks, by means of gas flow meters and recorders.

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Ross E. Sampson, Mine Manager
Advocate Mines Limited

Ross E. Sampson was born on March 31st, 1921, in London, Ontario, Canada. He attended public and high school in London and graduated from Queens' University in 1945 with the degree of Bachelor of Science in Mining.

His first position was the International Nickel Company of Canada Limited, at Sudbury, Ontario, and he then worked for Cochenour Williams Gold Mines at Red Lake, Ontario.

Mr. Sampson joined Canadian Johns-Manville Company Limited in April 1947 as Assistant Engineer at Jeffrey Mine. He was subsequently promoted to Mining Engineer, then to General Foreman Underground, transferred to Munro Mine at Matheson, Ontario, in December 1954 as Acting Underground Mine Superintendent, and was appointed Underground Mine Superintendent in September 1958. On April 1st, 1963, he was transferred on loan to Advocate Mines Limited, Baie Verte, Newfoundland, as Plant Engineer and appointed Mine Manager of Advocate on July 16th, 1964, the position which he presently holds.

Mr. Sampson is married, has four children, and is a member of the Rotary Club and the Canadian Institute of Mining and Metallurgy. He was mayor of Matheson, Ontario, for three years and his hobbies are hunting, fishing and gardening.

ASBESTOS PADS—Massive base-plate to support 38 stories of structural steelwork rests atop one of the concrete foundations for Canadian Pacific's Chateau Champlain hotel, now under construction near the railroad's Montreal terminal. Because of lead-asbestos "sandwiches" inserted between the base-plate for the structural steelwork and the foundations, guests will be undisturbed by vibrations from rail and road traffic near the hotel and from Montreal's new Metro which passes beside the luxury hotel-office building complex. The weight of the building exerts a half ton pressure on each square inch of the pad surface.



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INDUSTRIAL PRODUCTS

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ASBESTOS CEMENT INDUSTRIES LIMITED, Ceylon, has set a new asbestos-cement sheet production line into operation. By the application of the patented system of Atmospheric Corrugator, this plant allows the use of asbestos fibre of shorter lengths for the production of geometrically-precise, fault-free corrugated roofing sheet. This plant was commissioned in October 1964 at a ceremony at which the Honorable Minister of Rural & Industrial Development complimented the company on its rapid expansion and the excellent quality of its products. After a period of "running-in", the daily production of this plant is 140 tons. The complete machinery for the Atmospheric corrugating system and other automatic machinery, such as Piler, Depiler and Lubricating machines, were imported from and installed by *J. M. Voith A.G.*, St. Polten, Austria, who had shortly before modernized another sheet plant of this company.

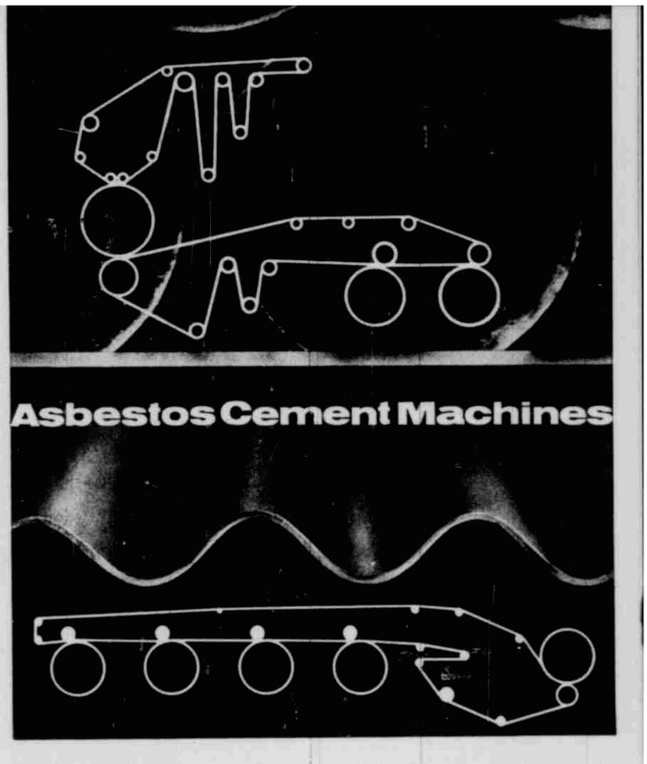
Asbestos Cement Industries Limited, the pioneer asbestos-cement manufacturer in Ceylon, was incorporated on November 28th, 1955. It commenced production with one plant in 1957 and now has a total of four of the most modern plants in the world. It manufactures a variety of roofing and flat sheets and about 150 different items of moulded goods and employs a work force of nearly 700. In 1962, the company negotiated with Tudor Trust, Vaduz, Liechtenstein for the sole right to manufacture roofing sheets by the Atmospheric system and obtained the license for Ceylon. Corrugating asbestos-cement sheets by this system is the most up-to-date method in the world today.

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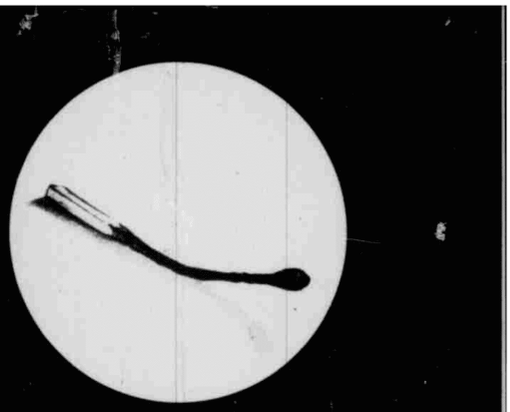
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Automobile Sales

The Automobile Manufacturers Association, Detroit, Michigan, has issued the following statistics of motor vehicle factory sales from plants in the United States for APRIL 1965: total 1,017,737 (passenger cars 860,996; trucks and buses 156,741). The total for APRIL 1964 was 939,859. The figure for the first four months of 1965 was 3,985,040 compared with 3,474,142 for the same period 1964.

NICOLET INDUSTRIES, INC. has purchased a new fourdrinier and press section from Sandy Hill Corporation. Nicolet expects the new machine to go into operation in its Norristown, Pennsylvania, plant by the end of this year. The new installation will mark Nicolet's first venture into the use of a fourdrinier wet end. Up to this time all the machines in its plants have been of multicylinder design. Advanced technology in production and new asbestos product lines developed in Nicolet's research facilities at Florham Park, New Jersey, led to the selection of a fourdrinier for the new installation. The fourdrinier and headbox will incorporate a number of special design features. The new machine will produce all grades made in the cylinder operations in addition to the new product lines. Nicolet, specialists in asbestos products and the country's largest producer of asbestos papers and boards, is largely a manufacturer's manufacturer, producing custom-made specialties for converting into consumer products. Raw materials for all of Nicolet's operations come from its asbestos mine holdings in Quebec, Canada.

BALDWIN-EHRET-HILL, INC. has announced a new branch office opening in Fanwilworth, New Jersey. This location has a complete staff of sales engineers and qualified insulation applicators that will serve the North and Central sections of New Jersey with the full line of B-E-H insulation products. The new office and warehouse is located at 715 Fairfield Avenue (P. O. Box 238) and this addition makes a total of 15 B-E-H Contract and subbranch locations located in strategic marketing areas across the United States.



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FLINTKOTE

TURNERS ASBESTOS FIBRES LIMITED, a Turner & Newall company, has issued a new sales booklet covering its entire range of raw fibre from Southern Africa and Canada. Grades can be supplied to suit the needs of all manufacturing industries for asbestos textiles, asbestos-cement, friction materials, insulation materials, papers and boards and plastics fillers. The booklet contains details of packaging and ports of shipment for consignments of fibre. Brief mention is also made of the work of the T&N Asbestos Fibre Laboratory and the laboratories at the mines in ensuring the consistently high quality of the grades offered. A list of the company's principal agents throughout the world is included.

TURNERS ASBESTOS CEMENT COMPANY LIMITED, a Turner & Newall company, is to establish a factory in Northern Ireland to manufacture asbestos-cement products, mainly for the building industry. Up to now the Northern Ireland market has been supplied largely from the company's factory at Widnes in Lancashire, England. The new factory, which will cost £1½-million, will be the first asbestos-cement factory in Northern Ireland and the eighth Turners Asbestos Cement factory in the United Kingdom. It is anticipated that the new factory will be in production within eighteen months.

SYSTEMS ENGINEERING CONFERENCE & EXPOSITION will be held in McCormick Place, Chicago, Illinois, September 20th through 23rd, 1965. The program for the 1965 sessions will place increased emphasis on systems design, development and applications. Special attention will be paid to methods of adapting currently used and highly sophisticated systems techniques to industrial requirements. Executives interested in obtaining more detailed information should write the producers, Clapp & Poliak, Inc., 341 Madison Avenue, New York, New York 10017.

CHECK THE PLUS FACTORS OF THIS 7RF FLOAT!



1. UNUSUAL WHITENESS
2. LOW IRON CONTENT
3. GRIT-FREE
4. UNIFORM FIBRE LENGTH
5. HIGH FIBRE VALUE
(90% on 100 mesh)

Carey-Canadian's 7RF-9, available in commercial quantities, has proved to be of extreme interest to resin compounders, joint cement manufacturers and others seeking an asbestos float with the above properties.

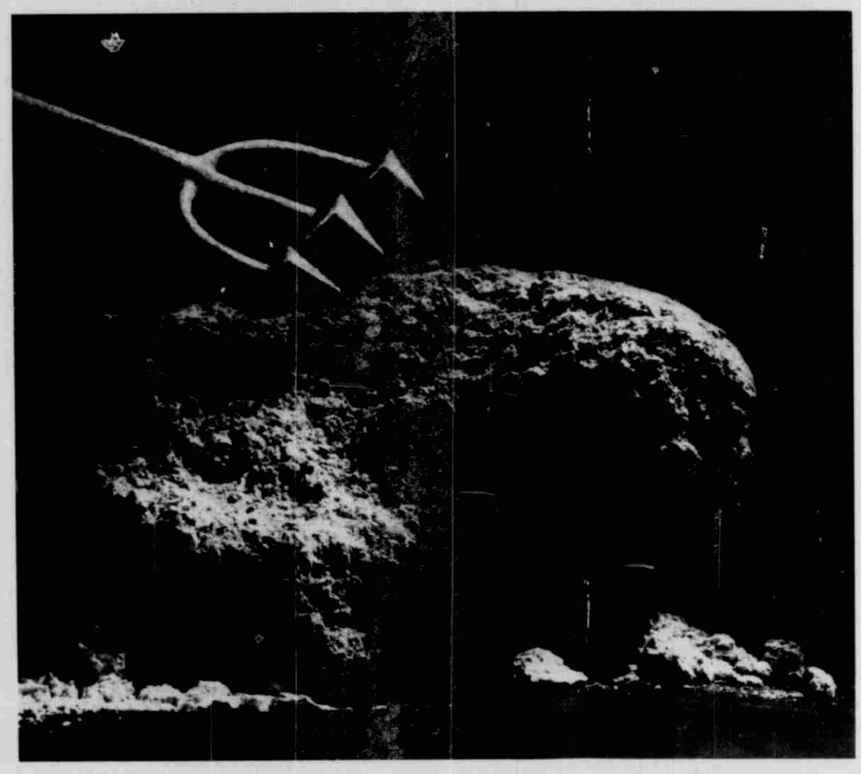
Samples and complete information on Carey-Canadian 7RF-9 floats may be obtained from the warehouse locations listed below or by writing to Carey-Canadian Mines, Ltd., P.O. Box 15095, Lockland, Cincinnati, Ohio 45215, or The Philip Carey Company, Ltd., Ville St. Laurent, Montreal 9, P. Q., Canada.

Carey®

Warehouse stock located at:

Baltimore, Md.	A. B. Kohl Sales Company
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Chicago, Ill.	Chicago Firebrick Company
Cleveland, Ohio	Donald McKay Smith, Inc.
Dallas, Texas	Thompson-Hayward Chemical Company
Davenport, Iowa	Thompson-Hayward Chemical Company
Des Moines, Iowa	Thompson-Hayward Chemical Company
Detroit, Mich.	A. E. Fleming Company
Garwood, N.J.	Asbestos Corporation of America
Houston, Texas	Thompson-Hayward Chemical Company
Indianapolis, Ind.	Thompson-Hayward Chemical Company
Kansas City, Mo.	Thompson-Hayward Chemical Company
Knoxville, Tenn.	A. G. Heins Company
Little Rock, Ark.	Thompson-Hayward Chemical Company
Los Angeles, Calif.	E. S. Browning Company
Memphis, Tenn.	Thompson-Hayward Chemical Company
Milwaukee, Wisc.	Sprinkmann & Sons
Minneapolis, Minn.	Thompson-Hayward Chemical Company
New Orleans, La.	Thompson-Hayward Chemical Company
Oklahoma City, Okla.	Thompson-Hayward Chemical Company
Philadelphia, Pa.	George A. Rowley & Company, Inc.
Pittsburgh, Pa.	McCann-Shields Paint Company
St. Louis, Mo.	Thompson-Hayward Chemical Company
San Francisco, Calif.	E. S. Browning Company
Seattle, Wash.	Durkin Chemicals, Inc.
Trenton, N.J.	H. M. Royal, Inc.
Winchester, Mass.	W. D. Egleston Company, Inc.

How the devil's asbestos cuts floor tile cost.



High in the Diablo Mountains, the new Johns-Manville Coalinga mill produces a very special grade of asbestos. Diablo, of course, is Spanish for devil. And the unusual asbestos mined in this central California range is proof some devils are really good guys.

Coalinga fibers are short and strong. Which makes them ideally suited to floor tile use. And they are exceptionally bright and clean. Which enables tile manufacturers to cut pigment cost substantially.

Still more proof the Diablos are good guys: this range promises an almost unlimited supply of short, bright, floor-tile-perfect asbestos fiber. Utilizing the most modern production methods, the J-M Coalinga mill assures their usefulness to our friends in the flooring industry.

For asbestos fiber literature, write Canadian Johns-Manville Co., Ltd., Box 1500, Asbestos, P.Q. Or Johns-Manville, Asbestos Fiber Sales, Research and Engineering Center, Manville, N.J.

JM

Johns-Manville

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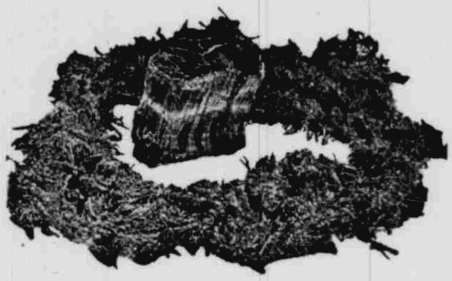
Building

The value of contracts for future construction work reached an all-time high of $4,864,226,000 in MAY 1965, 5% ahead of May 1964, it was reported by F. W. Dodge Company, a division of McGraw-Hill, Inc. This month typically brings the year's peak in the value of new construction contracts. Nonresidential building contract value surged ahead to $1,774,580,000, an amount 30% above May 1964. Commercial and manufacturing building continued to spark the growth in nonresidential contracts. Large percentage gains also scored in educational, public, and social and recreational building; hospitals and religious building values declined. Residential building contract value was $2,074,171,000 exceeding the still-buoyant year-ago amount by 1%. One-family housing, up 6%, provided all of the increase in May. Contracts for apartments and nonhousekeeping units were both below their totals. Nonbuilding construction contract value totaled $1,015,475,000 and was 17% below the year-ago amount. Streets and highways declined 12%. In addition, the sharp decline in contracts for dams and reservoirs reflects, in part, the fact that several big projects were included in the year-ago figures. Utilities construction held about even with last year.

At the end of five months, cumulative construction contract value was $20,095,889,000 to lead the same period of 1964 by 2%.

BALDWIN-EHRET-HILL, INC. is offering a four-page bulletin explaining how *Thermasil* calcium silicate insulation inhibits stress-corrosion of stainless steel piping, vessels and other equipment operating at temperatures up to 1200°F. and gives results of six-day exposure in accelerated Dana test. This bulletin also contains data on physical properties, thermal conductivity, and compliance with Government and ASTM specifications. Thermasil pipe or block insulation is a molded, hydrous calcium silicate insulation—a blend of special inorganic ingredients reinforced with selected long asbestos fibers.

Australian Blue Asbestos Pty. Limited



Australian Blue is an ideal fibre for asbestos cement and for purposes requiring good heat insulation and acid resistance. It has excellent spinning properties. Samples available on request.

SOLE SELLING AGENTS

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St. Vedast House, Cheapside, London, E. C. 2.

Algeria, Belgium, Bulgaria, Canada, Denmark, France, Egypt, Eire, Finland, Great Britain, Greece, Holland, India, Iran, Iraq, Italy, Kuwait, Lebanon, Liechtenstein, Morocco, Nigeria, Norway, Pakistan, Portugal, Rumania, Spain, Sweden, Switzerland, Tunisia, Turkey, Uganda, Uruguay, Viet-nam, West Indies.

Huxley Development Corporation, Time & Life Building, New York.

United States of America, Yugoslavia.

In Australia, address inquiries to:—
AUSTRALIAN BLUE ASBESTOS PTY. LTD.
89 St. George's Terrace, Perth,
Western Australia.

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ASTM—The election of the following new national officers for the American Society for Testing and Materials was announced during the 68th Annual Meeting of the Society: President—*Robert F. Legget*, Director, Division of Building Research, National Research Council of Canada; Vice President—*Frank J. Mardulier*, Manager, Rock Products Chemicals, Dewey and Almy Chemical Division, W. R. Grace & Company; and, Vice President—*James B. Rather, Jr.*, Manager, Toxicology and Pollution, Research Department, Socony Mobil Oil Company, Inc. New members of the Board of Directors elected for three-year terms were: *Frank M. Gavan*, General Manager, Physical Test Department, Research & Development Center, Armstrong Cork Company; *William H. Goetz*, Research Engineer, Engineering Experiment Station and Professor of Highway Engineering, School of Civil Engineering, Purdue University; *John L. Menson*, Executive Vice President, Michigan Seamless Tube Company, and President, The Standard Tube Company; *Raymond B. Smith*, Director, Engineering Standards, Reynolds Metals Company, *Clifford W. Straitor*, Supervisor of Standards, The Detroit Edison Company; and, *Samuel A. Wenk*, Manager, Accelerator Applications, Radiation Division, Varian Associates.

'ASTM COMMITTEE C-16 (Thermal Insulating Materials)—The newer types of thermal conductivity apparatus were described in a technical session sponsored by Committee C-16 on Thermal Insulating Materials at its meeting in Atlanta, Georgia, March 7th through 10th, 1965. These included apparatus based on the use of line heat sources, a heat flow meter and a conductivity disk thermal conductivity apparatus. A review of stress corrosion investigations in the thermal insulation field was also included in the technical session.

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Is the combination of chrysotile properties you're looking for RIGHT HERE?

Best way to find out is to tell us what product you make and the properties of the reinforcing fibre most important to you . . . high reinforcing strength, superior wetting characteristics, greater surface area, low grit content. Your test evaluation may find the characteristics of Lake fibre ideally suited to fill your needs.

Lake's annual capacity of 100,000 tons of high grade chrysotile asbestos fibre is processed to meet the special requirements of its customers.

For test sample and catalog, write to Asarco International Corporation, 120 Broadway, New York, N. Y. 10005, distributors for Lake Asbestos of Quebec, Ltd.

LAKE ASBESTOS

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Atlanta Bauer & Co.
Bremen, Germany

BELGIUM
Keyser & MacKay
Brussels

EGYPT
Textile Improvements Ltd.
Guildford, England

ENGLAND
Metal Traders, Ltd.
Asbestos Division
London

FRANCE
Dieppedalle & Seailles
Paris

GERMANY
Atlanta Bauer & Co.
Bremen

GREECE
Textile Improvements Ltd.
Guildford, England

HOLLAND
Keyser & MacKay
Amsterdam

INDIA
Metal Distributors, Ltd.
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ITALY
Amianto Del Lago
Torino

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C. Itoh Co., Ltd.
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Astrup & Son
Oslo

SOUTHEAST ASIA
Jardine Waugh, Ltd.
Singapore

SPAIN
Textile Improvements Ltd.
Guildford, England

SWEDEN
Titan
Stockholm

TURKEY
Textile Improvements Ltd.
Guildford, England

ASARCO INTERNATIONAL CORPORATION
A SUBSIDIARY OF AMERICAN SMELTING AND REFINING COMPANY ASARCO

MARKET CONDITIONS

General Business.

General business conditions continue quite good. As this is written the President's proposal for eliminating some, and cutting other, excise taxes seems sure of enactment and this should give a lift to many lines of business by, in effect, putting more money in the consumer's pocket. As things have been going, such money will almost surely be spent. It is most encouraging to see this further evidence that our political leaders recognize the throttling effect of high taxes on the general economy and are willing to do something about it. Certainly, if we can't cut taxes in an era of good business such as the present, we never will.

Industrial production and consumer spending continue at very high levels. The stock market has suffered a rather severe decline but, while selling has been heavy at times, there have been no indications of panic and leading economists feel that business will continue good for some time to come.

Asbestos—Raw Material.

Quebec asbestos fibre shipments for the Industry during May 1965 totalled 103,525 tons. However, as the result of an error in reporting April shipments (105,592 reported —should have been 106,407), the difference of 815 tons has been added to the May figure for a total of 104,340 tons. This tonnage is 12,371 tons or approximately 10% lower than the same period last year. Year to date shipments at 398,955 tons are running 41,450 tons or approximately 9% below the same period 1964.

Asbestos—Manufactured Goods.

Asbestos Textiles. The demand for asbestos textiles continues strong and with current heavy government purchases placing additional demands on the industry, there is every evidence of a continuing high level of operation for the month ahead. The industry looks to 1965 as another banner year.

Asbestos Brake Lining. The market both in Replace-

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ment and O.E.M. continues on a very high level. The forecast for the rest of the year is good.

Asbestos Paper. The demand for this material is holding firm. However, an increase in fibre and other costs indicate a 5% price increase for asbestos paper.

Asbestos Millboard. The demand for this market is also holding firm, although the situation is made somewhat difficult due to strikes at two producing plants.

Asbestos Saturated Paper. Asbestos Felt usage is much higher than it was for the equivalent period last year. A 20% to 25% gain in volume of business is indicated over last year.

Corrugated & Flat. The amount of large projects using corrugated is slightly ahead of 1964 and the rest of the year should be good.

High Pressure Insulation. Demand for high temperature insulations remains strong during the first six months of 1965 and is expected to continue through the balance of the year. There are some indications of prices becoming stabilized.

Asbestos Cement Shingles—Roofing & Siding. Some companies report that industry promotion efforts are showing good results and that mineral fibre siding is making inroads against competitive products. Other firms feel that the siding and roofing market in new construction has had a late start this year and do not feel as if the remaining half of the year can make up for lost orders. Other siding materials are taking an ever-increasing part of what used to belong to asbestos-cement in new construction. However, all companies reporting expect a pick-up in demand and have a good outlook for the year.

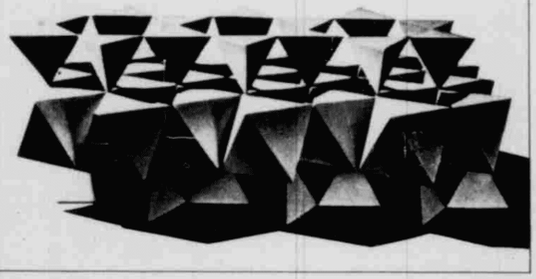
Asbestos-Cement Pipes. Strong demand is continuing for all pipe products and the long range outlook is good.

Asbestos Filter Fibre. Markets are holding steady and Arizona mines are increasing production. Demand for lower grades is steadily increasing and this situation should remain for the balance of the year.

The above comments have been made by various informed executives in the Industry. All comments are welcome.

Raw and processed amphibole from the

Schematic representation of structure of Amosite and Blue Asbestos



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* Largest producers in the world of Amosite and Blue (Crocidolite)
* Fibres from a number of different South African mining areas—blended for different applications
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114 Park Street, London, W.1 Tel: GRO 6022

(A member of the Cape Asbestos Group of Companies)

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ASBESTOS-LINED PIPE—Using cost data from a half mile of in-plant piping as a yardstick, Pennsalt Chemicals Corporation estimates that asbestos-lined reinforced plastic pipe carrying corrosive chemicals in its Wyandotte, Michigan, plant pays for itself in less than two years. Because of the dollar savings and increased efficiency that result, Pennsalt is gradually changing over from rubber-lined metal to RP pipe in ferric and acid units of its chemical production complex in Wyandotte. The thermo-setting plastic-based pipe has demonstrated advantages of lower cost of installation and maintenance, longer service life and an increase in the plant's overall efficiency that has been achieved by reducing the number of emergency shut-downs caused by piping failures. The pipe's general utility in the chemical processing industry, as well as its high flow characteristics and exceptional resistance to heat and abrasion, are credited in large measure to an inner liner of epoxy reinforced with *North American Asbestos Corporation's crocidolite asbestos fibers.* Crocidolite asbestos is stronger and more resistant to both acids and alkalies than any other fibrous reinforcement known.



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PRODUCTION

Australia—The Bureau of Mineral Resources has issued "The Australian Mineral Industry" containing the following production statistics on asbestos for the 3RD QUARTER 1964: Production totalled 3,150 short tons (Chrysotile—428 & Crocidolite—2,722).

Australia—It is estimated that crocidolite asbestos production in 1964 was about 12,000 short tons, the lowest recorded output since 1956. Production of chrysotile asbestos is estimated to have increased from 949 short tons in 1963 to about 1,700 short tons in 1964. A new operation, the Comet Mine, near Marble Bar, Western Australia, which commenced production towards the end of 1963, provided the increase in chrysotile production. (Bureau of Mineral Resources)

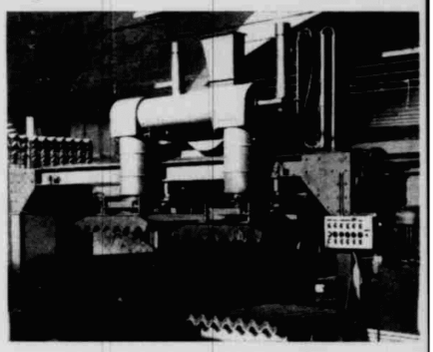
Canada—According to the Dominion Bureau of Statistics, Ottawa, production of asbestos in Canada during MARCH 1965 amounted to 84,303 tons compared to 82,153 in March 1964. Total for the first three months of 1965 was 215,258 compared to 230,594 for the same period in 1964.

Rhodesia—The Ministry of Mines and Lands, Salisbury, has issued the following statistics on asbestos for APRIL 1965: Production—14,078.10 short tons; valued at £681,791.18.06.

Charter of the Quebec Mining Exploration Company, Bill 10, has had its first reading by the Legislative Assembly of Quebec. The company shall have its corporate seat at or in the immediate vicinity of Quebec and its objects shall be: to carry out mining exploration by all methods; to participate in the development of discoveries, including those made by others, with power to purchase and to sell properties at various stages of development, and to associate itself with others for such purposes; and, to participate in the bringing into production of mineral deposits, either by selling them outright or transferring them in return for an interest. The authorized capital of the company shall be $15,000,000. (The policy of miners begins by the basic law with Bill 8—Mining Act and Bill 9—Mining Duties Act.)

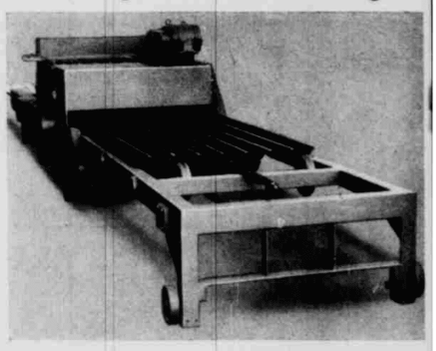
Hedman Mines produced over 3,055,000 pounds of asbestos during 1964, valued at $67,226. This represented a recovery of 60% or 1,200 pounds of asbestos per ton treated at the company's pilot plant at Matheson, Northern Ontario, Canada. (The Northern Miner)

machines for removing asbestos - cement sheets from moulds



Fully automatic machines for removing asbestos-cement flat, straight corrugated and curved corrugated sheets from their moulds.
Oleodinamyc working with fast and exact displacements.
Suckers provided with jointed anchorage for a sure drawing of the sheet.
Possibility of installation combined with the cleaning and lubricating unit.

machines for cleaning and lubricating steel moulds



Fully automatic machines for cleaning, lubricating and storing on the proper carriages the flat or corrugated steel moulds.
Cleaning section provided with rollers having a steel wire covering, and lubricating section with special cloth rollers that assure one regular oiling and low lubricating consumption.

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IMPORTS & EXPORTS

Imports Into U.S.A.

(Published by Bureau of the Census) JANUARY 1965

Unmanufactured Asbestos:	Short Tons
Amosite, Crude, Republic of South Africa	370
Crocidolite (Blue), Crude, Rep. of South Africa	230
Chrysotile, Crude, Canada	50
Republic of South Africa	130
*Zambia, Southern Rhodesia & Malawi	240
Chrysotile Spinning Fibres, Canada	1,060
Other Countries	3
Chrysotile, Other, Canada	43,672
Asbestos, Other, Canada	1,517
United Kingdom	80
*Zambia, Southern Rhodesia & Malawi	25
	47,378

Valued at $4,551,497

Manufactured Asbestos Goods:	Pounds	Value
A-C Pipes, Tubes & Fittings	4,353,639	$193,569
Asbestos-Cement Articles, Other	483,596	47,674
Asbestos Yarn, Rope, etc. & Other	..	12,627
		$253,870

*Zambia (formerly Northern Rhodesia); Malawi (formerly Nyasaland)

Australia—Imports of asbestos for the 3RD QUARTER 1964 amounted to 10,849 short tons (Amosite—1,623; Chrysotile—8,208; Other—1,018). Exports of asbestos for the same period amounted to 1,268 short tons for all types and grades. (Bureau of Mineral Resources)

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Phenolic & Cashew Resins

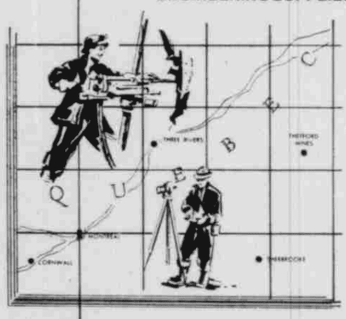
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INDUSTRY NEWS

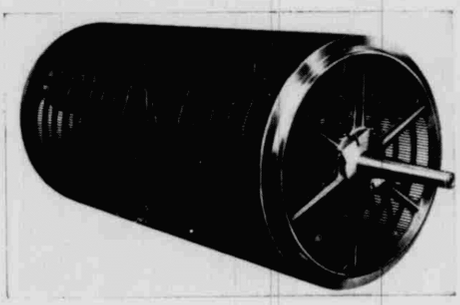
HAPPY BIRTHDAY

Ian C. Spark, Vice President & General Manager, Cape Asbestos (Canada) Limited, Toronto, Ontario, Canada, July 16.
John F. D. Rohrbach, President, Raybestos-Manhattan, Inc., Passaic, New Jersey, July 18.
C. Brown Whitley, President, Scandura, Inc., Charlotte, North Carolina, July 20.
C. J. Backstrand, Chairman, Armstrong Cork Company, Lancaster, Pennsylvania, July 21.
Robert S. King, Chairman, The Philip Carey Manufacturing Company, Cincinnati, Ohio, July 21.
Albert G. Kovacs, Industrial Relations Representative, The Ruberoid Co., New York City, July 21.
Seymour Milstein, Senior Vice President—Corporate Development, The Ruberoid Co., New York City, July 21.
William S. Simpson, Vice President & Secretary, Raybestos-Manhattan, Inc., Bridgeport, Connecticut, July 21.
Roscoe E. Tallman, Director, Tallman McCluskey Fabric Company, Kirkwood, Missouri, July 22.
Mrs. Nina Schwezoff, Vice Managing Director, Putten's Asbestos Organization, Johannesburg, South Africa, July 25.
George C. Anderson, Vice President—Sales, Roofing Granule Division, The Ruberoid Co., New York City, July 29.
Clinton B. Burnett, President, Johns-Manville Corporation, New York City, July 29.
Thomas A. Dent, Vice President—Management Services, The Ruberoid Co., New York City, July 30.
R. B. Williams, First Vice President, Treasurer & Secretary, The Russell Mfg. Co., Middletown, Connecticut, July 31.
C. B. Brown, Turner & Newall (Overseas) Limited, Montreal, Canada, August 1.
Desmond Kirkness, Managing Director, The Universal Asbestos Mfg. Co. Ltd., Tolpits, Watford, England, August 1.
G. P. Reilly, Plant Manager, National Gypsum Company, Millington, New Jersey, August 5.
A. P. Keasbey, Sr., President & General Manager, Robert A. Keasbey Company, New York City, August 6.
R. C. Braun, Secretary-Treasurer, Niagara Asbestos Company, Buffalo, New York, August 8.
Arthur C. Smith, Vice President of Research, Development & Engineering, Johns-Manville Corp., New York City, August 8.
J. M. Dunn, Executive Vice-President, Standco Industries, Inc., Houston, Texas, August 9.
Melvin H. Baker, Honorary Chairman, National Gypsum Company, Buffalo, New York, August 11.
Grant V. Wilson, President, Grant Wilson, Inc., Chicago, Illinois, August 11.

To all these gentlemen we extend congratulations and best wishes on the occasion of their birthdays.

WANDEL-CYLINDER MOULDS

are successfully employed in the ASBESTOS-CEMENT-INDUSTRY all over the world for many years.



We have constantly improved the construction of our Cylinders, thus being able to meet exactly your requirements, even up to the largest dimensions.

The unique feature is the solid construction guaranteeing a long service.

If you would like to learn more about these and other WANDEL products, just drop us a line.

CHR. WANDEL KG

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Asarco—American Smelting and Refining Company has appointed **Allen L. Hatch, Jr.** as Manager of the Ore Department and **James G. Cox** as Assistant Manager of the department.

Asbestos Corporation Limited has appointed **W. W. Oughtred** as Executive Vice-President. He was formerly Vice-President and General Manager.

Canadian Johns-Manville Company Limited has named **M. A. Haddon** as General Sales Manager of the Special Products Unit.

Cape Building Products Limited has appointed **G. E. C. Pease** to the Board effective June 10th, 1965. Cape Building Products is a member of the Cape Asbestos group of companies.

Nicolet—Guy George Gabrielson, Jr., President of Nicolet Industries, Inc., Florham Park, New Jersey, has announced the election by the Board of Directors of **Richard D. Deininger** to the office of Vice President—Manufacturing. Mr. Deininger started with Nicolet in 1946, has held managerial positions at various plants and in 1964 was appointed Operations Manager of the paper mills within Nicolet.

National Gypsum Company—President Fred A. Manske has announced the election by the Board of Directors of **Albert H. Fay** as Vice President of Marketing. In his new position, Mr. Fay will supervise the activities of the following departments: Product Planning, Market Research, Product Management and Advertising and Sales Promotion. He was formerly Director of the Product Management Department for the company.

„ Tropag "

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Canadian Mines Handbook 1965 will be published July 29th, 1965, and available from Northern Miner Press Limited, 116 Richmond Street West, Toronto 1, Canada. This authoritative and up-to-date mines handbook is widely used by bankers, stock brokers, mining executives and others dealing with the mining industry. It contains 350 pages and covers mine locations, ownership, capitalization, financial details, maps with producing areas in color, eight-year range of stock prices, and classification of metal mines. Serviceable paper-covered editions are $4.00 each and deluxe-bound personalized copies are $6.00 each. (Add exchange on out-of-town checks—Ontario sales subject to 3% Provincial Sales Tax.)

1965 Mining Annual Review is now available from Mining Journal, 15 Wilson Street, Moorgate, London E.C.2, England. It offers sections on government and the miner, review of metals and minerals (including asbestos, under Insulants and Refractories), technical progress reports, the world's mining fields, progress of individual companies, professional directory, buyers' guide and index to manufacturers, index to companies, and index to advertisers. This very comprehensive publication is circulated free to all subscribers to Mining Journal and Mining Magazine. To others the price is 27s. 6d. postage paid.

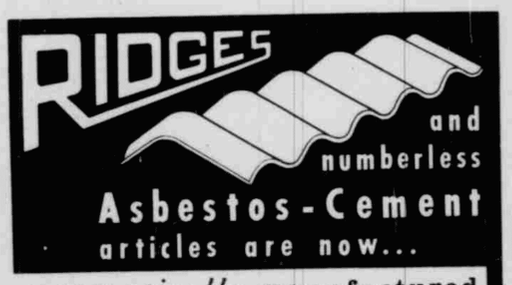
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ARIZONA— Per Ton of 2,000 lbs., f.o.b. Globe, Arizona

(As of July 10, 1964)

No. 1 Crude	$1,410.00 to $1,650.00
No. 2 Crude	610.00 to 900.00
AAA	.. 800.00
Group No. 3 (Non-Ferrous Filtering & Spinning)	425.00 to 750.00
Group No. 4 (Non-Ferrous Plastic & Filtering)	385.00 to 500.00
Group No. 5 (Plastic & Filtering)	250.00 to 400.00
Group No. 7 (Refuse & Shorts)	58.00 to 90.00

CANADA— Per Ton of 2,000 lbs. f.o.b. Mine

(As of January 1, 1965) Canadian Currency

Group No. 1 (Crude No. 1)	$ .. $1,410.00
Group No. 2 (Crude No. 2, Run of the Mine Crude, Sundry Crudes)	640.00 to 875.00
Group No. 3 (Spinning Fibre)	345.00 to 565.00
Group No. 4 (Shingle Fibre)	190.00 to 320.00
Group No. 5 (Paper Fibre)	115.00 to 156.00
Group No. 6 (Waste, Stucco or Plaster)	.. 95.00
Group No. 7 (Refuse or Shorts)	40.00 to 80.00

CASSIAR— Per Ton of 2,000 lbs., f.o.b. Vancouver, B. C.

(As of January 1, 1965) Canadian Currency

AAA grade (non-ferrous spinning fibre)	$ 787.00
AA grade (non-ferrous spinning fibre)	625.00
A grade (non-ferrous spinning—Canadian Group 3)	470.00
AC grade (asbestos cement—Canadian Group 4)	325.00
AD grade (asbestos-cement—Canadian Group 4)	260.00
AK grade (shingle fibre—Canadian Group 4)	220.00
AS grade (shingle fibre—Canadian Group 4)	181.00
AX grade (shingle fibre—Canadian Group 5)	160.00
AY grade (shingle fibre—Canadian Group 5)	120.00

VERMONT— Per Ton of 2,000 lbs., f.o.b. Mine

(As of January 10, 1965) U. S. Dollars

Group No. 3 (Spinning & Filtering)	$ 319.00 to $ 370.00
Group No. 4 (Shingle Fibre)	176.00 to 296.00
Group No. 5 (Paper Fibre)	121.00 to 144.00
Group No. 6 (Waste, Stucco or Plaster)	.. to 88.00
Group No. 7 (Shorts & Floats)	40.50 to 75.00

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British Belting & Asbestos Limited has started to build a small factory near Cleckheaton, England, for the production of materials under license from THE BENDIX CORPORATION of America.

British Belting & Asbestos Limited signed an agreement and finalized arrangements whereby the parent Company granted to ALTA FRICCION S.A. a license for the manufacture in Mexico of B.B.A.-developed woven flexible brake linings, asbestos yarn clutch facings and asbestos yarn.

British Belting & Asbestos Limited—It was decided to expand asbestos production capacity by building a factory at West Auckland, County Durham, England, to house an asbestos yarn manufacturing unit. The demand for the products of B.B.A.'s Asbestos Division in 1964 confirmed this need and building has commenced early this year. The plant is expected to be in operation before the end of the year.

Hazemag/Rose Alloy — Rose Alloy Industrial Corporation, Uniontown, Pennsylvania, has been named manufacturing and service representative with marketing and sales territory in the United States for Hazemag mbH, Munster, Germany. The firm will manufacture, assemble, warehouse and distribute the Hazemag Impact Crusher (Andreas System). The large industrial machine is widely used in mining, quarrying and the steel industry to crush asbestos ore, coal, rock, iron ore, refuse and other materials. This crusher reduces materials by natural cleavage, whereas in conventional crushers, squeezing or shearing is utilized. The impact method consists of breaking by impinging on a steel wall. This enables the Hazemag to provide high reduction ratios. As a result of this contract with Hazemag, the principal product will be made available to a wide range of industrial users in the United States without import from Germany.

GUMMI ASBEST KUNSTSTOFFE

is the asbestos periodical in Europe which covers editorially in each issue the production, processing and application of asbestos. Therefore, it is read by all firms connected with the importing and processing of asbestos in 60 countries and is used for advertising by the asbestos mines all over the world.

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Built on a rock



Crude Asbestos is the rock on which B.B.A. is built. We use it to make everything for which asbestos is best, from yarns and cloths to all types of jointings and packings and the world famous MINTEX friction materials. Our factory leads in production, our Research Laboratories keep us at the head of development. Asbestos is our subject.

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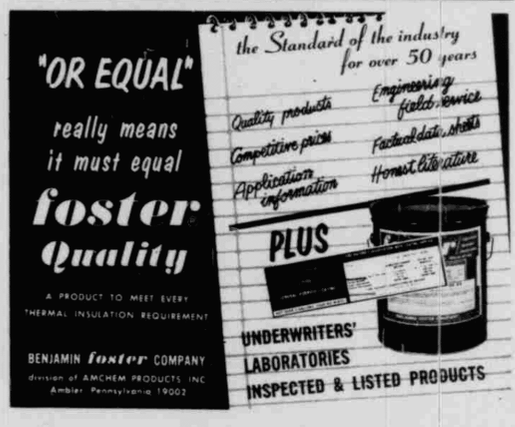
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H. K. Porter—A new warehouse of the Thermoid Division of H. K. Porter Company, Inc. will store all the division's automotive and industrial products including those manufactured by the newly-acquired Russell plant. The official grand opening for the 35,000 square foot building occurred on May 21st, 1965.

Jesse Griffis, Works Manager for the Charlotte and Davidson works of **H. K. Porter Company, Inc.,** has been promoted to Manager, Marketing Development Textiles, with headquarters in Pittsburgh, Pennsylvania. He also will continue to maintain an office and residence in Charlotte, North Carolina. **Peter Gouveia,** formerly assistant works manager, succeeds Mr. Griffis as Works Manager of the Charlotte and Davidson plants. The Thermoid Division of H. K. Porter, as well as its Charlotte and Davidson plants, also has textile operations in Bennettsville, South Carolina and Middletown and Dansville, Connecticut.

B.B.A. Annual Report 1964—Group sales turnover of British Belting & Asbestos Limited for the year ended December 31st, 1964, amounted to £14,998,914, an increase of 13% over 1963. After deducting taxation and minority interests, the net profit attributable to B.B.A. was £949,040 against £792,226 in 1963.



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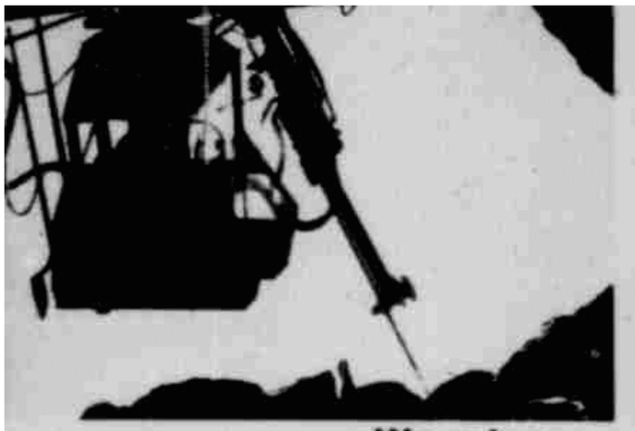
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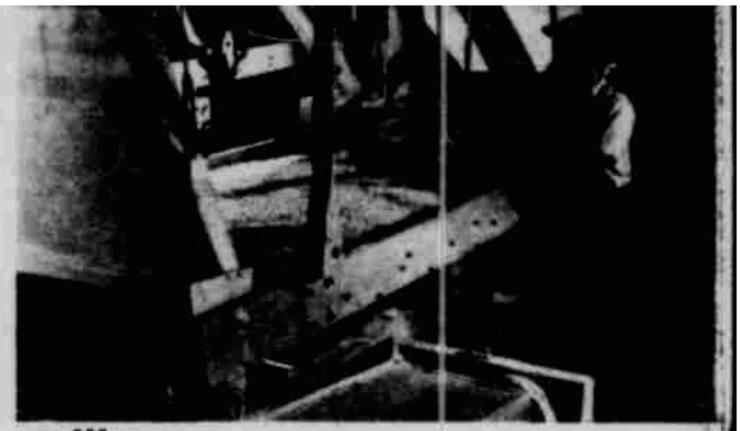
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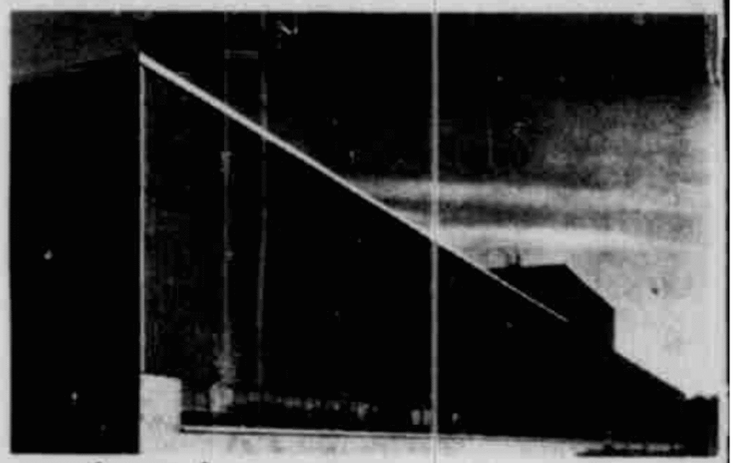
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