Aug. 31, 1948. L. B. MILLER ET AL 2,448,186

HEAT INSULATION

Filed June 29, 1942

Fig. 1

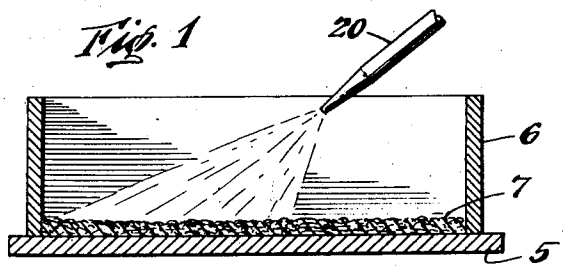


Fig. 2

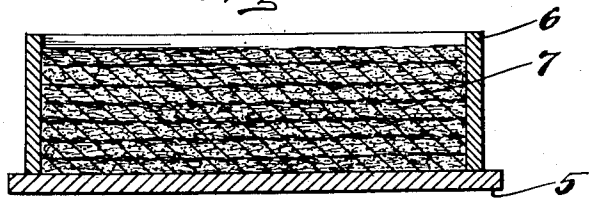


Fig. 3

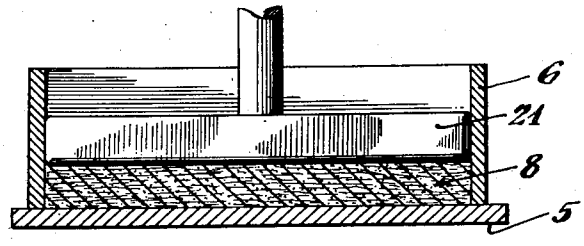
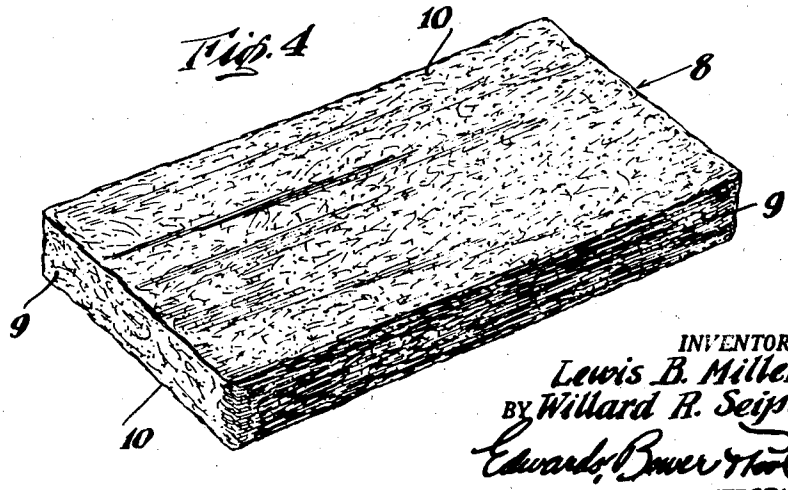


Fig. 4



INVENTORS
Lewis B. Miller
BY Willard R. Seijst
Edwards, Bauer & Hall
ATTORNEYS

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HEAT INSULATION

Lewis B. Miller, Ambler, and Willard R. Seipt, North Wales, Pa., assignors to Keasbey & Mattison Company, Ambler, Pa., a corporation of Pennsylvania

Application June 29, 1942, Serial No. 448,928

6 Claims. (Cl. 154—44)

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This invention relates to heat insulation, and particularly to insulation adapted for use over a wide range of heat conditions and up to relatively high temperatures.

The object of the invention is to provide an insulation which will have low density for the relatively high temperature which it is adapted to withstand.

A further object is to provide an inexpensive, adaptable process for the production of such insulation composed of a combination of fibrous and powdery materials.

In the accompanying drawing

Figs. 1, 2 and 3 are diagrammatic views illustrating one method of producing the insulation, and

Fig. 4 is a perspective view of the insulation in rectangular block form.

The raw materials are composed of fibers, a powdered filling material and a powdered binder. Preferably the fibrous material is asbestos in the form of amosite, this being in proportion of 25–40%. The powdered filler is diatomaceous earth in proportion of 35–45% and the powdered binder is bentonite in proportion of 25–30%, all of the proportions being by relative dry weights.

In the formation of the insulation the raw materials are first proportioned and dry mixed so that the powdery materials are well blended and distributed among the asbestos fibers giving a very open, fluffy structure. This fluffy material is then spread in a thin layer 7 on a base or on a movable support, such as an endless belt or rotary table in case of a continuous process. In Fig. 1 of the drawings the base 5 has a layer 7 of the material within a surrounding rim or retainer 6.

The thin layer 7 of raw materials is then uniformly moistened by a very fine spray of water, it being important merely to moisten the surfaces of the fibrous and powdery particles and not to overwet the mixture at any point. The amount of moisture added is from one and a half to three times the dry weight of the mixture, and preferably this moisture will be held within two to two and a half times the dry weight.

Preferably an air spray nozzle 20 is used to effect the moistening, the water being atomized by an air jet so as to form a cloud or mist penetrating and permeating the layer 7 from surface to surface.

Successive layers 7 are then accumulated on top of each other one by one as indicated in Fig. 2, each layer of the fibrous powdery mixture being dampened down as above described by

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means of an atomized spray, the mixture of materials in dampened form thus being built up to desired depth on the base plate, belt or table.

The accumulated dampened mass of asbestos, diatomaceous earth and bentonite is still in open fluffy form and is now compressed to a thickness and shape corresponding to the desired density and the use to which it is to be put. For instance, as indicated in Fig. 3 with the block insulation, plunger 21 may be used within the rim or retainer 6 to press the layers into more compact form, designated 8, this compacting being variable in amount depending upon the desired density of the final insulation. The result is a rectangular insulating block 8 as illustrated in Fig. 4 with the upper and lower surfaces 10 and the edge surfaces 9. In this block the tendency is for the fibers, particularly the long ones, to run flatwise with the layers; however, in each layer the fibers may run in all directions and may even run from one layer to another, and entangle with the powdery materials, all of the surfaces of the mixture being evenly dampened.

The shaped piece is then dried driving off the moisture and developing the adhesive bond of the bentonite between the particles of diatomaceous earth and between the asbestos fibers and the other materials, the particles of the whole mass being thoroughly cemented together to impart great strength to the block as a whole.

During this drying the bentonite is subjected to a heated moisture-laden atmosphere as the wetting water is vaporized and the bentonite is supplied with moisture from the mixture of fibers and diatomaceous earth, the great surface areas of which adsorb the atomized moisture. If desired, this moisture treatment may be accentuated by steaming the shaped pieces for a few minutes before drying further to develop the binding effect. After drying the shaped and dried pieces are ready for packaging.

By this method insulation which will withstand 1000° to 1200° F. may be made with a density of six to eight pounds per cubic foot and insulation withstanding a temperature of 900° to 1000° F. may be made with a density as low as 3.9 pounds per cubic foot and with sufficient strength for usual service conditions. A light weight high temperature thermal insulation will result when the mixture is compressed under a pressure of about fifty pounds per square inch or less to give a final product weighing eleven pounds per cubic foot and capable of withstanding a temperature of at least 1900° F. and in the neighborhood of

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2200° F. to 2300° F. for the higher pressures and densities.

The density of the final product will depend upon the degree to which the dampened mixture is compressed and this can be very accurately predetermined depending upon the insulating surface to which the product is to be put. A very superior high temperature insulation of great strength and durability is produced at densities from eleven to fifteen pounds per cubic foot. For instance, at the lighter weight of eleven pounds per cubic foot, the hardness is 1.9 by Pusey and Jones test, the linear shrinkage at 1900° F. is 1.05% and the strength is such that the blocks three feet in length may be held horizontally by a grip at one end surface.

At a density of 12.0 the modulus of rupture is 30.0, the Pusey and Jones hardness 1.10 and under the Navy abrasion test the percent loss in ten minutes is 43 and in twenty minutes 67. At 850° F. the modulus of rupture is 17.6 and the linear shrinkage 0.35%; at 1100° F. the modulus of rupture is 14.3 and the linear shrinkage is 0.59%; at 1500° F. the modulus of rupture is 13.7 and the linear shrinkage 1.10%; and at 1900° F. the modulus of rupture is 19.8 and the linear shrinkage is 1.77%, these latter figures being on the basis of a six hour soaking heat, subjecting the whole piece to the temperature indicated. Under normal conditions of usage insulations are subjected to high temperatures only upon one side and any thermal deterioration encountered is therefore in general less in practice than under the conditions of the test.

In conductivity the present insulation is very low being only about 50% of the standard high temperature insulations up to 700° F., and is distinctly superior in the lower ranges of temperature, i. e., below 1000° F. The higher densities and larger proportions of diatomaceous earth render the insulation more effective at higher temperatures and the composition of a corresponding block or other shape may be varied to be denser at the portions adjacent the heated surface. Larger proportions of the diatomaceous earth may also be used at these portions of the insulation by correspondingly varying the composition of the successive layers 7 and variations in density may be effected by subjecting the earlier deposited layers to separate higher compacting pressure so that a plurality of pressures successively lower in intensity are used to produce the block or other shape.

The material in dampened form is relatively plastic and may be pressed to any desired shape and will retain this shape during drying. No pressures are required in the drying operation and the material is self-setting in that the drying operation does not require the shape to be retained in the shaping mold.

The drying shrinkage of the blocks is negligible and they may be cast substantially to the exact size of the finished piece.

This insulation is relatively simple in manufacture and low in cost and widely adaptable to different conditions of use.

The heat insulation of this invention combines mineral fibers, such as asbestos or rock wool with powdery particles, to give a highly porous unit structure withstanding a very high temperature in proportion to the density of the insulating material. It maintains its form under continuous six hours' heating at least to the temperatures as above described. The withstood temperature or the maximum temperature to which the material may be applied without failure is considerably dependent on the composition of the product. The light weight product composed of bentonite and fiber in the ratio of about 30–70 has a density variable ordinarily from about four pounds per cubic foot to eight pounds per cubic foot and will tend to disintegrate beyond usefulness above a temperature of about 900° F. With less fiber and with some diatomaceous earth the density will in general vary from about eight pounds per cubic foot to twelve pounds per cubic foot with distintegration setting in above 1200° F. A third type of composition using still less fiber and more diatomaceous earth (30 parts fiber, 40 parts diatomaceous earth and 30 parts bentonite) will shrink somewhat above 1900° F. and will be used at densities of eleven pounds per cubic foot to sixteen pounds per cubic foot. Thus the maximum temperature is relatively high in relation to the density of the insulation.

In place of the bentonite or in conjunction with it, other binders may be used, such as kaolins or other clays in temperatures up to 1900° F. Silicates may be used in place of the bentonite, but only up to temperatures of about 700° F. while gums and other emulsified or water soluble organic binders may be employed up to about 200–300° F. To give temporary strength at normal air temperatures and facilitate handling before and during application of the insulation, a small percentage of a water soluble gum may be added as an additional binder. Other fiber may also be used in place or together with the amosite such as chrysotile and amphibole asbestos up to 1900° F., rock wool or glass wool up to 1000° F. or organic fibers up to 200° F.

In the formation of these insulations the characteristics are controllable by the proportions of the ingredients and by the compacting pressures employed making the insulation widely adaptable while at the same time maintaining a relatively low density in proportion to the temperatures involved. This represents not only a saving in weight and material over prior insulations but is accompanied by a lower conductivity as above explained.

The process for producing the product of this invention is described and claimed in our copending application Serial No. 534,650, filed May 3, 1944.

We claim:

1. A heat insulating structure formed by a series of layers of similar composition, each layer comprising whole mineral fibers in proportion of the order of 25 to 40% by dry weight and tending to run flatwise of the structure and entangled with evenly distributed separate particles of powdery mineral material and evenly distributed separate powdery particles of a binder material of the group bentonite, clays and silicates of the order of 25 to 30% of the dry weight of the insulation and set in place adhering to the fibers and to the powdery material and to each other by surface contact between the individual fibers and individual particles leaving intervening voids to provide an open highly porous structure having a low density of the order of 8 to 15 lbs. per cu. ft. and capable of withstanding for at least six hours a temperature in degrees F. which is over 100 times the weight of a cu. ft. of the insulation.

2. A heat insulating structure as set forth in claim 1 in which successive layers of the structure vary in density and correspondingly vary in heat resistance.

3. A heat insulating structure as set forth in

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claim 1 in which successive layers vary in the proportion of powdery material and correspondingly vary in heat resistance.

4. A heat insulating structure comprising whole mineral fibers in proportion of the order of 70% by dry weight and tending to run flatwise of the structure and entangled with evenly distributed separate powdery particles of a binder of the group bentonite, clays and silicates set in place adhering to the fibers and to each other by surface contact between the individual fibers and particles and leaving intervening voids to provide an open highly porous structure having a low density of the order of 4 lbs. per cu. ft. and capable of withstanding for at least six hours a temperature in degrees F. which is over 200 times the weight of a cu. ft. of the insulation.

5. A heat insulating structure composed of 25–30% of a bonding material of the group bentonite, clays and silicates and the remainder noncementitious mineral particles including whole mineral fibers forming at least 25% of the entire composition, the bonding material being in the form of powdery particles intermixed and entangled and evenly distributed among the noncementitious particles and bonded thereto by surface contact between the individual particles of the bonding material and the individual noncementitious particles to provide an open highly porous structure having a low density of the order of 4–15 pounds per cubic foot and capable of withstanding for at least six hours a temperature in degrees F. which is over 100 times the weight of a cubic foot of the insulation.

6. A heat insulating structure as set forth in claim 5 in which the noncementitious mineral material is composed of asbestos and diatomaceous earth.

LEWIS B. MILLER.
WILLARD R. SEIPT.

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