

THE STATE OF SOUTH CAROLINA
In The Court of Appeals

APPEAL FROM SPARTANBURG COUNTY
Court of Common Pleas

Jean H. Toal, Circuit Court Judge

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SC Court of Appeals

Appellate Case No. 2017-002611
Case No. 2016-CP-42-1592

Beverly Dale Jolly and Brenda Rice Jolly, ... Respondents,

v.

General Electric Company, et al., ... Defendants,

Of whom Fisher Controls International LLC and Crosby
Valve, LLC are the Appellants.

RECORD ON APPEAL
VOLUME IX

C. Mitchell Brown
A. Mattison Bogan
James B. Glenn
Nicholas A. Charles
NELSON MULLINS RILEY &
SCARBOROUGH LLP
1320 Main Street / 17th Floor
Post Office Box 11070 (29211-1070)
Columbia, SC 29201
(803) 799-2000

Attorneys for Appellants Fisher Controls
International LLC and Crosby Valve
LLC

Theile B. McVey, Esq.
John D. Kassel, Esq.
KASSEL McVEY ATTORNEYS AT
LAW
Post Office Box 1476
1330 Laurel Street (29201)
Columbia, SC 29201

Jonathan M. Holder, Esq.
Lisa White Shirley, Esq. (*Pro Hac
Vice*)
DEAN OMAR BRANHAM, LLP
302 North Market Street, Suite 300
Dallas, TX 75202
jholder@dobllp.com

Attorneys for Respondents

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Additional Fractional/Decimal Inch—Millimeter Equivalents

INCHES			INCHES			INCHES		
Frac-tions	Decimals	MILLI-METERS	Frac-tions	Decimals	MILLI-METERS	Frac-tions	Decimals	MILLI-METERS
1/64	.00394	.1	13/64	.2	5.08	29/64	.44	11.176
	.00787	.2		.203125	5.1594		.45	11.430
	.01	.254		.21	5.334		.453125	11.5094
	.01181	.3		.21875	5.5562		.46	11.684
	.015625	.3969		.22	5.688		.46875	11.9062
	.01575	.4	15/64	.23	5.842	31/64	.47	11.938
	.01969	.5		.234375	5.9531		.47244	12.0
	.02	.508		.23622	6.0		.48	12.192
	.02362	.6		.24	6.096		.484375	12.3031
	.02756	.7		.25	6.35		.49	12.446
1/32	.03	.762	17/64	.26	6.604	1/2	.50	12.7
	.03125	.7938		.265625	6.7469		.51	12.954
	.0315	.8		.27	6.858		.51181	13.0
	.03543	.9		.27559	7.0		.515625	13.0969
	.03937	1.0		.28	7.112		.52	13.208
3/64	.04	1.016	9/32	.28125	7.1438	17/32	.53	13.462
	.046875	1.1906		.29	7.366		.53125	13.4938
	.05	1.27		.296875	7.5406		.54	13.716
	.06	1.524		.30	7.62		.546875	13.8906
	.0625	1.5875		.31	7.874		.55	13.970
5/64	.07	1.778	5/16	.3125	7.9375	9/16	.55118	14.0
	.078125	1.9844		.31496	8.0		.56	14.224
	.07874	2.0		.32	8.128		.5625	14.2875
	.08	2.032		.328125	8.3344		.57	14.478
	.09	2.286		.33	8.382		.578125	14.6844
3/32	.09375	2.3812	11/32	.34	8.636	19/32	.58	14.732
	.1	2.54		.34375	8.7312		.59	14.986
	.109375	2.7781		.35	8.89		.59055	15.0
	.11	2.794		.35433	9.0		.59375	15.0812
	.11811	3.0		.359375	9.1281		.60	15.24
7/64	.12	3.048	3/8	.36	9.144	5/8	.609375	15.4781
	.125	3.175		.37	9.398		.61	15.494
	.13	3.302		.375	9.525		.62	15.748
	.14	3.556		.38	9.652		.625	15.875
	.140625	3.5719		.39	9.906		.62992	16.0
5/32	.15	3.810	25/64	.390625	9.9219	41/64	.63	16.002
	.15625	3.9688		.39370	10.0		.64	16.256
	.15748	4.0		.40	10.16		.640625	16.2719
	.16	4.064		.40625	10.3188		.65	16.510
	.17	4.318		.41	10.414		.65625	16.6688
11/64	.171875	4.3656	27/64	.42	10.668	21/32	.66	16.764
	.18	4.572		.421875	10.7156		.66929	17.0
	.1875	4.7625		.43	10.922		.67	17.018
	.19	4.826		.43307	11.0		.671875	17.0656
	.19685	5.0		.4375	11.1125		.68	17.272

- Continued -

Additional Fractional/Decimal Inch—Millimeter Equivalents (Continued)

INCHES			INCHES			INCHES		
Frac-tions	Decimals	MILLI-METERS	Frac-tions	Decimals	MILLI-METERS	Frac-tions	Decimals	MILLI-METERS
11/16	.8875	17.4625	51/64	.796875	20.2408		.90551	23.0
	.89	17.526		.80	20.320	29/32	.90625	23.0188
	.70	17.78		.81	20.574		.91	23.114
45/64	.703125	17.8594	13/16	.8125	20.6375		.92	23.368
	.70866	18.0		.82	20.828	59/64	.921875	23.4166
	.71	18.034		.82877	21.0		.93	23.622
23/32	.71875	18.2562	53/64	.828125	21.0344	15/16	.9375	23.8125
	.72	18.288		.83	21.082		.94	23.876
	.73	18.542		.84	21.336		.94488	24.0
47/64	.734375	18.6531	27/32	.84375	21.4312		.95	24.130
	.74	18.796		.85	21.590	61/64	.953125	24.2094
	.74803	19.0	55/64	.859375	21.8281		.96	24.384
3/4	.75	19.050		.86	21.844	31/32	.96875	24.6082
	.76	19.304		.86614	22.0		.97	24.638
49/64	.765625	19.4469		.87	22.098		.98	24.892
	.77	19.558	7/8	.875	22.225		.98425	25.0
	.78	19.812		.88	22.352	63/64	.984375	25.0031
25/32	.78125	19.8438		.89	22.606		.99	25.146
	.78740	20.0	57/64	.890625	22.6219	1	1.00000	25.4000
	.79	20.066		.90	22.860			

Note: Round off decimal points to provide no more than the desired degree of accuracy.

Area Equivalents

Multiply by Number of	To Obtain				
	Square Meters	Square Inches	Square Feet	Square Miles	Square Kilometers
Square Meters	1	1549.99	10.7639	3.861×10^{-7}	1×10^{-6}
Square Inches	0.0006452	1	6.944×10^{-3}	2.491×10^{-10}	6.452×10^{-10}
Square Feet	0.0929	144	1	3.587×10^{-8}	9.29×10^{-8}
Square Miles	2,589,999	...	27,878,400	1	2.59
Square Kilometers	1,000,000	...	10,763,867	0.3861	1

1 square meter = 10,000 square centimeters.
1 square millimeter = 0.01 square centimeter = 0.00155 square inches.

Volume Equivalents

To Obtain by Multiply Number of	Cubic Decimeters (Liters)	Cubic Inches	Cubic Feet	U.S. Quart	U.S. Gallon	Imperial Gallon	U.S. Barrel (Petro- leum)
Cubic Decimeters (Liters)	1	61.0234	0.03531	1.05668	0.264178	0.220083	0.00629
Cubic Inches	0.01639	1	5.787×10^{-4}	0.01732	0.004329	0.003606	0.000103
Cubic Feet	28.317	1728	1	29.9221	7.48055	6.22888	0.1781
U.S. Quart	0.94636	57.75	0.03342	1	0.25	0.2082	0.00595
U.S. Gallon	3.78543	231	0.13368	4	1	0.833	0.02381
Imperial Gallon	4.54374	277.274	0.16054	4.80128	1.20032	1	0.02877
U.S. Barrel (Petroleum)	158.98	9702	5.6146	168	42	34.973	1

1 cubic meter = 1,000,000 cubic centimeters.
1 liter = 1000 milliliters = 1000 cubic centimeters.

Volume Rate Equivalents

To Obtain by Multiply Number of	Liters Per Minute	Cubic Meters Per Hour	Cubic Feet Per Hour	Liters Per Hour	U.S. Gallon Per Minute	U.S. Barrel Per Day
Liters Minute	1	0.06	2.1189	60	0.264178	9.057
Cubic Meters Per Hour	16.667	1	35.314	1000	4.403	151
Cubic Feet Per Hour	0.4719	0.028317	1	28.317	0.1247	4.2746
Liters Per Hour	0.016667	0.001	0.035314	1	0.004403	0.151
U.S. Gallon Per Minute	3.785	0.2273	8.0208	227.3	1	34.28
U.S. Barrel Per Day	0.1104	0.006624	0.23394	6.624	0.02917	1

Pressure Equivalents

To Obtain by Multiply Number of	Kg. Per Sq. Cm.	Lb. Per Sq. In.	Atm.	Bar	In. of Hg.	Kilopascals	In. of Water	Ft. of Water
Kg. Per Sq. Cm.	1	14.22	0.9678	0.98067	28.96	98.067	394.06	32.84
Lb. Per Sq. In.	0.07031	1	0.06804	0.06895	2.036	6.895	27.7	2.309
Atm.	1.0332	14.696	1	1.01325	29.92	101.325	407.14	33.93
Bar	1.01972	14.5038	0.98692	1	29.53	100	402.156	33.513
In. of Hg.	0.03453	0.4912	0.03342	0.033864	1	3.3864	13.61	1.134
Kilopascals	0.0101972	0.145038	0.0098696	0.01	0.2953	1	4.02156	0.33513
In. of Water	0.002538	0.0361	0.002456	0.00249	0.07349	0.249	1	0.0833
Ft. of Water	0.03046	0.4332	0.02947	0.029839	0.8819	2.9839	12	1

1 ounce/sq. inch = 0.0625 lbs./sq. inch.

Mass Conversion—Pounds to Kilograms
(1 pound = 0.4536 kilogram)

Pounds	0	1	2	3	4	5	6	7	8	9
	Kilograms									
0	0.00	0.45	0.91	1.36	1.81	2.27	2.72	3.18	3.63	4.08
10	4.54	4.99	5.44	5.90	6.35	6.80	7.26	7.71	8.16	8.62
20	9.07	9.53	9.98	10.43	10.89	11.34	11.79	12.25	12.70	13.15
30	13.61	14.06	14.52	14.97	15.42	15.88	16.33	16.78	17.24	17.69
40	18.14	18.60	19.05	19.50	19.96	20.41	20.87	21.32	21.77	22.23
50	22.68	23.13	23.59	24.04	24.49	24.95	25.40	25.86	26.31	26.76
60	27.22	27.67	28.12	28.58	29.03	29.48	29.94	30.39	30.84	31.30
70	31.75	32.21	32.66	33.11	33.57	34.02	34.47	34.93	35.38	35.83
80	36.29	36.74	37.20	37.65	38.10	38.56	39.01	39.46	39.92	40.37
90	40.82	41.28	41.73	42.18	42.64	43.09	43.55	44.00	44.45	44.91

Pressure Conversion—Pounds per Square Inch to Bar*

Pounds Per Square Inch	0	1	2	3	4	5	6	7	8	9
	Bar									
0	0.000000	0.068948	0.137895	0.206843	0.275790	0.344738	0.413685	0.482633	0.551581	0.620528
10	0.689476	0.758423	0.827371	0.896318	0.965266	1.034214	1.103161	1.172109	1.241056	1.310004
20	1.378951	1.447899	1.516847	1.585794	1.654742	1.723689	1.792637	1.861584	1.930532	1.999480
30	2.068427	2.137375	2.206322	2.275270	2.344217	2.413165	2.482113	2.551060	2.620008	2.688955
40	2.757903	2.826850	2.895798	2.964746	3.033693	3.102641	3.171588	3.240536	3.309484	3.378431
50	3.447379	3.516326	3.585274	3.654221	3.723169	3.792117	3.861064	3.930012	3.998959	4.067907
60	4.136854	4.205802	4.274750	4.343697	4.412645	4.481592	4.550540	4.619487	4.688435	4.757383
70	4.826330	4.895278	4.964225	5.033173	5.102120	5.171068	5.240016	5.308963	5.377911	5.446858
80	5.515806	5.584753	5.653701	5.722649	5.791598	5.860544	5.929491	5.998439	6.067386	6.136334
90	6.205282	6.274229	6.343177	6.412124	6.481072	6.550019	6.618967	6.687915	6.756862	6.825810
100	6.894757	6.963705	7.032652	7.101600	7.170548	7.239495	7.308443	7.377390	7.446338	7.515286

*To convert to kilopascals, move decimal point two positions to right; to convert to Megapascals, move decimal point one position to left. For example, 30 psi = 2.068427 bar = 206.8427 kPa = 0.2068427 MPa.

Note: Round off decimal points to provide no more than the desired degree of accuracy.

Temperature Conversion Tables**Temperature Conversion Formulas**

To Convert From	To	Substitute in Formula
Degrees Celsius	Degrees Fahrenheit	$(^{\circ}\text{C} \times 9/5) + 32$
Degrees Celsius	Kelvin	$(^{\circ}\text{C} + 273.16)$
Degrees Fahrenheit	Degrees Celsius	$(^{\circ}\text{F} - 32) \times 5/9$
Degrees Fahrenheit	Degrees Rankin	$(^{\circ}\text{F} + 459.69)$

Temperature Conversions

$^{\circ}\text{C}$	Temp. in $^{\circ}\text{C}$ or $^{\circ}\text{F}$ to be Con- verted	$^{\circ}\text{F}$	$^{\circ}\text{C}$	Temp. in $^{\circ}\text{C}$ or $^{\circ}\text{F}$ to be Con- verted	$^{\circ}\text{F}$	$^{\circ}\text{C}$	Temp. in $^{\circ}\text{C}$ or $^{\circ}\text{F}$ to be Con- verted	$^{\circ}\text{F}$
-273.16	-459.69		-90.00	-130	-202.0	-17.8	0	32.0
-267.78	-450		-84.44	-120	-184.0	-18.7	2	35.6
-262.22	-440		-78.89	-110	-166.0	-15.6	4	39.2
-256.67	-430		-73.33	-100	-148.0	-14.4	6	42.8
-251.11	-420		-70.56	-95	-139.0	-13.3	8	48.4
-245.56	-410		-67.78	-90	-130.0	-12.2	10	50.0
-240.00	-400		-65.00	-85	-121.0	-11.1	12	53.6
-234.44	-390		-62.22	-80	-112.0	-10.0	14	57.2
-228.89	-380		-59.45	-75	-103.0	-8.89	16	60.8
-223.33	-370		-56.67	-70	-94.0	-7.78	18	64.4
-217.78	-360		-53.89	-65	-85.0	-6.67	20	68.0
-212.22	-350		-51.11	-60	-76.0	-5.56	22	71.6
-206.67	-340		-48.34	-55	-67.0	-4.44	24	75.2
-201.11	-330		-45.56	-50	-58.0	-3.33	26	78.8
-195.56	-320		-42.78	-45	-49.0	-2.22	28	82.4
-190.00	-310		-40.00	-40	-40.0	-1.11	30	86.0
-184.44	-300		-38.89	-38	-36.4	0	32	89.6
-178.89	-290		-37.78	-36	-32.8	1.11	34	93.2
-173.33	-280		-36.67	-34	-29.2	2.22	36	96.8
-169.53	-273.16	-459.69	-35.56	-32	-25.6	3.33	38	100.4
-168.89	-272	-457.6	-34.44	-30	-22.0	4.44	40	104.0
-167.78	-270	-454.0	-33.33	-28	-18.4	5.56	42	107.6
-162.22	-260	-436.0	-32.22	-26	-14.8	6.67	44	111.2
-156.67	-250	-418.0	-31.11	-24	-11.2	7.78	46	114.8
-151.11	-240	-400.0	-30.00	-22	-7.6	8.89	48	118.4
-145.56	-230	-382.0	-28.89	-20	-4.0	10.0	50	122.0
-140.00	-220	-364.0	-27.78	-18	-0.4	11.1	52	125.6
-134.44	-210	-346.0	-26.67	-16	3.2	12.2	54	129.2
-128.89	-200	-328.0	-25.56	-14	6.8	13.3	56	132.8
-123.33	-190	-310.0	-24.44	-12	10.4	14.4	58	136.4
-117.78	-180	-292.0	-23.33	-10	14.0	15.6	60	140.0
-112.22	-170	-274.0	-22.22	-8	17.6	16.7	62	143.6
-106.67	-160	-256.0	-21.11	-6	21.2	17.8	64	147.2
-101.11	-150	-238.0	-20.00	-4	24.8	18.9	66	150.8
-95.56	-140	-220.0	-18.89	-2	28.4	20.0	68	154.4

- Continued -

Temperature Conversions (Continued)

°C	Temp. in °C or °F to be Con- verted	°F	°C	Temp. in °C or °F to be Con- verted	°F	°C	Temp. in °C or °F to be Con- verted	°F
21.1	70	158.0	204.4	400	752.0	454.4	860	1562.0
22.2	72	161.6	210.0	410	770.0	460.0	860	1580.0
23.3	74	165.2	215.6	420	788.0	465.6	870	1598.0
24.4	76	168.8	221.1	430	806.0	471.1	880	1616.0
25.6	78	172.4	226.7	440	824.0	476.7	890	1634.0
26.7	80	176.0	232.2	450	842.0	482.2	900	1652.0
27.8	82	179.6	237.8	460	860.0	487.8	910	1670.0
28.9	84	183.2	243.3	470	878.0	493.3	920	1688.0
30.0	86	186.8	248.9	480	896.0	498.9	930	1706.0
31.1	88	190.4	254.4	490	914.0	504.4	940	1724.0
32.2	90	194.0	260.0	500	932.0	510.0	950	1742.0
33.3	92	197.6	265.6	510	950.0	515.6	960	1760.0
34.4	94	201.2	271.1	520	968.0	521.1	970	1778.0
35.6	96	204.8	276.7	530	986.0	526.7	980	1796.0
36.7	98	208.4	282.2	540	1004.0	532.2	990	1814.0
37.8	100	212.0	287.8	550	1022.0	537.8	1000	1832.0
43.3	110	230.0	293.3	560	1040.0	543.3	1010	1850.0
48.9	120	248.0	298.9	570	1058.0	548.9	1020	1868.0
54.4	130	266.0	304.4	580	1076.0	554.4	1030	1886.0
60.0	140	284.0	310.0	590	1094.0	560.0	1040	1904.0
65.6	150	302.0	315.6	600	1112.0	565.6	1050	1922.0
71.1	160	320.0	321.1	610	1130.0	571.1	1060	1940.0
76.7	170	338.0	326.7	620	1148.0	576.7	1070	1958.0
82.2	180	356.0	332.2	630	1166.0	582.2	1080	1976.0
87.8	190	374.0	337.8	640	1184.0	587.8	1090	1994.0
93.3	200	392.0	343.3	650	1202.0	593.3	1100	2012.0
98.9	210	410.0	348.9	660	1220.0	598.9	1110	2030.0
104.4	220	428.0	354.4	670	1238.0	604.4	1120	2048.0
110.0	230	446.0	360.0	680	1256.0	610.0	1130	2066.0
115.6	240	464.0	365.6	690	1274.0	615.6	1140	2084.0
121.1	250	482.0	371.1	700	1292.0	621.1	1150	2102.0
126.7	260	500.0	376.7	710	1310.0	626.7	1160	2120.0
132.2	270	518.0	382.2	720	1328.0	632.2	1170	2138.0
137.8	280	536.0	387.8	730	1346.0	637.8	1180	2156.0
143.3	290	554.0	393.3	740	1364.0	643.3	1190	2174.0
148.9	300	572.0	398.9	750	1382.0	648.9	1200	2192.0
154.4	310	590.0	404.4	760	1400.0	654.4	1210	2210.0
160.0	320	608.0	410.0	770	1418.0	660.0	1220	2228.0
165.6	330	626.0	415.6	780	1436.0	665.6	1230	2246.0
171.1	340	644.0	421.1	790	1454.0	671.1	1240	2264.0
176.7	350	662.0	426.7	800	1472.0	676.7	1250	2282.0
182.2	360	680.0	432.2	810	1490.0	682.2	1260	2300.0
187.8	370	698.0	437.8	820	1508.0	687.8	1270	2318.0
193.3	380	716.0	443.3	830	1526.0	693.3	1280	2336.0
198.9	390	734.0	448.9	840	1544.0	698.9	1290	2354.0

- Continued -

Temperature Conversions (Continued)

°C	Temp. in °C or °F to be Con- verted	°F	°C	Temp. in °C or °F to be Con- verted	°F	°C	Temp. in °C or °F to be Con- verted	°F
704.4	1300	2372.0	760.0	1400	2552.0	815.6	1500	2732.0
710.0	1310	2390.0	765.6	1410	2570.0			
715.6	1320	2408.0	771.1	1420	2588.0			
721.1	1330	2426.0	776.7	1430	2606.0			
726.7	1340	2444.0	782.2	1440	2624.0			
732.2	1350	2462.0	787.0	1450	2642.0			
737.8	1360	2480.0	793.3	1460	2660.0			
743.3	1370	2498.0	798.9	1470	2678.0			
748.9	1380	2516.0	804.4	1480	2696.0			
754.4	1390	2634.0	810.0	1490	2714.0			

A.P.I. and Baumé Gravity Tables and Weight Factors

A.P.I. Gravity	Baumé Gravity	Specific Gravity	Lb/ U.S. Gal	U.S. Gal/ Lb	A.P.I. Gravity	Baumé Gravity	Specific Gravity	Lb/ U.S. Gal	U.S. Gal/ Lb
0	10.247	1.0760	8.962	0.1116	31	30.78	0.8708	7.251	0.1379
1	9.223	1.0679	8.895	0.1124	32	31.77	0.8654	7.208	0.1388
2	8.198	1.0699	8.828	0.1133	33	32.76	0.8602	7.163	0.1396
3	7.173	1.0620	8.762	0.1141	34	33.75	0.8550	7.119	0.1405
4	6.148	1.0443	8.698	0.1150	35	34.73	0.8498	7.076	0.1413
5	5.124	1.0366	8.634	0.1158	36	35.72	0.8448	7.034	0.1422
6	4.099	1.0291	8.571	0.1167	37	36.71	0.8398	6.993	0.1430
7	3.074	1.0217	8.509	0.1175	38	37.70	0.8348	6.951	0.1439
8	2.049	1.0143	8.448	0.1184	39	38.69	0.8299	6.910	0.1447
9	1.025	1.0071	8.388	0.1192	40	39.68	0.8251	6.870	0.1456
10	10.00	1.0000	8.328	0.1201	41	40.67	0.8203	6.830	0.1464
11	10.99	0.9930	8.270	0.1209	42	41.66	0.8155	6.790	0.1473
12	11.98	0.9861	8.212	0.1218	43	42.65	0.8109	6.752	0.1481
13	12.97	0.9792	8.155	0.1226	44	43.64	0.8063	6.713	0.1490
14	13.96	0.9725	8.099	0.1235	45	44.63	0.8017	6.675	0.1498
15	14.95	0.9659	8.044	0.1243	46	45.62	0.7972	6.637	0.1507
16	15.94	0.9593	7.989	0.1252	47	46.61	0.7927	6.600	0.1515
17	16.93	0.9529	7.935	0.1260	48	47.60	0.7883	6.563	0.1524
18	17.92	0.9465	7.882	0.1269	49	48.59	0.7839	6.526	0.1532
19	18.90	0.9402	7.830	0.1277	50	49.58	0.7796	6.490	0.1541
20	19.89	0.9340	7.778	0.1286	51	50.57	0.7753	6.455	0.1549
21	20.88	0.9279	7.727	0.1294	52	51.55	0.7711	6.420	0.1558
22	21.87	0.9218	7.676	0.1303	53	52.54	0.7669	6.385	0.1566
23	22.86	0.9159	7.627	0.1311	54	53.53	0.7628	6.350	0.1575
24	23.85	0.9100	7.578	0.1320	55	54.52	0.7587	6.316	0.1583
25	24.84	0.9042	7.529	0.1328	56	55.51	0.7547	6.283	0.1592
26	25.83	0.8984	7.481	0.1337	57	56.50	0.7507	6.249	0.1600
27	26.82	0.8927	7.434	0.1345	58	57.49	0.7467	6.216	0.1609
28	27.81	0.8871	7.387	0.1354	59	58.48	0.7428	6.184	0.1617
29	28.80	0.8816	7.341	0.1362	60	59.47	0.7389	6.151	0.1626
30	29.79	0.8762	7.296	0.1371					

- Continued -

A.P.I. and Baumé Gravity Tables and Weight Factors (Continued)

A.P.I. Gravity	Baumé Gravity	Specific Gravity	Lb/ U.S. Gal	U.S. Gal/ Lb	A.P.I. Gravity	Baumé Gravity	Specific Gravity	Lb/ U.S. Gal	U.S. Gal/ Lb
61	60.46	0.7351	6.119	0.1634	81	80.25	0.6659	5.542	0.1804
62	61.46	0.7313	6.087	0.1643	82	81.24	0.6628	5.516	0.1813
63	62.44	0.7275	6.056	0.1651	83	82.23	0.6597	5.491	0.1821
64	63.43	0.7238	6.025	0.1660	84	83.22	0.6566	5.465	0.1830
65	64.42	0.7201	6.994	0.1668	85	84.20	0.6536	5.440	0.1838
66	65.41	0.7165	5.964	0.1677	86	85.19	0.6506	5.415	0.1847
67	66.40	0.7128	5.934	0.1685	87	86.18	0.6476	5.390	0.1855
68	67.39	0.7093	5.904	0.1694	88	87.17	0.6446	5.365	0.1864
69	68.37	0.7057	5.874	0.1702	89	88.16	0.6417	5.341	0.1872
70	69.36	0.7022	5.845	0.1711	90	89.15	0.6388	5.316	0.1881
71	70.35	0.6988	5.817	0.1719	91	90.14	0.6360	5.293	0.1889
72	71.34	0.6953	5.788	0.1728	92	91.13	0.6331	5.269	0.1898
73	72.33	0.6919	5.759	0.1736	93	92.12	0.6303	5.246	0.1906
74	73.32	0.6886	5.731	0.1745	94	93.11	0.6275	5.222	0.1915
75	74.31	0.6852	5.703	0.1753	95	94.10	0.6247	5.199	0.1924
76	75.30	0.6819	5.676	0.1762	96	95.09	0.6220	5.176	0.1932
77	76.29	0.6787	5.649	0.1770	97	96.08	0.6193	5.154	0.1940
78	77.28	0.6754	5.622	0.1779	98	97.07	0.6166	5.131	0.1949
79	78.27	0.6722	5.595	0.1787	99	98.06	0.6139	5.109	0.1957
80	79.26	0.6690	5.568	0.1796	100	99.05	0.6112	5.086	0.1966

The relation of Degrees Baumé or A.P.I. to Specific Gravity is expressed by the following formulas:

For liquids lighter than water:

$$\text{Degrees Baumé} = \frac{140}{G} - 130, \quad G = \frac{140}{130 + \text{Degrees Baumé}}$$

$$\text{Degrees A.P.I.} = \frac{141.5}{G} - 131.5, \quad G = \frac{141.5}{131.5 + \text{Degrees A.P.I.}}$$

For liquids heavier than water:

$$\text{Degrees Baumé} = 145 - \frac{145}{G}, \quad G = \frac{145}{145 - \text{Degrees Baumé}}$$

G = Specific Gravity = ratio of the weight of a given volume of oil at 60° Fahrenheit to the weight of the same volume of water at 60° Fahrenheit.

The above tables are based on the weight of 1 gallon (U.S.) of oil with a volume of 231 cubic inches at 60° Fahrenheit in air at 760 mm pressure and 50% humidity. Assumed weight of 1 gallon of water at 60° Fahrenheit in air is 8.32828 pounds.

To determine the resulting gravity by mixing oils of different gravities:

$$D = \frac{md_1 + nd_2}{m + n}$$

D = Density or Specific Gravity of mixture

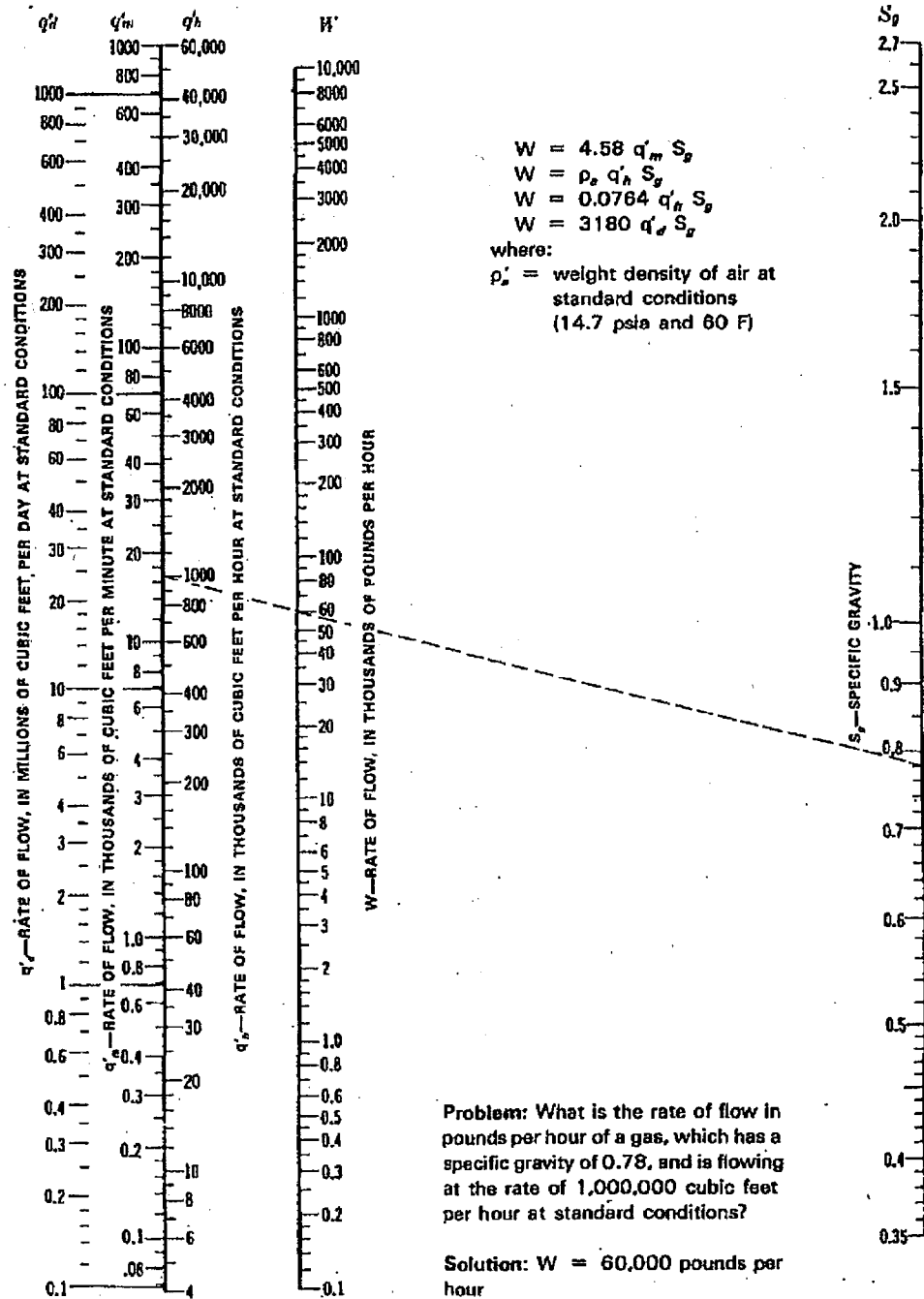
m = Proportion of oil of d_1 density

n = Proportion of oil of d_2 density

d_1 = Specific Gravity of m oil

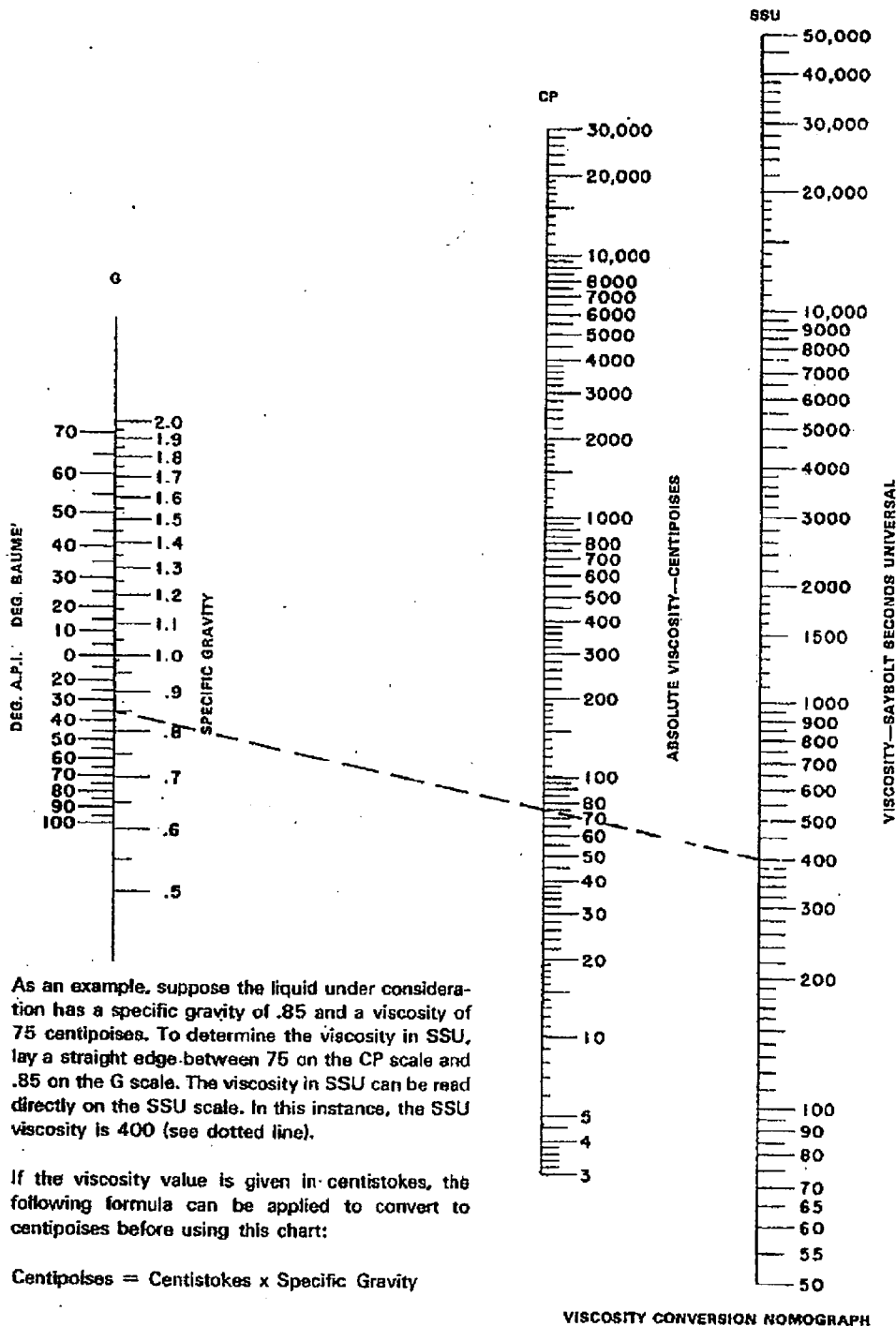
d_2 = Specific Gravity of n oil

Equivalent Volume and Weight Flow Rates of Compressible Fluids



Extracted from Technical Paper No. 410, *Flow of Fluids*, with permission of Crane Co.

Viscosity Conversion Nomograph



VISCOSITY CONVERSION NOMOGRAPH

Other Useful Conversions

To Convert From	To	Multiply By
Cu Ft (Methane)	B.T.U.	1000 (approx.)
Cu Ft of Water	Lbs of Water	62.4
Degrees	Radians	0.01745
Gals	Lbs of Water	8.336
Grams	Ounces	0.0352
Horsepower (mech.)	Ft Lbs per Min	33,000
Horsepower (elec.)	Watts	746
Kg	Lbs	2.205
Kg per Cu Meter	Lbs per Cu Ft	0.06243
Kilowatts	Horsepower	1.341
Lbs	Kg	0.4536
Lbs of Air (14.7 psia and 60°F)	Cu Ft of Air	13.1
Lbs per Cu Ft	Kg per Cu Meter	16.0184
Lbs per Hr (Gas)	Std Cu Ft per Hr	13.1
Lbs per Hr (Water)	Gals per Min	Specific Gravity 0.002
Lbs per Sec (Gas)	Std Cu Ft per Hr	46.160 Specific Gravity
Radians	Degrees	57.3
Scfh Air	Scfh Propane	0.81
Scfh Air	Scfh Butane	0.71
Scfh Air	Scfh 0.6 Natural Gas	1.29
Scfh	Cu Meters per Hr	0.028317

Section 7

Engineering Data

Characteristics of the Elements

Element	Symbol	Atomic Number	Mass Number*	Melting Point (°C)	Boiling Point (°C)
actinium	Ac	89	(227)	1600†	
aluminum	Al	13	27	659.7	2057
americium	Am	95	(243)		
antimony	Sb	51	121	630.5	1380
(stibium)					
argon	Ar	18	40	-189.2	-185.7
arsenic	As	33	75	sublimes at 615	
astatine	At	85	(210)		
barium	Ba	56	138	850	1140
berkelium	Bk	97	(247)		
beryllium	Be	4	9	1278±5	2970
bismuth	Bi	83	209	271.3	1560±5
boron	B	5	11	2300	2550
bromine	Br	35	79	-7.2	58.78
cadmium	Cd	48	114	320.9	767±2
calcium	Ca	20	40	842±8	1240
californium	Cf	98	(249)		
carbon	C	6	12	>3550	4200
cerium	Ce	58	140	804	1400
cesium	Cs	55	133	28.5	670
chlorine	Cl	17	35	-103±5	-34.6
chromium	Cr	24	52	1890	2480
cobalt	Co	27	59	1495	2800
copper	Cu	29	63	1083	2336
curium	Cm	96	(248)		
dysprosium	Dy	66	164		
* Mass number shown is that of the stable isotope most common in nature. Mass numbers shown in parentheses designate the isotope with the longest half-life (slowest rate of radio-active decay) for those elements having no stable isotope. † Calculated. > Greater than.					

- Continued -

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ROA_03439

Characteristics of the Elements (Continued)

Element	Symbol	Atomic Number	Mass Number*	Melting Point (°C)	Boiling Point (°C)
einsteinium	Es	99	(254)		
erbium	Er	68	166		
europium	Eu	63	153	1150±50	
fermium	Fm	100	(252)		
fluorine	F	9	19	-223	-188
francium	Fr	87	(223)		
gadolinium	Gd	64	158		
gallium	Ga	31	69	29.78	1983
germanium	Ge	32	74	958.6	2700
gold	Au	79	197	1083	2600
hafnium	Hf	72	180	1700†	>3200
helium	He	2	4	-272	-268.9
holmium	Ho	67	165		
hydrogen	H	1	1	-258.14	-252.8
indium	In	49	115	156.4	2000±10
iodine	I	53	127	113.7	184.35
iridium	Ir	77	193	2454	>4800
iron	Fe	26	56	1535	3000
krypton	Kr	36	84	-166.6	-152.9
lanthanum	La	57	139	828	
lawrencium	Lw	103	(257)		
lead	Pb	82	208	327.43	1620
lithium	Li	3	7	186	1336±5
lutetium	Lu	71	175		
magnesium	Mg	12	24	651	1107
manganese	Mn	25	55	1260	1900
mendeleevium	Mv	101	(256)		
mercury	Hg	80	202	-38.87	356.58
molybdenum	Mo	42	98	2620±10	4800
neodymium	Nd	60	142	840	
neon	Ne	10	20	-248.67	-245.9
neptunium	Np	93	(237)		
nickel	Ni	28	58	1455	2900
niobium	Nb	41	93	2500±50	3700
nitrogen	N	7	14	-209.86	-195.8
nobelium	No	102	(253)		
osmium	Os	76	192	2700	>5300
oxygen	O	8	16	-218.4	-182.86
palladium	Pd	46	106	1549.4	2000
phosphorus	P	15	31		
platinum	Pt	78	195	1773.5	4300
plutonium	Pu	94	(242)		
polonium	Po	84	(209)		
potassium	K	19	39	63.3	760
praseodymium	Pr	59	141	940	
promethium	Pm	61	(145)		
protactinium	Pa	91	(231)		
radium	Ra	88	(226)	700	1140
radon	Rn	86	(222)	-71	-61.8
rhenium	Re	75	187	3167±60	

* Mass number shown is that of the stable isotope most common in nature. Mass numbers shown in parentheses designate the isotope with the longest half-life (slowest rate of radio-active decay) for those elements having no stable isotope.
† Calculated.
> Greater than.

- Continued -

Characteristics of the Elements (Continued)

Element	Symbol	Atomic Number	Mass Number*	Melting Point (°C)	Boiling Point (°C)
rhodium	Rh	45	103	1968±3	>2500
rubidium	Rb	37	85	38.5	700
ruthenium	Ru	44	102	2460	2700
samarium	Sm	62	152	>1300	
scandium	Sc	21	45	1200	2400
selenium	Se	34	80	217	688
silicon	Si	14	28	1420	2355
silver	Ag	47	107	960.8	1950
sodium	Na	11	23	97.5	880
strontium	Sr	38	88	800	1150
sulfur	S	16	32		
tantalum	Ta	73	180	2996±50	c.4100
technetium	Tc	43	(99)		
tellurium	Te	52	130	452	1390
terbium	Tb	65	159	327±5	
thallium	Tl	81	205	302	1457±10
thorium	Th	90	232	1845	4500
thulium	Tm	69	169		
tin	Sn	50	120	231.89	2270
titanium	Ti	22	48	1800	>3000
tungsten (wolfram)	W	74	184	3370	5900
uranium	U	92	238	c.1133	
vanadium	V	23	51	1710	3000
xenon	Xe	54	132	-112	-107.1
ytterbium	Yb	70	174	1800	
yttrium	Y	39	89	1490	2500
zinc	Zn	30	64	419.47	907
zirconium	Zr	40	90	1867	>2900

* Mass number shown is that of the stable isotope most common in nature. Mass numbers shown in parentheses designate the isotope with the longest half-life (slowest rate of radio-active decay) for those elements having no stable isotope.
† Calculated.
> Greater than.

Recommended Standard Specifications for Valve Materials**Pressure-Containing Castings**

① Carbon Steel ASTM A216 Grade WCB Temp. range = -20°F to 1000°F Composition (Percent) C 0.30 max Mn 1.00 max P 0.05 max S 0.06 max Si 0.60 max	③ Chrome Moly Steel ASTM A217 Grade C5 Temp. range = -20°F to 1100°F Composition (Percent) C 0.20 max Mn 0.40 to 0.70 P 0.05 max S 0.06 max Si 0.75 max Cr 4.00 to 6.50 Mo 0.45 to 0.65
② Carbon Steel ASTM A352 Grade LCB Temp. range = -50°F to 650°F Composition: Same as ASTM A216 Grade WCB	

Recommended Standard Specifications for Valve Materials
Pressure-Containing Castings
(Continued)

4 Carbon Moly Steel
ASTM A217 Grade WC1

Temp. range = -20°F to 850°F
 Composition (Percent)
 C 0.25 max
 Mn 0.50 to 0.80
 P 0.05 max
 S 0.06 max
 Si 0.60 max
 Mo 0.45 to 0.66

5 Chrome Moly Steel
ASTM A217 Grade WC6

Temp. range = -20°F to 1000°F
 Composition (Percent)
 C 0.20 max
 Mn 0.50 to 0.80
 P 0.05 max
 S 0.06 max
 Si 0.60 max
 Cr 1.00 to 1.50
 Mo 0.45 to 0.65

6 Chrome Moly Steel
ASTM A217 Grade WC9

Temp. range = -20°F to 1050°F
 Composition (Percent)
 C 0.18 max
 Mn 0.40 to 0.70
 P 0.05 max
 Si 0.60 max
 Cr 2.00 to 2.75
 Mo 0.90 to 1.20

7 3-1/2% Nickel Steel
ASTM A352 Grade LC3

Temp. range = -150°F to 650°F
 Composition (Percent)
 C 0.15 max
 Mn 0.50 to 0.80
 P 0.05 max
 S 0.05 max
 Si 0.60 max
 Ni 3.00 to 4.00

8 Chrome Moly Steel
ASTM A217 Grade C12

Temp. range = -20°F to 1100°F
 Composition (Percent)
 C 0.20 max
 Si 1.00 max
 Mn 0.35 to 0.65
 Cr 8.00 to 10.00
 Mo 0.90 to 1.20
 P 0.05 max
 S 0.06 max

9 Type 304 Stainless Steel
ASTM A351 Grade CF-8

Temp. range = -425°F to 1500°F
 Composition (Percent)
 C 0.08 max
 Mn 1.50 max
 Si 2.00 max
 S 0.04 max
 P 0.04 max
 Cr 18.00 to 21.00
 Ni 8.00 to 11.00

10 Type 316 Stainless Steel
ASTM A351 Grade CF-8M

Temp. range = -425°F to 1500°F
 Composition (Percent)
 C 0.08 max
 Mn 1.50 max
 Si 2.00 max
 P 0.04 max
 S 0.04 max
 Cr 18.00 to 21.00
 Ni 9.00 to 12.00
 Mo 2.00 to 3.00

11 Cast Iron
ASTM A126 Class B

Temp. range = -150°F to 450°F
 Composition (Percent)
 P 0.75 max
 S 0.12 max

12 Cast Iron
ASTM A126 Class C

Temp. range = -150°F to 450°F
 Composition (Percent)
 P 0.75 max
 S 0.12 max

Recommended Standard Specifications for Valve Materials
Pressure-Containing Castings
(Continued)

MAT'L CODE	MINIMUM PHYSICAL PROPERTIES				MODULUS OF ELASTICITY AT 70°F (PSI x 10 ⁶)	APPROX. BRINELL HARDNESS
	Tensile (Psi)	Yield Point (Psi)	Elong. in 2" (%)	Reduction of Area (%)		
①	70,000	36,000	22	35	27.9	137-187
②	65,000	35,000	24	35	27.9	137-187
③	90,000	80,000	18	35	27.4	241 Max.
④	65,000	35,000	24	35	29.9	215 Max.
⑤	70,000	40,000	20	35	28.9	215 Max.
⑥	70,000	40,000	20	35	29.9	241 Max.
⑦	65,000	40,000	24	35	27.9	137
⑧	90,000	80,000	18	35	27.4	180-240
⑨	65,000	28,000	35	...	28.0	140
⑩	70,000	30,000	30	...	28.3	156-170
⑪	31,000	...	...	...	...	160-220
⑫	41,000	...	...	...	...	160-220
⑬	60,000	45,000	15	...	23-26	143-207
⑭	68,000	30,000	7	...	...	148-211
⑮	30,000	14,000	20	17	13.5	55-65*
⑯	40,000	18,000	20	20	15	75-85*
⑰	65,000	25,000	20	20	15.4	98*
⑱	75,000	30,000	12 min.	12	17	150
⑲	65,000	32,500	25	...	23	120-170
⑳	72,000	46,000	6	...	...	...
㉑	72,000	46,000	4	...	...	...
㉒	121,000	64,000	1-2	...	30.4	...

*500 kg load.

⑬ Ductile Iron
ASTM A395 Type 60-45-15

Temp. range = -20°F to 650°F

Composition (Percent)

C 3.00 min

Si 2.75 max

P 0.08 max

⑭ Ductile Ni-Resist* Iron
ASTM A439 Type D-2B

Temp. range = -20°F to 750°F

Composition (Percent)

C 3.00 max

Si 1.50 to 3.00

Mn 0.70 to 1.25

P 0.08 max

Ni 18.00 to 22.00

Cr 2.75 to 4.00

*Trademark of International Nickel Co.

⑮ Standard Valve Bronze
ASTM B62

Temp. range = -325°F to 450°F

Composition (Percent)

Cu 84.00 to 86.00

Sn 4.00 to 6.00

Pb 4.00 to 6.00

Zn 4.00 to 6.00

Ni 1.00 max

Fe 0.30 max

P 0.05 max

Recommended Standard Specifications for Valve Materials
Pressure-Containing Castings
(Continued)

(16) Tin Bronze
ASTM B143 Alloy 1A

Temp. range = -325°F to 400°F
 Composition (Percent)
 Cu 86.00 to 89.00
 Sn 9.00 to 11.00
 Pb 0.30 max
 Zn 1.00 to 3.00
 Ni 1.00 max
 Fe 0.15 max
 P 0.05 max

(17) Manganese Bronze
ASTM B147 Alloy 8A

Temp. range = -325°F to 350°F
 Composition (Percent)
 Cu 55.00 to 60.00
 Sn 1.00 max
 Pb 0.40 max
 Ni 0.50 max
 Fe 0.40 to 2.00
 Al 0.50 to 1.50
 Mn 1.50 max
 Zn Remainder

(18) Aluminum Bronze
ASTM B148 Alloy 9C

Temp. range = -325°F to 500°F
 Composition (Percent)
 Cu 83.00 min
 Al 10.00 to 11.50
 Fe 3.00 to 5.00
 Mn 0.50
 Ni 2.50 max
 Min. total named elements = 99.5

(19) Monel* Alloy 411
(Weldable Grade)

Temp. range = -325°F to 900°F
 Composition (Percent)
 Ni 60.00 min
 Cu 26.00 to 33.00
 C 0.30 max
 Mn 1.50 max
 Fe 3.50 max
 S 0.015 max
 Si 1.00 to 2.00
 Nb 1.00 to 3.00

(20) Nickel-Moly Alloy "B"
ASTM A494 (Hastelloy "B"†)

Temp. range = -325°F to 700°F
 Composition (Percent)
 Cr 1.00 max
 Fe 4.00 to 6.00
 C 0.12 max
 Si 1.00 max
 Co 2.50 max
 Mn 1.00 max
 V 0.20 to 0.60
 Mo 26.00 to 30.00
 P 0.04 max
 S 0.03 max
 Ni Remainder

(21) Nickel-Moly-Chrome Alloy "C"
ASTM A494 (Hastelloy "C"†)

Temp. range = -325°F to 1000°F
 Composition (Percent)
 Cr 15.50 to 17.50
 Fe 4.50 to 7.50
 W 3.75 to 5.25
 C 0.12 max
 Si 1.00 max
 Co 2.50 max
 Mn 1.00 max
 V 0.20 to 0.40
 Mo 16.00 to 18.00
 P 0.04
 S 0.03
 Ni Remainder

(22) Cobalt-base Alloy No. 6
Stellite No. 6

Composition (Percent)
 C 0.90 to 1.40
 Mn 1.00
 W 3.00 to 6.00
 Ni 3.00
 Cr 26.00 to 32.00
 Mo 1.00
 Fe 3.00
 Si 0.40 to 2.00
 Co Remainder

*Trademark of International Nickel Co.
 †Trademark of Stellite Div., Cabot Corp.

Bar Stock Materials

Frequently Used for Trim Parts of Valves

- (23) Aluminum Bar
ASTM B211 Alloy 2011-T3

Composition (Percent)

Si 0.40 max
Fe 0.70 max
Cu 5.00 to 6.00
Zn 0.30 max
Bi 0.20 to 0.60
Pb 0.20 to 0.60
Other Elements 0.15 max
Al Remainder

- (24) Yellow Brass Bar
ASTM B16 1/2 Hard

Composition (Percent)

Cu 60.00 to 63.00
Pb 2.50 to 3.70
Fe 0.35 max
Zn Remainder

- (25) Naval Brass Bar
ASTM B21 Alloy 464

Composition (Percent)

Cu 59.00 to 62.00
Sn 0.50 to 1.00
Pb 0.20 max
Zn Remainder

- (26) Lead Steel Bar
AISI 12L14

Composition (Percent)

C 0.15 max
Mn 0.80 to 1.20
P 0.04 to 0.09
S 0.25 to 0.35
Pb 0.15 to 0.35

- (27) Carbon Steel Bar
ASTM A108 Grade 1018

Composition (Percent)

C 0.15 to 0.20
Mn 0.60 to 0.90
P 0.04 max
S 0.05 max

- (28) AISI 4140 Chrome-Moly Steel
(Suitable for ASTM A193
Grade B7 bolt material)

Composition (Percent)

C 0.38 to 0.43
Mn 0.75 to 1.00
P 0.035 max
S 0.040 max
Si 0.20 to 0.35
Cr 0.80 to 1.10
Mo 0.15 to 0.25
Fe Remainder

- (29) Type 302 Stainless Steel
ASTM A276 Type 302

Composition (Percent)

C 0.15 max
Mn 2.00 max
P 0.045 max
S 0.030 max
Si 1.00 max
Cr 17.00 to 19.00
Ni 8.00 to 10.00

- (30) Type 304 Stainless Steel
ASTM A276 Type 304

Composition (Percent)

C 0.08 max
Mn 2.00 max
P 0.045 max
S 0.030 max
Si 1.00 max
Cr 18.00 to 20.00
Ni 8.00 to 12.00

- (31) Type 316 Stainless Steel
ASTM A276 Type 316

Composition (Percent)

C 0.08 max
Mn 2.00 max
P 0.045 max
S 0.030 max
Si 1.00 max
Cr 16.00 to 18.00
Ni 10.00 to 14.00
Mo 2.00 to 3.00

Bar Stock Material (Continued) Frequently Used for Trim Parts of Valves

③② Type 316L Stainless Steel ASTM A276 Type 316L

Composition (Percent)

C 0.03 max
Mn 2.00 max
P 0.045 max
S 0.030 max
Si 1.00 max
Cr 16.00 to 18.00
Ni 10.00 to 14.00
Mo 2.00 to 3.00

③③ Type 410 Stainless Steel ASTM A276 Type 410

Composition (Percent)

C 0.15 max
Mn 1.00 max
P 0.040 max
S 0.030 max
Si 1.00 max
Cr 11.50 to 13.50
Al 0.10 to 0.30

③④ Type 17-4PH Stainless Steel ASTM A461 Grade 630

Composition (Percent)

C 0.07 max
Mn 1.00 max
Si 1.00 max
P 0.04 max
S 0.03 max
Cr 15.50 to 17.50
Nb 0.05 to 0.45
Cu 3.00 to 5.00
Ni 3.00 to 5.00
Fe Remainder

③⑤ Nickel-Copper Alloy Bar Alloy K500 (K Monel*)

Composition (Percent)

Ni 63.00 to 70.00
Fe 2.00 max
Mn 1.50 max
Si 1.00 max
C 0.25 max
S 0.01 max
Al 2.00 to 4.00
Ti 0.25 to 1.00
Cu Remainder

③⑥ Nickel-Moly Alloy "B" Bar ASTM B335 (Hastelloy "B"†)

Composition (Percent)

Cr 1.00 max
Fe 4.00 to 6.00
C 0.05 max
Si 1.00 max
Co 2.50 max
Mn 1.00 max
V 0.20 to 0.40
Mo 26.00 to 30.00
P 0.025 max
S 0.030 max
Ni Remainder

③⑦ Nickel-Moly-Chrome Alloy "C" Bar ASTM B336 (Hastelloy "C"†)

Composition (Percent)

Cr 14.50 to 16.50
Fe 4.00 to 7.00
W 3.00 to 4.50
C 0.08 max
Si 1.00 max
Co 2.50 max
Mn 1.00 max
Va 0.35 max
Mo 15.00 to 17.00
P 0.04
S 0.03
Ni Remainder

*Trademark of International Nickel Co.
†Trademark of Stellite Div., Cabot Corp.

MAT'L CODE	MINIMUM PHYSICAL PROPERTIES				MODULUS OF ELASTICITY AT 70°F (PSI x 10 ⁶)	APPROX. BRINELL HARDNESS
	Tensile (Psi)	Yield Point (Psi)	Elong. in 2" (%)	Reduction of Area (%)		
23	44,000	36,000	15	...	10.2	95
24	45,000	15,000	7	50	14	...
25	60,000	27,000	22	55	...	...
26	79,000	71,000	16	52	...	163
27	69,000	48,000	38	62	...	143
28	135,000	115,000	22	63	28.9	255
29	85,000	35,000	60	70	28	150
30	85,000	35,000	60	70	...	149
31	80,000	30,000	60	70	28	149
32	81,000	34,000	55	...	...	146
33	75,000	40,000	35	70	29	155
34	135,000	105,000	18	50	29	275-345
35	100,000	70,000	35	...	26	175-280
36	100,000	46,000	30	...	...	...
37	100,000	46,000	20	...	...	...

Physical Constants of Hydrocarbons

NO.	COMPOUND	FORMULA	MOLECULAR WEIGHT	BOILING POINT AT 14.696 psia (°F)	VAPOR PRESSURE AT 100° F (psia)	FREEZING POINT AT 14.696 psia (°F)	CRITICAL CONSTANTS		SPECIFIC GRAVITY at 14.696 psia	
							Critical Temperature (°F)	Critical Pressure (psia)	Liquid, ²⁴ 60° F/60° F	Gas at 60° F (Air = 1) ¹
1	Methane	CH ₄	16.043	-258.68	(5000) ²	-296.48 ⁶	-116.63	667.8	0.3 ⁶	0.5539
2	Ethane	C ₂ H ₆	30.070	-127.48	(800) ²	-297.89 ⁵	90.09	707.8	0.3664 ⁷	1.0382
3	Propane	C ₃ H ₈	44.097	-43.67	190.	-305.84 ⁶	206.01	616.3	0.5077 ⁷	1.5225
4	n-Butane	C ₄ H ₁₀	58.124	31.10	51.6	-217.05	305.65	550.7	0.5844 ⁷	2.0068
5	Isobutane	C ₄ H ₁₀	58.124	10.90	72.2	-255.29	274.98	529.1	0.5631 ⁷	2.0068
6	n-Pentane	C ₅ H ₁₂	72.151	96.92	15.570	-201.51	385.7	488.6	0.6310	2.4911
7	Isopentane	C ₅ H ₁₂	72.151	82.12	20.44	-255.83	369.10	490.4	0.6247	2.4911
8	Neopentane	C ₅ H ₁₂	72.151	49.10	35.9	2.17	321.13	464.0	0.5967 ⁷	2.4911
9	n-Hexane	C ₆ H ₁₄	86.178	156.72	4.956	-139.58	453.7	436.9	0.6640	2.9753
10	2-Methylpentane	C ₆ H ₁₄	86.178	140.47	6.767	-244.63	435.83	436.6	0.6579	2.9753
11	3-Methylpentane	C ₆ H ₁₄	86.178	145.89	6.098	...	448.3	453.1	0.6689	2.9753
12	Neohexane	C ₆ H ₁₄	86.178	121.52	9.856	-147.72	420.13	446.8	0.6540	2.9753
13	2,3-Dimethylbutane	C ₆ H ₁₄	86.178	136.36	7.404	-199.38	440.29	453.5	0.6664	2.9753
14	n-Heptane	C ₇ H ₁₆	100.205	209.17	1.620	-131.05	512.8	396.8	0.6882	3.4596
15	2-Methylhexane	C ₇ H ₁₆	100.205	194.09	2.271	-180.89	495.00	396.5	0.6830	3.4596
16	3-Methylhexane	C ₇ H ₁₆	100.205	197.32	2.130	...	503.78	408.1	0.6917	3.4596
17	3-Ethylpentane	C ₇ H ₁₆	100.205	200.25	2.012	-181.48	513.48	419.3	0.7028	3.4596
18	2,2-Dimethylpentane	C ₇ H ₁₆	100.205	174.54	3.492	-190.86	477.23	402.2	0.6782	3.4596
19	2,4-Dimethylpentane	C ₇ H ₁₆	100.205	176.89	3.292	-182.63	475.95	396.9	0.6773	3.4596
20	3,3-Dimethylpentane	C ₇ H ₁₆	100.205	186.91	2.773	-210.01	505.86	427.2	0.6976	3.4596
21	Triptane	C ₇ H ₁₆	100.205	177.58	3.374	-12.82	496.44	428.4	0.6946	3.4596

- Continued -

22	n-Octane	C_8H_{18}	114.232	258.22	0.637	-70.18	564.22	360.6	0.7068	3.9439
23	Diisobutyl	C_8H_{18}	114.232	228.39	1.101	-132.07	530.44	360.6	0.6979	3.9439
24	Isooctane	C_8H_{18}	114.232	210.63	1.708	-161.27	519.46	372.4	0.6962	3.9439
25	n-Nonane	C_9H_{20}	128.259	303.47	0.179	-64.28	610.68	332.	0.7217	4.4282
26	n-Decane	$C_{10}H_{22}$	142.288	345.48	0.0597	-21.36	652.1	304.	0.7342	4.9125
27	Cyclopentane	C_5H_{10}	70.135	120.65	9.914	-136.91	461.5	653.8	0.7504	2.4215
28	Methylcyclopentane	C_6H_{12}	84.162	161.25	4.503	-224.44	499.35	548.9	0.7536	2.9057
29	Cyclohexane	C_6H_{12}	84.162	177.29	3.264	43.77	636.7	591.	0.7834	2.9057
30	Methylcyclohexane	C_7H_{14}	98.189	213.68	1.609	-195.87	570.27	503.5	0.7740	3.3900
31	Ethylene	C_2H_4	28.054	-154.62	...	-272.45 ⁶	48.58	729.8	...	0.9686
32	Propane	C_3H_8	42.081	-53.90	226.4	-301.45 ⁶	196.9	669.	0.5220 ⁷	1.4529
33	1-Butene	C_4H_8	56.108	20.75	63.05	-301.63 ⁶	295.6	583.	0.6013 ⁷	1.9372
34	Cis-2-Butene	C_4H_8	56.108	38.69	45.54	-218.06	324.37	610.	0.6271 ⁷	1.9372
35	Trans-2-Butene	C_4H_8	56.108	33.58	49.80	-157.96	311.86	595.	0.6100 ⁷	1.9372
36	Isobutene	C_4H_8	56.108	19.59	63.40	-220.61	292.55	580.	0.6004 ⁷	1.9372
37	1-Pentene	C_5H_{10}	70.135	85.93	19.115	-265.39	376.93	590.	0.6457	2.4215
38	1,2-Butadiene	C_4H_6	54.092	51.53	(20.) ⁸	-213.16	(339.) ⁹	(653.) ⁹	0.658 ⁷	1.8676
39	1,3-Butadiene	C_4H_6	54.092	24.06	(80.) ⁸	-164.02	306.	628.	0.6272 ⁷	1.8676
40	Isoprene	C_5H_8	68.119	93.30	16.672	-230.74	(412.) ⁹	(558.4) ⁹	0.6861	2.3519
41	Acetylene	C_2H_2	26.038	-119. ⁵	...	-114. ⁵	95.31	890.4	0.615 ⁹	0.8990
42	Benzene	C_6H_6	78.114	176.17	3.224	41.96	552.22	710.4	0.8844	2.6969
43	Toluene	C_7H_8	92.141	231.13	1.032	-138.94	805.55	595.9	0.8718	3.1812
44	Ethylbenzene	C_8H_{10}	106.168	277.16	0.371	-138.91	651.24	523.5	0.8718	3.6655
45	o-Xylene	C_8H_{10}	106.168	291.97	0.264	-13.30	675.0	541.4	0.8848	3.6655
46	m-Xylene	C_8H_{10}	106.168	282.41	0.326	-54.12	651.02	513.6	0.8687	3.6655
47	p-Xylene	C_8H_{10}	106.168	281.05	0.342	55.86	649.6	509.2	0.8657	3.6655
48	Styrene	C_8H_8	104.152	293.29	(0.24) ⁸	-23.10	706.0	580.	0.9110	3.5959
49	Isopropylbenzene	C_9H_{12}	120.195	306.34	0.188	-140.82	676.4	465.4	0.8663	4.1498

1. Calculated values.
2. () - Estimated values.
3. Air saturated hydrocarbons.
4. Absolute values from weights in vacuum.
5. At saturation pressure (triple point).

6. Sublimation point.
7. Saturation pressure and 80°F.
8. Apparent value for methane at 80°F.
9. Specific gravity, 118°F/60°F (sublimation point).

Physical Constants of Various Fluids

FLUID	FORMULA	MOLECULAR WEIGHT	BOILING POINT (°F AT 14.696 PSIA)	VAPOR PRESSURE @ 70°F (PSIG)	CRITICAL TEMP. (°F)	CRITICAL PRESSURE (PSIA)	SPECIFIC GRAVITY	
							Liquid 60/60°F	Gas
Acetic Acid	HC ₂ H ₃ O ₂	60.05	245				1.05	
Acetone	C ₃ H ₆ O	58.08	133		455	681	0.79	2.01
Air	N ₂ O ₂	28.97	-317		-221	547	0.86±	1.0
Alcohol, Ethyl	C ₂ H ₅ O	46.07	173	2.3†	470	925	0.794	1.59
Alcohol, Methyl	CH ₃ O	32.04	148	4.63†	463	1174	0.796	1.11
Ammonia	NH ₃	17.03	-28	114	270	1636	0.82	0.69
Ammonium Chloride*	NH ₄ Cl						1.07	
Ammonium Hydroxide*	NH ₄ OH						0.91	
Ammonium Sulfate*	(NH ₄) ₂ SO ₄						1.15	
Aniline	C ₆ H ₇ N	93.12	365		798	770	1.02	
Argon	A	39.94	-302		-188	705	1.85	1.38
Beer							1.01	
Bromine	Br ₂	159.84	138		575		2.93	5.52
Calcium Chloride*	CaCl ₂						1.23	
Carbon Dioxide	CO ₂	44.01	-109	839	88	1072	0.801±	1.52
Carbon Disulfide	CS ₂	76.1	115				1.29	2.63
Carbon Monoxide	CO	28.01	-314		-220	507	0.80	0.97
Carbon Tetrachloride	CCl ₄	153.84	170		542	681	1.59	5.31
Chlorine	Cl ₂	70.91	-30	85	291	1119	1.42	2.45
Chromic Acid	H ₂ CrO ₄	118.03					1.21	
Citric Acid	C ₆ H ₈ O ₇	192.12					1.54	
Copper Sulfate*	CuSO ₄						1.17	

- Continued -

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Ether	$(C_2H_5)_2O$	74.12	34				0.74	2.65
Ferric Chloride*	$FeCl_3$						1.23	
Fluorine	F_2	38.00	-305	300	-200	809	1.11	1.31
Formaldehyde	H_2CO	30.03	-6				0.82	1.08
Formic Acid	HCO_2H	46.03	214				1.23	
Furfural	$C_5H_4O_2$	96.08	324				1.16	
Glycerine	$C_3H_8O_3$	92.08	554				1.26	
Glycol	$C_2H_6O_2$	62.07	387				1.11	
Helium	He	4.003	-454		-450	33	0.18	0.14
Hydrochloric Acid	HCl	36.47	-115				1.64	
Hydrofluoric Acid	HF	20.01	66	0.9	446		0.92	
Hydrogen	H_2	2.016	-422		-400	188	0.07†	0.07
Hydrogen Chloride	HCl	36.47	-115	613	125	1198	0.86	1.26
Hydrogen Sulfide	H_2S	34.07	-78	252	213	1307	0.79	1.17
Isopropyl Alcohol	C_3H_8O	60.09	180				0.78	2.08
Linseed Oil			538				0.93	
Magnesium Chloride*	$MgCl_2$						1.22	
Mercury	Hg	200.61	670				13.6	6.93
Methyl Bromide	CH_3Br	94.96	38	13	376		1.73	3.27
Methyl Chloride	CH_3Cl	50.49	-11	59	290	969	0.99	1.74
Naphthalene	$C_{10}H_8$	128.16	424				1.14	4.43
Nitric Acid	HNO_3	63.02	187				1.5	
Nitrogen	N_2	28.02	-320		-233	493	0.81†	0.97
Oil, Vegetable							0.91 - 0.94	
Oxygen	O_2	32	-297		-181	737	1.14†	1.105

*Aqueous Solution - 25% by weight of compound.
†Vapor pressure in psia at 100°F.

‡Density of liquid, gm/ml at normal boiling point.

- Continued -

Physical Constants of Various Fluids (Continued)

FLUID	FORMULA	MOLECULAR WEIGHT	BOILING POINT (°F AT 14.696 PSIA)	VAPOR PRESSURE @ 70°F (PSIG)	CRITICAL TEMP. (°F)	CRITICAL PRESSURE (PSIA)	SPECIFIC GRAVITY	
							Liquid 60/60°F	Gas
Phosgene	COCl_2	98.92	47	10.7	360	823	1.39	3.42
Phosphoric Acid	H_3PO_4	98.00	415				1.83	
Potassium Carbonate*	K_2CO_3						1.24	
Potassium Chloride*	KCl						1.16	
Potassium Hydroxide*	KOH						1.24	
Refrigerant 11	CCl_3F	137.38	75	13.4	388	635		5.04
Refrigerant 12	CCl_2F_2	120.93	-22	70.2	234	597		4.2
Refrigerant 13	CClF_3	104.47	-115	458.7	84	561		
Refrigerant 21	CHCl_2F	102.93	48	8.4	353	750		3.82
Refrigerant 22	CHClF_2	86.48	-41	122.5	205	716		
Refrigerant 23	CHF_3	70.02	-119	635	91	691		
Sodium Chloride*	NaCl						1.19	
Sodium Hydroxide*	NaOH						1.27	
Sodium Sulfate*	Na_2SO_4						1.24	
Sodium Thiosulfate*	$\text{Na}_2\text{S}_2\text{O}_3$						1.23	
Starch	$(\text{C}_6\text{H}_{10}\text{O}_5)_x$						1.50	
Sugar Solutions*	$\text{C}_{12}\text{H}_{22}\text{O}_{11}$						1.10	
Sulfuric Acid	H_2SO_4	98.08	626				1.83	
Sulfur Dioxide	SO_2	64.6	14	34.4	316	1145	1.39	2.21
Turpentine			320				0.87	
Water	H_2O	18.016	212	0.9492†	706	3208	1.00	0.62
Zinc Chloride*	ZnCl_2						1.24	
Zinc Sulfate*	ZnSO_4						1.31	

*Aqueous Solution - 25% by weight of compound.

†Vapor pressure in psia at 100°F.

Properties of Water

Temperature of Water (°F)	Saturation Pressure (Pounds Per Square Inch Absolute)	Weight (Pounds Per Gallon)	Specific Gravity 60/60 F	Conversion Factor, * lbs./hr. to GPM
32	.0885	8.345	1.0013	.00199
40	.1217	8.345	1.0013	.00199
50	.1781	8.340	1.0007	.00199
60	.2653	8.334	1.0000	.00199
70	.3631	8.325	.9989	.00200
80	.5069	8.314	.9976	.00200
90	.6982	8.303	.9963	.00200
100	.9492	8.289	.9946	.00201
110	1.2748	8.267	.9919	.00201
120	1.6924	8.253	.9901	.00201
130	2.2225	8.227	.9872	.00202
140	2.8886	8.207	.9848	.00203
150	3.718	8.182	.9818	.00203
160	4.741	8.156	.9786	.00204
170	5.992	8.127	.9752	.00205
180	7.510	8.098	.9717	.00205
190	9.339	8.068	.9681	.00206
200	11.526	8.039	.9646	.00207
210	14.123	8.005	.9605	.00208
212	14.696	7.996	.9594	.00208
220	17.186	7.972	.9566	.00209
240	24.969	7.901	.9480	.00210
260	35.429	7.822	.9386	.00211
280	49.203	7.746	.9294	.00215
300	67.013	7.662	.9194	.00217
350	134.63	7.432	.8918	.00224
400	247.31	7.172	.8606	.00232
450	422.6	6.892	.8270	.00241
500	680.8	6.553	.7863	.00254
550	1045.2	6.132	.7358	.00271
600	1542.9	5.664	.6796	.00294
700	3093.7	3.623	.4347	.00460

*Multiply flow in pounds per hour by the factor to get equivalent flow in gallons per minute. Weight per gallon is based on 7.48 gallons per cubic foot.

Properties of Saturated Steam

ABSOLUTE PRESSURE		VACUUM (INCHES OF Hg)	TEMPER- ATURE t (°F)	HEAT OF THE LIQUID (BTU/LB)	LATENT HEAT OF EVAPORATION (BTU/LB)	TOTAL HEAT OF STEAM H _g (BTU/LB)	SPECIFIC VOLUME V (CU FT PER LB)
Lbs Per Sq In. P _a	Inches of Hg						
0.20	0.41	29.51	53.14	21.21	1063.8	1085.0	1526.0
0.25	0.51	28.41	59.30	27.36	1060.3	1087.7	1235.3
0.30	0.61	29.31	64.47	32.52	1057.4	1090.0	1039.5
0.35	0.71	29.21	68.93	36.87	1054.9	1091.9	898.5
0.40	0.81	29.11	72.86	40.89	1052.7	1093.6	791.9
0.45	0.92	29.00	76.38	44.41	1050.7	1095.1	708.5
0.50	1.02	28.90	79.58	47.60	1048.8	1096.4	641.4
0.60	1.22	28.70	85.21	53.21	1045.7	1098.9	540.0
0.70	1.43	28.49	90.08	58.07	1042.9	1101.0	466.9
0.80	1.63	28.29	94.38	62.36	1040.4	1102.8	411.7
0.90	1.83	28.09	98.24	66.21	1038.3	1104.5	368.4
1.0	2.04	27.88	101.74	69.70	1036.3	1106.0	333.6
1.2	2.44	27.48	107.92	75.87	1032.7	1108.6	280.9
1.4	2.85	27.07	113.26	81.20	1029.6	1110.8	243.0
1.6	3.26	26.66	117.99	85.91	1026.9	1112.8	214.3
1.8	3.66	26.26	122.23	90.14	1024.5	1114.6	191.8
2.0	4.07	25.85	126.08	93.99	1022.2	1116.2	173.73
2.2	4.48	25.44	129.62	97.52	1020.2	1117.7	158.85
2.4	4.89	25.03	132.89	100.79	1018.3	1119.1	146.38
2.6	5.29	24.63	135.94	103.83	1016.5	1120.3	135.78
2.8	5.70	24.22	138.79	106.68	1014.8	1121.5	126.65
3.0	6.11	23.81	141.48	109.37	1013.2	1122.6	118.71
3.5	7.13	22.79	147.57	115.46	1009.6	1125.1	102.72
4.0	8.14	21.78	152.97	120.86	1006.4	1127.3	90.63
4.5	9.16	20.76	157.83	125.71	1003.6	1129.3	81.16
5.0	10.18	19.74	162.24	130.13	1001.0	1131.1	73.52
5.5	11.20	18.72	166.30	134.19	998.5	1132.7	67.24
6.0	12.22	17.70	170.06	137.96	996.2	1134.2	61.98
6.5	13.23	16.69	173.56	141.47	994.1	1135.6	57.50
7.0	14.25	15.67	176.85	144.76	992.1	1136.9	53.64
7.5	15.27	14.65	179.94	147.86	990.2	1138.1	50.29
8.0	16.29	13.63	182.86	150.79	988.5	1139.3	47.34
8.5	17.31	12.61	185.64	153.57	986.8	1140.4	44.73
9.0	18.32	11.60	188.26	156.22	985.2	1141.4	42.40
9.5	19.34	10.58	190.80	158.75	983.6	1142.3	40.31
10.0	20.36	9.56	193.21	161.17	982.1	1143.3	38.42
11.0	22.40	7.52	197.75	165.73	979.3	1145.0	35.14
12.0	24.43	5.49	201.96	169.96	976.6	1146.6	32.40
13.0	26.47	3.45	205.88	173.91	974.2	1148.1	30.06
14.0	28.50	1.42	209.66	177.61	971.9	1149.5	28.04

Properties of Saturated Steam

PRESSURE (LBS PER SQ IN.)		TEMPER- ATURE t (°F)	HEAT OF THE LIQUID (BTU/LB)	LATENT HEAT OF EVAPORATION (BTU/LB)	TOTAL HEAT OF STEAM H _g (BTU/LB)	SPECIFIC VOLUME V (CU FT PER LB)
Absolute P'	Gauge P					
14.696	0.0	212.00	180.07	970.3	1150.4	26.80
15.0	0.3	213.03	181.11	969.7	1150.8	26.29
16.0	1.3	216.32	184.42	967.6	1152.0	24.75
17.0	2.3	219.44	187.56	965.5	1153.1	23.39
18.0	3.3	222.41	190.56	963.6	1154.2	22.17
19.0	4.3	225.24	193.42	961.9	1155.3	21.08
20.0	5.3	227.96	196.16	960.1	1156.3	20.089
21.0	6.3	230.57	198.79	958.4	1157.2	19.192
22.0	7.3	233.07	201.33	956.8	1158.1	18.375
23.0	8.3	235.49	203.78	955.2	1159.0	17.627
24.0	9.3	237.82	206.14	953.7	1159.8	16.938
25.0	10.3	240.07	208.42	952.1	1160.6	16.303
26.0	11.3	242.25	210.62	950.7	1161.3	15.715
27.0	12.3	244.36	212.75	949.3	1162.0	15.170
28.0	13.3	246.41	214.83	947.9	1162.7	14.663
29.0	14.3	248.40	216.86	946.5	1163.4	14.189
30.0	15.3	250.33	218.82	945.3	1164.1	13.746
31.0	16.3	252.22	220.73	944.0	1164.7	13.330
32.0	17.3	254.05	222.59	942.8	1165.4	12.940
33.0	18.3	255.84	224.41	941.6	1166.0	12.572
34.0	19.3	257.58	226.18	940.3	1166.5	12.226
35.0	20.3	259.28	227.91	939.2	1167.1	11.898
36.0	21.3	260.95	229.60	938.0	1167.6	11.588
37.0	22.3	262.57	231.26	936.9	1168.2	11.294
38.0	23.3	264.16	232.89	935.8	1168.7	11.015
39.0	24.3	265.72	234.48	934.7	1169.2	10.750
40.0	25.3	267.25	236.03	933.7	1169.7	10.498
41.0	26.3	268.74	237.55	932.6	1170.2	10.258
42.0	27.3	270.21	239.04	931.6	1170.7	10.029
43.0	28.3	271.64	240.51	930.6	1171.1	9.810
44.0	29.3	273.05	241.95	929.6	1171.6	9.601
45.0	30.3	274.44	243.36	928.6	1172.0	9.401
46.0	31.3	275.80	244.75	927.7	1172.4	9.209
47.0	32.3	277.13	246.12	926.7	1172.9	9.025
48.0	33.3	278.45	247.47	925.8	1173.3	8.848
49.0	34.3	279.74	248.79	924.9	1173.7	8.678
50.0	35.3	281.01	250.09	924.0	1174.1	8.516
51.0	36.3	282.26	251.37	923.0	1174.4	8.359
52.0	37.3	283.49	252.63	922.2	1174.8	8.208
53.0	38.3	284.70	253.87	921.3	1175.2	8.062
54.0	39.3	285.90	255.09	920.5	1175.6	7.922

- Continued -

Properties of Saturated Steam (Continued)

PRESSURE (LBS PER SQ. IN.)		TEMPER- ATURE t (°F)	HEAT OF THE LIQUID (BTU/LB)	LATENT HEAT OF EVAPORATION (BTU/LB)	TOTAL HEAT OF STEAM H _g (BTU/LB)	SPECIFIC VOLUME v (CU FT PER LB)
Absolute P	Gauge P					
55.0	40.3	287.07	256.30	919.6	1175.9	7.787
56.0	41.3	288.22	257.50	918.8	1176.3	7.656
57.0	42.3	289.37	258.67	917.9	1176.6	7.529
58.0	43.3	290.60	259.82	917.1	1176.9	7.407
59.0	44.3	291.61	260.96	916.3	1177.3	7.289
60.0	45.3	292.71	262.09	915.5	1177.6	7.175
61.0	46.3	293.79	263.20	914.7	1177.9	7.064
62.0	47.3	294.86	264.30	913.9	1178.2	6.957
63.0	48.3	295.90	265.38	913.1	1178.5	6.853
64.0	49.3	296.94	266.45	912.3	1178.8	6.752
65.0	50.3	297.97	267.50	911.6	1179.1	6.655
66.0	51.3	298.99	268.55	910.8	1179.4	6.560
67.0	52.3	299.99	269.58	910.1	1179.7	6.468
68.0	53.3	300.98	270.60	909.4	1180.0	6.378
69.0	54.3	301.96	291.61	908.7	1180.3	6.291
70.0	55.3	302.92	272.61	907.9	1180.6	6.206
71.0	56.3	303.88	273.60	907.2	1180.8	6.124
72.0	57.3	304.83	274.57	906.5	1181.1	6.044
73.0	58.3	305.76	275.54	906.8	1181.3	5.966
74.0	59.3	306.68	276.49	905.1	1181.6	5.890
75.0	60.3	307.60	277.43	904.5	1181.9	5.816
76.0	61.3	308.50	278.37	903.7	1182.1	5.743
77.0	62.3	309.40	279.30	903.1	1182.4	5.673
78.0	63.3	310.29	280.21	902.4	1182.6	5.604
79.0	64.3	311.16	281.12	901.7	1182.8	5.537
80.0	65.3	312.03	282.02	901.1	1183.1	5.472
81.0	66.3	312.89	282.91	900.4	1183.3	5.408
82.0	67.3	313.74	283.79	899.7	1183.5	5.346
83.0	68.3	314.59	284.66	899.1	1183.8	5.285
84.0	69.3	315.42	285.53	898.5	1184.0	5.226
85.0	70.3	316.25	286.39	897.8	1184.2	5.168
86.0	71.3	317.07	287.24	897.2	1184.4	5.111
87.0	72.3	317.88	288.08	896.5	1184.6	5.055
88.0	73.3	318.68	288.91	895.9	1184.8	5.001
89.0	74.3	319.48	289.74	895.3	1185.1	4.948
90.0	75.3	320.27	290.56	894.7	1185.3	4.896
91.0	76.3	321.06	291.38	894.1	1185.5	4.845
92.0	77.3	321.83	292.18	893.5	1185.7	4.796
93.0	78.3	322.60	292.98	892.9	1185.9	4.747
94.0	79.3	323.36	293.78	892.3	1186.1	4.699
95.0	80.3	324.12	294.56	891.7	1186.2	4.652
96.0	81.3	324.87	295.34	891.1	1186.4	4.606
97.0	82.3	325.61	296.12	890.5	1186.6	4.561
98.0	83.3	326.35	296.89	889.9	1186.8	4.517
99.0	84.3	327.08	297.65	889.4	1187.0	4.474

- Continued -

Properties of Saturated Steam (Continued)

PRESSURE (LBS PER SQ. IN.)		TEMPER- ATURE t (°F)	HEAT OF THE LIQUID (BTU/LB)	LATENT HEAT OF EVAPORATION (BTU/LB)	TOTAL HEAT OF STEAM H _g (BTU/LB)	SPECIFIC VOLUME v (CU FT PER LB)
Absolute P	Gauge P					
100.0	85.3	327.81	298.40	888.8	1187.2	4.432
101.0	86.3	328.53	299.15	888.2	1187.4	4.391
102.0	87.3	329.25	299.90	887.6	1187.5	4.360
103.0	88.3	329.96	300.64	887.1	1187.7	4.310
104.0	89.3	330.66	301.37	886.5	1187.9	4.271
105.0	90.3	331.36	302.10	886.0	1188.1	4.232
106.0	91.3	332.05	302.82	885.4	1188.2	4.194
107.0	92.3	332.74	303.54	884.9	1188.4	4.157
108.0	93.3	333.42	304.26	884.3	1188.6	4.120
109.0	94.3	334.10	304.97	883.7	1188.7	4.084
110.0	95.3	334.77	305.66	883.2	1188.9	4.049
111.0	96.3	335.44	306.37	882.6	1189.0	4.015
112.0	97.3	336.11	307.06	882.1	1189.2	3.981
113.0	98.3	336.77	307.75	881.6	1189.4	3.947
114.0	99.3	337.42	308.43	881.1	1189.5	3.914
115.0	100.3	338.07	309.11	880.6	1189.7	3.882
116.0	101.3	338.72	309.79	880.0	1189.8	3.850
117.0	102.3	339.36	310.46	879.5	1190.0	3.819
118.0	103.3	339.99	311.12	879.0	1190.1	3.788
119.0	104.3	340.62	311.78	878.4	1190.2	3.758
120.0	105.3	341.25	312.44	877.9	1190.4	3.728
121.0	106.3	341.88	313.10	877.4	1190.5	3.699
122.0	107.3	342.50	313.75	876.9	1190.7	3.670
123.0	108.3	343.11	314.40	876.4	1190.8	3.642
124.0	109.3	343.72	315.04	875.9	1190.9	3.614
125.0	110.3	344.33	315.68	875.4	1191.1	3.587
126.0	111.3	344.94	316.31	874.9	1191.2	3.560
127.0	112.3	345.54	316.94	874.4	1191.3	3.533
128.0	113.3	346.13	317.57	873.9	1191.5	3.507
129.0	114.3	346.73	318.19	873.4	1191.6	3.481
130.0	115.3	347.32	318.81	872.9	1191.7	3.455
131.0	116.3	347.90	319.43	872.5	1191.9	3.430
132.0	117.3	348.48	320.04	872.0	1192.0	3.405
133.0	118.3	349.06	320.65	871.5	1192.1	3.381
134.0	119.3	349.64	321.25	871.0	1192.2	3.357
135.0	120.3	350.21	321.85	870.6	1192.4	3.333
136.0	121.3	350.78	322.45	870.1	1192.5	3.310
137.0	122.3	351.35	323.05	869.6	1192.6	3.287
138.0	123.3	351.91	323.64	869.1	1192.7	3.264
139.0	124.3	352.47	324.23	868.7	1192.8	3.242
140.0	125.3	353.02	324.82	868.2	1193.0	3.220
141.0	126.3	353.57	325.40	867.7	1193.1	3.198
142.0	127.3	354.12	325.98	867.2	1193.2	3.177
143.0	128.3	354.67	326.56	866.7	1193.3	3.155
144.0	129.3	355.21	327.13	866.3	1193.4	3.134

- Continued -

Properties of Saturated Steam (Continued)

PRESSURE (LBS PER SQ IN.)		TEMPER- ATURE t (°F)	HEAT OF THE LIQUID (BTU/LB)	LATENT HEAT OF EVAPORATION (BTU/LB)	TOTAL HEAT OF STEAM H _g (BTU/LB)	SPECIFIC VOLUME v (CU FT PER LB)
Absolute P _a	Gauge P _g					
145.0	130.3	355.78	327.70	865.8	1193.5	3.114
146.0	131.3	356.29	328.27	865.3	1193.6	3.094
147.0	132.3	356.83	328.83	864.9	1193.8	3.074
148.0	133.3	357.36	329.39	864.5	1193.9	3.054
149.0	134.3	357.89	329.95	864.0	1194.0	3.034
150.0	135.3	358.42	330.51	863.6	1194.1	3.015
152.0	137.3	359.46	331.61	862.7	1194.3	2.977
154.0	139.3	360.49	332.70	861.8	1194.5	2.940
156.0	141.3	361.52	333.79	860.9	1194.7	2.904
158.0	143.3	362.53	334.86	860.0	1194.9	2.869
160.0	145.3	363.53	335.93	859.2	1195.1	2.834
162.0	147.3	364.63	336.98	858.3	1195.3	2.801
164.0	149.3	365.51	338.02	857.5	1195.5	2.768
166.0	151.3	366.48	339.05	856.6	1195.7	2.736
168.0	153.3	367.45	340.07	855.7	1195.8	2.705
170.0	155.3	368.41	341.09	854.9	1196.0	2.675
172.0	157.3	369.35	342.10	854.1	1196.2	2.646
174.0	159.3	370.29	343.10	853.3	1196.4	2.616
176.0	161.3	371.22	344.09	852.4	1196.5	2.587
178.0	163.3	372.14	345.08	851.6	1196.7	2.559
180.0	165.3	373.06	346.03	850.8	1196.9	2.532
182.0	167.3	373.96	347.00	850.0	1197.0	2.505
184.0	169.3	374.86	347.98	849.2	1197.2	2.479
186.0	171.3	375.75	348.92	848.4	1197.3	2.454
188.0	173.3	376.64	349.86	847.6	1197.5	2.429
190.0	175.3	377.51	350.79	846.8	1197.6	2.404
192.0	177.3	378.38	351.72	846.1	1197.8	2.380
194.0	179.3	379.24	352.64	845.3	1197.9	2.356
196.0	181.3	380.10	353.55	844.5	1198.1	2.333
198.0	183.3	380.95	354.46	843.7	1198.2	2.310
200.0	185.3	381.79	355.36	843.0	1198.4	2.288
205.0	190.3	383.86	357.58	841.1	1198.7	2.234
210.0	195.3	385.90	359.77	839.2	1199.0	2.183
215.0	200.3	387.89	361.91	837.4	1199.3	2.134
220.0	205.3	389.86	364.02	835.6	1199.6	2.087
225.0	210.3	391.79	366.09	833.8	1199.9	2.0422
230.0	215.3	393.68	368.13	832.0	1200.1	1.9992
235.0	220.3	395.54	370.14	830.3	1200.4	1.9579
240.0	225.3	397.37	372.12	828.5	1200.6	1.9183
245.0	230.3	399.18	374.08	826.8	1200.9	1.8803
250.0	235.3	400.95	376.00	825.1	1201.1	1.8438
255.0	240.3	402.70	377.89	823.4	1201.3	1.8086
260.0	245.3	404.42	379.76	821.8	1201.5	1.7748
265.0	250.3	406.11	381.60	820.1	1201.7	1.7422
270.0	255.3	407.78	383.42	818.5	1201.9	1.7107

- Continued -

calafish_00225

ROA_03458

Properties of Saturated Steam (Continued)

PRESSURE (LBS PER SQ IN.)		TEMPER- ATURE	HEAT OF THE LIQUID (BTU/LB)	LATENT HEAT OF EVAPORATION (BTU/LB)	TOTAL HEAT OF STEAM H_g (BTU/LB)	SPECIFIC VOLUME V (CU FT PER LB)
Absolute P	Gauge P	t (°F)				
275.0	260.3	409.43	385.21	818.9	1202.1	1.6804
280.0	265.3	411.06	386.98	815.3	1202.3	1.6511
285.0	270.3	412.65	388.73	813.7	1202.4	1.6228
290.0	275.3	414.23	390.46	812.1	1202.6	1.5954
295.0	280.3	415.79	392.16	810.5	1202.7	1.5689
300.0	285.3	417.33	393.84	809.0	1202.8	1.5433
320.0	305.3	423.29	400.39	803.0	1203.4	1.4486
340.0	325.3	428.97	406.66	797.1	1203.7	1.3645
360.0	345.3	434.40	412.67	791.4	1204.1	1.2895
380.0	365.3	439.60	418.46	785.8	1204.3	1.2222
400.0	385.3	444.59	424.0	780.5	1204.5	1.1613
420.0	405.3	449.39	429.4	775.2	1204.6	1.1061
440.0	425.3	454.02	434.6	770.0	1204.8	1.0556
460.0	445.3	458.50	439.7	764.9	1204.6	1.0094
480.0	465.3	462.82	444.6	759.9	1204.5	0.9670
500.0	485.3	467.01	449.4	755.0	1204.4	0.9278
520.0	505.3	471.07	454.1	750.1	1204.2	0.8915
540.0	525.3	475.01	458.6	745.4	1204.0	0.8578
560.0	545.3	478.85	463.0	740.8	1203.8	0.8265
580.0	565.3	482.58	467.4	736.1	1203.5	0.7973
600.0	585.3	486.21	471.6	731.6	1203.2	0.7698
620.0	605.3	489.75	475.7	727.2	1202.9	0.7440
640.0	625.3	493.21	479.8	722.7	1202.5	0.7198
660.0	645.3	496.58	483.8	718.3	1202.1	0.6971
680.0	665.3	499.88	487.7	714.0	1201.7	0.6757
700.0	685.3	503.10	491.5	709.7	1201.2	0.6554
720.0	705.3	506.25	495.3	705.4	1200.7	0.6362
740.0	725.3	509.34	499.0	701.2	1200.2	0.6180
760.0	745.3	512.36	502.6	697.1	1199.7	0.6007
780.0	765.3	515.33	506.2	692.9	1199.1	0.5843
800.0	785.3	518.23	509.7	688.9	1198.6	0.5687
820.0	805.3	521.08	513.2	684.8	1198.0	0.5538
840.0	825.3	523.88	516.6	680.8	1197.4	0.5396
860.0	845.3	526.63	520.0	676.8	1196.8	0.5260
880.0	865.3	529.33	523.3	672.8	1196.1	0.5130
900.0	885.3	531.98	526.6	668.8	1195.4	0.5006
920.0	905.3	534.59	529.8	664.9	1194.7	0.4886
940.0	925.3	537.16	533.0	661.0	1194.0	0.4772
960.0	945.3	539.68	536.2	657.1	1193.3	0.4663
980.0	965.3	542.17	539.3	653.3	1192.6	0.4557
1000.0	985.3	544.61	542.4	649.4	1191.8	0.4456
1050.0	1035.3	550.57	550.0	639.9	1189.9	0.4218
1100.0	1085.3	556.31	557.4	630.4	1187.8	0.4001
1150.0	1135.3	561.86	564.6	621.0	1185.6	0.3802
1200.0	1185.3	567.22	571.7	611.7	1183.4	0.3619

- Continued -

calafish_00226

Properties of Saturated Steam (Continued)

PRESSURE (LBS PER SQ IN.)		TEMPER- ATURE t (°F)	HEAT OF THE LIQUID (BTU/LB)	LATENT HEAT OF EVAPORATION (BTU/LB)	TOTAL HEAT OF STEAM H _g (BTU/LB)	SPECIFIC VOLUME v (CU FT PER LB)
Absolute P'	Gauge P					
1250.0	1235.3	572.42	578.6	602.4	1181.0	0.3450
1300.0	1285.3	577.46	585.4	593.2	1178.6	0.3293
1350.0	1335.3	582.35	592.1	584.0	1176.1	0.3148
1400.0	1385.3	587.10	598.7	574.7	1173.4	0.3012
1450.0	1435.3	591.73	605.2	565.5	1170.7	0.2884
1500.0	1485.3	596.23	611.6	556.3	1167.9	0.2765
1600.0	1585.3	604.90	624.1	538.0	1162.1	0.2548
1700.0	1685.3	613.15	636.3	519.8	1155.9	0.2354
1800.0	1785.3	621.03	648.3	501.1	1149.4	0.2179
1900.0	1885.3	628.58	660.1	482.4	1142.4	0.2021
2000.0	1985.3	636.82	671.7	463.4	1135.1	0.1878
2100.0	2085.3	642.77	683.3	444.1	1127.4	0.1746
2200.0	2185.3	649.46	694.8	424.4	1119.2	0.1626
2300.0	2285.3	655.91	706.5	403.9	1110.4	0.1513
2400.0	2385.3	662.12	718.4	382.7	1101.1	0.1407
2500.0	2485.3	668.13	730.6	360.6	1091.1	0.1307
2600.0	2585.3	673.94	743.0	337.2	1080.2	0.1213
2700.0	2685.3	679.55	756.2	312.1	1068.3	0.1123
2800.0	2785.3	684.99	770.1	284.7	1054.8	0.1036
2900.0	2885.3	690.26	785.4	253.6	1039.0	0.0947
3000.0	2985.3	695.36	802.5	217.8	1020.3	0.0858
3100.0	3085.3	700.31	825.0	168.1	993.1	0.0753
3200.0	3185.3	705.11	872.4	62.0	934.4	0.0580
3206.2	3191.5	705.40	902.7	0.0	902.7	0.0503

Refrigerant 717 (Ammonia)
Properties of Liquid and Saturated Vapor

TEMP. (°F)	PRESSURE		VOLUME (CU. FT./LB.)	DENSITY (LB./CU. FT.)	ENTHALPY† (BTU/LB.)		ENTROPY† BTU/(LB.)(°R)	
	psia	psig	Vapor v_g	Liquid l/v_f	Liquid h_f	Vapor h_g	Liquid s_f	Vapor s_g
-105	0.996	27.9*	223.2	45.71	-68.5	570.3	-0.1774	1.6243
-104	1.041	27.8*	214.2	45.67	-67.5	570.7	-0.1744	1.6205
-103	1.087	27.7*	205.7	45.63	-66.4	571.2	-0.1714	1.6167
-102	1.135	27.6*	197.6	45.59	-65.4	571.6	-0.1685	1.6129
-101	1.184	27.5*	189.8	45.55	-64.3	572.1	-0.1655	1.6092
-100	1.24	27.4*	182.4	45.52	-63.3	572.5	-0.1626	1.6055
-99	1.29	27.3*	175.3	45.47	-62.2	572.9	-0.1597	1.6018
-98	1.34	27.2*	168.5	45.43	-61.2	573.4	-0.1568	1.5982
-97	1.40	27.1*	162.1	45.40	-60.1	573.8	-0.1539	1.5945
-96	1.46	26.9*	155.9	45.36	-59.1	574.3	-0.1510	1.5910
-95	1.52	26.8*	150.0	45.32	-58.0	574.7	-0.1481	1.5874
-94	1.59	26.7*	144.3	45.28	-57.0	575.1	-0.1452	1.5838
-93	1.65	26.6*	138.9	45.24	-55.9	575.6	-0.1423	1.5803
-92	1.72	26.4*	133.8	45.20	-54.9	576.0	-0.1395	1.5768
-91	1.79	26.3*	128.9	45.16	-53.8	576.5	-0.1366	1.5734
-90	1.86	26.1*	124.1	45.12	-52.8	576.9	-0.1338	1.5699
-89	1.94	26.0*	119.6	45.08	-51.7	577.3	-0.1309	1.5665
-88	2.02	25.8*	115.3	45.04	-50.7	577.8	-0.1281	1.5631
-87	2.10	25.6*	111.1	45.00	-49.6	578.2	-0.1253	1.5597
-86	2.18	25.5*	107.1	44.96	-48.6	578.6	-0.1225	1.5564
-85	2.27	25.3*	103.3	44.92	-47.5	579.1	-0.1197	1.5531
-84	2.35	25.1*	99.68	44.88	-46.5	579.5	-0.1169	1.5498
-83	2.45	24.9*	96.17	44.84	-45.4	579.9	-0.1141	1.5465
-82	2.54	24.7*	92.81	44.80	-44.4	580.4	-0.1113	1.5432
-81	2.64	24.5*	89.59	44.76	-43.3	580.8	-0.1085	1.5400
-80	2.74	24.3*	86.50	44.73	-42.2	581.2	0.1067	1.5368
-79	2.84	24.1*	83.54	44.68	-41.2	581.6	-0.1030	1.5336
-78	2.95	23.9*	80.69	44.64	-40.1	582.1	-0.1002	1.5304
-77	3.06	23.7*	77.96	44.60	-39.1	582.5	-0.0975	1.5273
-76	3.18	23.5*	75.33	44.56	-38.0	582.9	-0.0947	1.5242
-75	3.29	23.2*	72.81	44.52	-37.0	583.3	-0.0920	1.5211
-74	3.42	23.0*	70.39	44.48	-35.9	583.8	-0.0892	1.5180
-73	3.54	22.7*	68.06	44.44	-34.9	584.2	-0.0865	1.5149
-72	3.67	22.4*	65.82	44.40	-33.8	584.6	-0.0838	1.5119
-71	3.80	22.2*	63.67	44.36	-32.8	585.0	-0.0811	1.5089
-70	3.94	21.9*	61.60	44.32	-31.7	585.5	-0.0784	1.5059
-69	4.08	21.6*	59.61	44.28	-30.7	585.9	-0.0757	1.5029
-68	4.23	21.3*	57.69	44.24	-29.6	586.3	-0.0730	1.4999
-67	4.38	21.0*	55.85	44.19	-28.6	586.7	-0.0703	1.4970
-66	4.53	20.7*	54.08	44.15	-27.5	587.1	-0.0676	1.4940
-65	4.69	20.4*	52.37	44.11	-26.5	587.5	-0.0650	1.4911
-64	4.85	20.0*	50.73	44.07	-25.4	588.0	-0.0623	1.4883
-63	5.02	19.7*	49.14	44.03	-24.4	588.4	-0.0596	1.4854
-62	5.19	19.4*	47.62	43.99	-23.3	588.8	-0.0570	1.4826
-61	5.37	19.0*	46.15	43.95	-22.2	589.2	-0.0543	1.4797
-60	5.55	18.6*	44.73	43.91	-21.2	589.6	-0.0517	1.4769

* Inches of mercury below one standard atmosphere.
† Based on 0 for the saturated liquid at -40°F.

Refrigerant 717 (Ammonia)
Properties of Liquid and Saturated Vapor (Continued)

TEMP. (°F)	PRESSURE		VOLUME (CU. FT./LB.)	DENSITY (LB./CU. FT.)	ENTHALPY† (BTU/LB.)		ENTROPY† BTU/(LB.)(°R)	
	psia	psig	Vapor V _g	Liquid 1/v _f	Liquid h _f	Vapor h _g	Liquid s _f	Vapor s _g
-59	5.74	18.2*	43.37	43.87	-20.1	590.0	-0.0480	1.4741
-58	5.93	17.8*	42.05	43.83	-19.1	590.4	-.0484	1.4713
-57	6.13	17.4*	40.79	43.78	-18.0	590.8	-.0438	1.4686
-56	6.33	17.0*	39.56	43.74	-17.0	591.2	-.0412	1.4658
-55	6.54	16.6*	38.38	43.70	-15.9	591.6	-.0388	1.4631
-54	6.75	16.2*	37.24	43.66	-14.8	592.1	-0.0360	1.4604
-53	6.97	15.7*	36.15	43.62	-13.8	592.4	-.0334	1.4577
-52	7.20	15.3*	35.09	43.58	-12.7	592.9	-.0307	1.4551
-51	7.43	14.8*	34.06	43.54	-11.7	593.2	-.0281	1.4524
-50	7.67	14.3*	33.08	43.49	-10.6	593.7	-.0256	1.4497
-49	7.91	13.8*	32.12	43.45	-9.6	594.0	-0.0230	1.4471
-48	8.16	13.3*	31.20	43.41	-8.5	594.4	-.0204	1.4445
-47	8.42	12.8*	30.31	43.37	-7.4	594.9	-.0179	1.4419
-46	8.68	12.2*	29.45	43.33	-6.4	595.2	-.0153	1.4393
-45	8.95	11.7*	28.62	43.28	-5.3	595.6	-.0127	1.4368
-44	9.23	11.1*	27.82	43.24	-4.3	596.0	-0.0102	1.4342
-43	9.51	10.6*	27.04	43.20	-3.2	596.4	-.0076	1.4317
-42	9.81	10.0*	26.29	43.16	-2.1	596.8	-.0051	1.4292
-41	10.10	9.3*	25.56	43.12	-1.1	597.2	-.0025	1.4267
-40	10.41	8.7*	24.86	43.08	0.0	597.6	.0000	1.4242
-39	10.72	8.1*	24.18	43.04	1.1	598.0	0.0025	1.4217
-38	11.04	7.4*	23.53	42.99	2.1	598.3	.0051	1.4193
-37	11.37	6.8*	22.89	42.95	3.2	598.7	.0076	1.4169
-36	11.71	6.1*	22.27	42.90	4.3	599.1	.0101	1.4144
-35	12.05	5.4*	21.68	42.86	5.3	599.5	.0126	1.4120
-34	12.41	4.7*	21.10	42.82	6.4	599.9	0.0151	1.4096
-33	12.77	3.9*	20.54	42.78	7.4	600.2	.0176	1.4072
-32	13.14	3.2*	20.00	42.73	8.5	600.6	.0201	1.4048
-31	13.52	2.4*	19.48	42.69	9.6	601.0	.0226	1.4025
-30	13.90	1.6*	18.97	42.65	10.7	601.4	.0250	1.4001
-29	14.30	0.8*	18.48	42.61	11.7	601.7	0.0275	1.3978
-28	14.71	0.0	18.00	42.57	12.8	602.1	.0300	1.3955
-27	15.12	0.4	17.54	42.54	13.9	602.5	.0325	1.3932
-26	15.55	0.8	17.09	42.48	14.9	602.8	.0350	1.3909
-25	15.98	1.3	16.66	42.44	16.0	603.2	.0374	1.3886
-24	16.24	1.7	16.24	42.40	17.1	603.6	0.0399	1.3863
-23	16.88	2.2	15.83	42.35	18.1	603.9	.0423	1.3840
-22	17.34	2.6	15.43	42.31	19.2	604.3	.0448	1.3818
-21	17.81	3.1	15.05	42.26	20.3	604.6	.0472	1.3796
-20	18.30	3.6	14.68	42.22	21.4	605.0	.0497	1.3774
-19	18.79	4.1	14.32	42.18	22.4	605.3	0.0521	1.3762
-18	19.30	4.6	13.97	42.13	23.5	605.7	.0545	1.3729
-17	19.81	5.1	13.62	42.09	24.6	606.1	.0570	1.3708
-16	20.34	5.6	13.29	42.04	25.6	606.4	.0594	1.3686
-15	20.88	6.2	12.97	42.00	26.7	606.7	.0618	1.3664
-14	21.43	6.7	12.66	41.96	27.8	607.1	.0642	1.3642

*Inches of mercury below one standard atmosphere.
†Based on 0 for the saturated liquid at -40°F.

Refrigerant 717 (Ammonia)
Properties of Liquid and Saturated Vapor (Continued)

TEMP. (°F)	PRESSURE		VOLUME (CU. FT./LB.)	DENSITY (LB./CU. FT.)	ENTHALPY† (BTU/LB.)		ENTROPY† BTU/(LB.)(°R)	
	psia	psig	Vapor V_g	Liquid $1/v_f$	Liquid h_f	Vapor h_g	Liquid s_f	Vapor s_g
-13	21.99	7.3	12.36	41.91	28.9	607.5	0.0666	1.3624
-12	22.56	7.9	12.06	41.87	30.0	607.8	.0690	1.3600
-11	23.15	8.5	11.78	41.82	31.0	608.1	.0714	1.3579
-10	23.74	9.0	11.50	41.78	32.1	608.5	.0738	1.3558
-9	24.35	9.7	11.23	41.74	33.2	608.8	.0762	1.3537
-8	24.97	10.3	10.97	41.69	34.3	609.2	0.0786	1.3516
-7	25.61	10.9	10.71	41.65	35.4	609.5	.0809	1.3493
-6	26.26	11.6	10.47	41.60	36.4	609.8	.0833	1.3474
-5	26.92	12.2	10.23	41.56	37.5	610.1	.0857	1.3454
-4	27.59	12.9	9.991	41.52	38.6	610.5	.0880	1.3433
-3	28.28	13.6	9.763	41.47	39.7	610.8	0.0909	1.3413
-2	28.98	14.3	9.541	41.43	40.7	611.1	.0928	1.3393
-1	29.69	15.0	9.326	41.38	41.8	611.4	.0951	1.3372
0	30.42	15.7	9.116	41.34	42.9	611.8	.0975	1.3352
1	31.16	16.5	8.912	41.29	44.0	612.1	.0998	1.3332
2	31.92	17.2	8.714	41.25	45.1	612.4	0.1022	1.3312
3	32.69	18.0	8.521	41.20	46.2	612.7	.1045	1.3292
4	33.47	18.8	8.333	41.16	47.2	613.0	.1069	1.3273
5†	34.27	19.6	8.150	41.11	48.3	613.3	.1092	1.3253
6	35.09	20.4	7.971	41.07	49.4	613.6	.1115	1.3234
7	35.92	21.2	7.798	41.01	50.5	613.9	0.1138	1.3214
8	36.77	22.1	7.629	40.98	51.6	614.3	.1162	1.3195
9	37.63	22.9	7.464	40.93	52.7	614.6	.1185	1.3176
10	38.51	23.8	7.304	40.89	53.8	614.9	.1208	1.3157
11	39.40	24.7	7.148	40.84	54.9	615.2	.1231	1.3137
12	40.31	25.6	6.996	40.80	56.0	615.5	0.1254	1.3118
13	41.24	26.5	6.847	40.75	57.1	615.8	.1277	1.3099
14	42.18	27.5	6.703	40.71	58.2	616.1	.1300	1.3081
15	43.14	28.4	6.562	40.66	59.2	616.3	.1323	1.3062
16	44.12	29.4	6.425	40.61	60.3	616.6	.1346	1.3043
17	45.12	30.4	6.291	40.57	61.4	616.9	0.1369	1.3025
18	46.13	31.4	6.161	40.52	62.5	617.2	.1392	1.3006
19	47.16	32.5	6.034	40.48	63.6	617.5	.1415	1.2988
20	48.21	33.5	5.910	40.43	64.7	617.8	.1437	1.2969
21	49.28	34.6	5.789	40.38	65.8	618.0	.1460	1.2951
22	50.36	35.7	5.671	40.34	66.9	618.3	0.1483	1.2933
23	51.47	36.8	5.556	40.29	68.0	618.6	.1505	1.2915
24	52.59	37.9	5.443	40.25	69.1	618.9	.1528	1.2897
25	53.73	39.0	5.334	40.20	70.2	619.1	.1551	1.2879
26	54.90	40.2	5.227	40.15	71.3	619.4	.1573	1.2861
27	56.08	41.4	5.123	40.10	72.4	619.7	0.1596	1.2843
28	57.28	42.6	5.021	40.06	73.5	619.9	.1618	1.2823
29	58.50	43.8	4.922	40.01	74.6	620.2	.1641	1.2809
30	59.74	45.0	4.825	39.96	75.7	620.5	.1663	1.2790
31	61.00	46.3	4.730	39.91	76.8	620.7	.1686	1.2773
32	62.29	47.6	4.637	39.86	77.9	621.0	.1708	1.2755

*Inches of mercury below one standard atmosphere.
†Based on 0 for the saturated liquid at -40°F.

† Standard cycle temperatures.

Refrigerant 717 (Ammonia)
Properties of Liquid and Saturated Vapor (Continued)

TEMP. (°F)	PRESSURE		VOLUME (CU. FT./LB.)	DENSITY (LB./CU. FT.)	ENTHALPY† (BTU/LB.)		ENTROPY† BTU/(LB.)(°R)	
	psia	psig	Vapor v_g	Liquid l/v_f	Liquid h_f	Vapor h_g	Liquid s_f	Vapor s_g
33	63.59	48.9	4.547	39.82	79.0	621.2	0.1730	1.2738
34	64.91	50.2	4.459	39.77	80.1	621.5	.1753	1.2721
35	66.28	51.6	4.373	39.72	81.2	621.7	.1775	1.2704
36	67.63	52.9	4.289	39.67	82.3	622.0	.1797	1.2686
37	69.02	54.3	4.207	39.63	83.4	622.2	.1819	1.2669
38	70.43	55.7	4.126	39.58	84.6	622.5	0.1841	1.2652
39	71.87	57.2	4.048	39.54	85.7	622.7	.1863	1.2635
40	73.32	58.6	3.971	39.49	86.8	623.0	.1885	1.2618
41	74.80	60.1	3.897	39.44	87.9	623.2	.1908	1.2602
42	76.31	61.6	3.823	39.39	89.0	623.4	.1930	1.2585
43	77.83	63.1	3.752	39.34	90.1	623.7	0.1952	1.2568
44	79.38	64.7	3.682	39.29	91.2	623.9	.1974	1.2552
45	80.96	66.3	3.614	39.24	92.3	624.1	.1996	1.2535
46	82.55	67.9	3.547	39.19	93.5	624.4	.2018	1.2518
47	84.18	69.5	3.481	39.14	94.6	624.6	.2040	1.2492
48	85.82	71.1	3.418	39.10	95.7	624.8	0.2062	1.2484
49	87.49	72.8	3.355	39.05	96.8	625.0	.2083	1.2469
50	89.19	74.5	3.294	39.00	97.9	625.2	.2105	1.2453
51	90.91	76.2	3.234	38.95	99.1	625.5	.2127	1.2437
52	92.66	78.0	3.176	38.90	100.2	625.7	.2149	1.2421
53	94.43	79.7	3.119	38.85	101.3	625.9	0.2171	1.2405
54	96.23	81.5	3.063	38.80	102.4	626.1	.2192	1.2382
55	98.06	83.4	3.008	38.75	103.5	626.3	.2214	1.2372
56	99.91	85.2	2.954	38.70	104.7	626.5	.2236	1.2357
57	101.8	87.1	2.902	38.65	105.8	626.7	.2257	1.2341
58	103.7	89.0	2.851	38.60	106.9	626.9	0.2279	1.2325
59	105.6	90.9	2.800	38.55	108.1	627.1	.2301	1.2310
60	107.6	92.9	2.751	38.50	109.2	627.3	.2322	1.2294
61	109.6	94.9	2.703	38.45	110.3	627.5	.2344	1.2273
62	111.6	96.9	2.656	38.40	111.5	627.7	.2365	1.2263
63	113.6	98.9	2.610	38.35	112.6	627.9	0.2387	1.2247
64	115.7	101.0	2.565	38.30	113.7	628.0	.2408	1.2231
65	117.8	103.1	2.520	38.25	114.8	628.2	.2430	1.2213
66	120.0	105.3	2.477	38.20	116.0	628.4	.2451	1.2201
67	122.1	107.4	2.435	38.15	117.1	628.6	.2473	1.2183
68	124.3	109.6	2.393	38.10	118.3	628.8	0.2494	1.2179
69	126.5	111.8	2.352	38.05	119.4	628.9	.2515	1.2165
70	128.8	114.1	2.312	38.00	120.5	629.1	.2537	1.2140
71	131.1	116.4	2.273	37.95	121.7	629.3	.2558	1.2125
72	133.4	118.7	2.235	37.90	122.8	629.4	.2579	1.2110
73	135.7	121.0	2.197	37.84	124.0	629.6	0.2601	1.2095
74	138.1	123.4	2.161	37.79	125.1	629.8	.2622	1.2080
75	140.5	125.8	2.125	37.74	126.2	629.9	.2643	1.2065
76	143.0	128.3	2.089	37.69	127.4	630.1	.2664	1.2050
77	145.4	130.7	2.055	37.64	128.5	630.2	.2685	1.2035
78	147.9	133.2	2.021	37.58	129.7	630.4	.2706	1.2020

*Inches of mercury below one standard atmosphere.
†Based on 0 for the saturated liquid at -40°F.

Refrigerant 717 (Ammonia)
Properties of Liquid and Saturated Vapor (Continued)

TEMP. (°F)	PRESSURE		VOLUME (CU. FT./LB.)	DENSITY (LB./CU. FT.)	ENTHALPY† (BTU/LB.)		ENTROPY† BTU/(LB.)(°R)	
	psia	psig	Vapor V_g	Liquid l/v_f	Liquid h_f	Vapor h_g	Liquid s_f	Vapor s_g
79	150.5	135.8	1.988	37.63	130.8	630.5	0.2728	1.2006
80	153.0	138.3	1.955	37.48	132.0	630.7	.2749	1.1891
81	155.6	140.9	1.923	37.43	133.1	630.8	.2769	1.1976
82	158.3	143.6	1.892	37.37	134.3	631.0	.2791	1.1962
83	161.0	146.3	1.861	37.32	135.4	631.1	.2812	1.1947
84	163.7	149.0	1.831	37.26	136.6	631.3	0.2833	1.1933
85	166.4	151.7	1.801	37.21	137.8	631.4	.2854	1.1918
86†	169.2	154.5	1.772	37.16	138.9	631.5	.2875	1.1904
87	172.0	157.3	1.744	37.11	140.1	631.7	.2895	1.1889
88	174.8	160.1	1.716	37.05	141.2	631.8	.2917	1.1875
89	177.7	163.0	1.688	37.00	142.4	631.9	0.2937	1.1860
90	180.6	165.9	1.661	36.95	143.5	632.0	.2958	1.1846
91	183.6	168.9	1.635	36.89	144.7	632.1	.2979	1.1832
92	186.6	171.9	1.609	36.84	145.8	632.2	.3000	1.1818
93	189.6	174.9	1.584	36.78	147.0	632.3	.3021	1.1804
94	192.7	178.0	1.559	36.73	148.2	632.5	0.3041	1.1789
95	195.8	181.1	1.534	36.67	149.4	632.6	.3062	1.1775
96	198.9	184.2	1.510	36.62	150.5	632.6	.3083	1.1761
97	202.1	187.4	1.487	36.56	151.7	632.8	.3104	1.1747
98	205.3	190.6	1.464	36.51	152.9	632.9	.3125	1.1733
99	208.6	193.9	1.441	36.45	154.0	632.9	0.3145	1.1719
100	211.9	197.2	1.419	36.40	155.2	633.0	.3166	1.1705
101	215.2	200.5	1.397	36.34	156.4	633.1	.3187	1.1691
102	218.6	203.9	1.375	36.29	157.6	633.2	.3207	1.1677
103	222.0	207.3	1.354	36.23	158.7	633.3	.3228	1.1663
104	225.4	210.7	1.334	36.18	159.9	633.4	0.3248	1.1649
105	228.9	214.2	1.313	36.12	161.1	633.4	.3269	1.1635
106	232.5	217.8	1.293	36.06	162.3	633.5	.3289	1.1621
107	236.0	221.3	1.274	36.01	163.5	633.6	.3310	1.1607
108	239.7	225.0	1.254	35.95	164.6	633.6	.3330	1.1593
109	243.3	228.6	1.235	35.90	165.8	633.7	0.3351	1.1580
110	247.0	232.3	1.217	35.84	167.0	633.7	.3372	1.1566
111	250.8	236.1	1.198	35.78	168.2	633.8	.3392	1.1552
112	254.5	239.8	1.180	35.72	169.4	633.8	.3413	1.1538
113	258.4	243.7	1.163	35.67	170.6	633.9	.3433	1.1524
114	262.2	247.5	1.145	35.61	171.8	633.9	0.3453	1.1510
115	266.2	251.5	1.128	35.55	173.0	633.9	.3474	1.1497
116	270.1	255.4	1.112	35.49	174.2	634.0	.3495	1.1483
117	274.1	259.4	1.095	35.43	175.4	634.0	.3515	1.1469
118	278.2	263.5	1.079	35.38	176.6	634.0	.3536	1.1455
119	282.3	267.6	1.063	35.32	177.8	634.0	.3556	1.1441
120	286.4	271.7	1.047	35.26	179.0	634.0	0.3576	1.1427
121	290.6	275.9	1.032	35.20	180.2	634.0	.3597	1.1414
122	294.8	280.1	1.017	35.14	181.4	634.0	.3618	1.1400
123	299.1	284.4	1.002	35.08	182.6	634.0	.3638	1.1386
124	303.4	288.7	0.987	35.02	183.9	634.0	.3659	1.1372
125	307.8	293.1	0.973	34.96	185.1	634.0	.3679	1.1358

* Inches of mercury below one standard atmosphere.

† Based on 0 for the saturated liquid at -40°F.

‡ Standard cycle temperatures.

Properties of Superheated Steam

$\bar{v}$ = specific volume, cubic feet per pound

h_g = total heat of steam, Btu per pound

PRESSURE (LBS PER SQ IN.)		SAT. TEMP. t		TOTAL TEMPERATURE—DEGREES FAHRENHEIT (t)										
Absolute p'	Gauge p			360°	400°	440°	480°	500°	600°	700°	800°	900°	1000°	1200°
14.696	0.0	212.00	$\bar{v}$ h_g	33.03 1221.1	34.68 1239.9	36.32 1258.8	37.96 1277.6	38.78 1287.1	42.88 1334.8	46.94 1383.2	51.00 1432.3	55.07 1482.3	59.13 1533.1	67.25 1637.5
20.0	5.3	227.96	$\bar{v}$ h_g	24.21 1220.3	25.43 1239.2	26.65 1258.2	27.88 1277.1	28.46 1286.6	31.47 1334.4	34.47 1382.9	37.46 1432.1	40.45 1482.1	43.44 1533.0	49.41 1637.4
30.0	15.3	250.33	$\bar{v}$ h_g	16.072 1218.6	16.897 1237.9	17.714 1257.0	18.528 1276.2	18.933 1285.7	20.95 1333.8	22.96 1382.4	24.96 1431.7	26.96 1481.8	28.95 1532.7	32.93 1637.2
40.0	25.3	267.26	$\bar{v}$ h_g	12.001 1216.9	12.628 1236.5	13.247 1255.9	13.862 1275.2	14.168 1284.8	15.688 1333.1	17.198 1381.9	18.702 1431.3	20.20 1481.4	21.70 1532.4	24.69 1637.0
50.0	35.3	281.01	$\bar{v}$ h_g	9.557 1215.2	10.065 1235.1	10.567 1254.7	11.062 1274.2	11.309 1283.9	12.532 1332.5	13.744 1381.4	14.950 1430.9	16.152 1481.1	17.352 1532.1	19.747 1636.8
60.0	45.3	292.71	$\bar{v}$ h_g	7.927 1213.4	8.357 1233.6	8.779 1253.5	9.196 1273.2	9.403 1283.0	10.427 1331.8	11.441 1380.9	12.449 1430.5	13.452 1480.8	14.454 1531.9	16.451 1636.6
70.0	55.3	302.92	$\bar{v}$ h_g	6.762 1211.5	7.136 1232.1	7.502 1252.3	7.863 1272.2	8.041 1282.0	8.924 1331.1	9.796 1380.4	10.662 1430.1	11.524 1480.5	12.383 1531.6	14.097 1636.3
80.0	65.3	312.03	$\bar{v}$ h_g	5.888 1209.7	6.220 1230.7	6.544 1251.1	6.862 1271.1	7.020 1281.1	7.797 1330.5	8.562 1379.9	9.322 1429.7	10.077 1480.1	10.830 1531.3	12.332 1636.2
90.0	75.3	320.27	$\bar{v}$ h_g	5.208 1207.7	5.508 1229.1	5.799 1249.8	6.084 1270.1	6.225 1280.1	6.920 1329.8	7.603 1379.4	8.279 1429.3	8.952 1479.8	9.623 1531.0	10.959 1635.9
100.0	85.3	327.81	$\bar{v}$ h_g	4.663 1205.7	4.937 1227.6	5.202 1248.6	5.462 1269.0	5.589 1279.1	6.218 1329.1	6.835 1378.9	7.446 1428.9	8.052 1479.5	8.656 1530.8	9.860 1635.7
120.0	105.3	341.25	$\bar{v}$ h_g	3.844 1201.6	4.081 1224.4	4.307 1246.0	4.527 1266.9	4.636 1277.2	5.165 1327.7	5.683 1377.8	6.196 1428.1	6.702 1478.8	7.207 1530.2	8.212 1635.3

- Continued -

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140.0	125.3	353.02	$\bar{V}$ h_p	3.258 1197.3	3.468 1221.1	3.667 1243.3	3.860 1264.7	3.954 1275.2	4.413 1326.4	4.861 1376.8	5.301 1427.3	5.738 1478.2	6.172 1529.7	7.035 1634.9
160.0	145.3	363.53	$\bar{V}$ h_p	...	3.008 1217.8	3.187 1240.6	3.359 1262.4	3.443 1273.1	3.849 1325.0	4.244 1375.7	4.631 1426.4	5.015 1477.5	5.398 1529.1	6.152 1634.5
180.0	165.3	373.06	$\bar{V}$ h_p	...	2.849 1214.0	2.813 1237.8	2.969 1260.2	3.044 1271.0	3.411 1323.5	3.764 1374.7	4.110 1425.6	4.452 1476.8	4.792 1528.8	5.466 1634.1
200.0	185.3	381.79	$\bar{V}$ h_p	...	2.361 1210.3	2.513 1234.9	2.656 1257.8	2.726 1268.9	3.060 1322.1	3.380 1373.8	3.693 1424.8	4.002 1476.2	4.309 1528.0	4.817 1633.7
220.0	205.3	389.86	$\bar{V}$ h_p	...	2.125 1206.5	2.267 1231.9	2.400 1255.4	2.465 1266.7	2.772 1320.7	3.066 1372.6	3.352 1424.0	3.634 1475.5	3.913 1527.5	4.467 1633.3
240.0	225.3	397.37	$\bar{V}$ h_p	...	1.9276 1202.5	2.062 1228.8	2.187 1253.0	2.247 1264.5	2.633 1319.2	2.804 1371.5	3.068 1423.2	3.327 1474.8	3.584 1526.9	4.093 1632.9
260.0	245.3	404.42	$\bar{V}$ h_p	...	...	1.8882 1225.7	2.006 1250.5	2.083 1262.3	2.330 1317.7	2.582 1370.4	2.827 1422.3	3.067 1474.2	3.305 1526.3	3.776 1632.5
280.0	265.3	411.05	$\bar{V}$ h_p	...	...	1.7388 1222.4	1.8512 1247.9	1.9047 1260.0	2.156 1316.2	2.392 1369.4	2.621 1421.5	2.845 1473.5	3.066 1525.8	3.504 1632.1
300.0	285.3	417.33	$\bar{V}$ h_p	...	...	1.6090 1219.1	1.7165 1245.3	1.7675 1257.6	2.005 1314.7	2.227 1368.3	2.442 1420.6	2.652 1472.8	2.859 1525.2	3.269 1631.7
320.0	305.3	423.29	$\bar{V}$ h_p	...	...	1.4950 1215.6	1.5985 1242.6	1.6472 1255.2	1.8734 1313.2	2.083 1367.2	2.285 1419.8	2.483 1472.1	2.678 1524.7	3.063 1631.3
340.0	325.3	428.97	$\bar{V}$ h_p	...	...	1.3941 1212.1	1.4941 1239.9	1.5410 1252.8	1.7569 1311.6	1.9562 1366.1	2.147 1419.0	2.334 1471.5	2.518 1524.1	2.881 1630.9
360.0	345.3	434.40	$\bar{V}$ h_p	...	...	1.3041 1208.4	1.4012 1237.1	1.4464 1250.3	1.6533 1310.1	1.8431 1365.0	2.025 1418.1	2.202 1470.8	2.376 1523.5	2.719 1630.5

- Continued -

Properties of Superheated Steam (Continued)

$\bar{v}$ = specific volume, cubic feet per pound

h_g = total heat of steam, Btu per pound

PRESSURE (LBS PER SQ IN.)		SAT. TEMP. t		TOTAL TEMPERATURE—DEGREES FAHRENHEIT (t)										
Absolute P'	Gauge P			500°	540°	600°	640°	660°	700°	740°	800°	900°	1000°	1200°
380.0	365.3	439.60	$\bar{v}$ h_g	1.3616 1247.7	1.4444 1273.1	1.5605 1308.5	1.6345 1331.0	1.6707 1342.0	1.7419 1363.8	1.8118 1385.3	1.9149 1417.3	2.083 1470.1	2.249 1523.0	2.575 1630.0
400.0	385.3	444.59	$\bar{v}$ h_g	1.2851 1245.1	1.3652 1271.0	1.4770 1306.9	1.5480 1329.6	1.5827 1340.8	1.6508 1362.7	1.7177 1384.3	1.8161 1416.4	1.9767 1469.4	2.134 1522.4	2.445 1629.6
420.0	405.3	449.39	$\bar{v}$ h_g	1.2158 1242.5	1.2935 1268.9	1.4014 1305.3	1.4697 1328.3	1.5030 1339.5	1.5684 1361.6	1.6324 1383.3	1.7267 1415.5	1.8802 1468.7	2.031 1521.9	2.327 1629.2
440.0	425.3	454.02	$\bar{v}$ h_g	1.1526 1239.8	1.2282 1266.7	1.3327 1303.6	1.3984 1326.9	1.4306 1338.2	1.4934 1360.4	1.5549 1382.3	1.6454 1414.7	1.7925 1468.1	1.9368 1521.3	2.220 1628.8
460.0	445.3	458.50	$\bar{v}$ h_g	1.0948 1237.0	1.1685 1264.5	1.2698 1302.0	1.3334 1325.4	1.3644 1336.9	1.4250 1359.3	1.4842 1381.3	1.5711 1413.8	1.7124 1467.4	1.8608 1520.7	2.122 1628.4
480.0	465.3	462.82	$\bar{v}$ h_g	1.0417 1234.2	1.1138 1262.3	1.2122 1300.3	1.2737 1324.0	1.3038 1335.6	1.3622 1358.2	1.4193 1380.3	1.5031 1412.9	1.6390 1466.7	1.7720 1520.2	2.033 1628.0
500.0	485.3	467.01	$\bar{v}$ h_g	0.9927 1231.3	1.0633 1260.0	1.1591 1298.6	1.2188 1322.6	1.2478 1334.2	1.3044 1357.0	1.3596 1379.3	1.4405 1412.1	1.5715 1466.0	1.6996 1519.6	1.9504 1627.6
520.0	505.3	471.07	$\bar{v}$ h_g	0.9473 1228.3	1.0166 1257.7	1.1101 1296.9	1.1681 1321.1	1.1962 1332.9	1.2511 1355.8	1.3045 1378.2	1.3826 1411.2	1.5091 1465.3	1.6326 1519.0	1.8743 1627.2
540.0	525.3	475.01	$\bar{v}$ h_g	0.9052 1225.3	0.9733 1255.4	1.0646 1295.2	1.1211 1319.7	1.1485 1331.5	1.2017 1354.6	1.2535 1377.2	1.3291 1410.3	1.4514 1464.6	1.5707 1518.5	1.8039 1626.8
560.0	545.3	478.85	$\bar{v}$ h_g	0.8659 1222.2	0.9330 1253.0	1.0224 1293.4	1.0775 1318.2	1.1041 1330.2	1.1568 1353.5	1.2060 1376.1	1.2794 1409.4	1.3978 1463.9	1.5132 1517.9	1.7385 1626.4
580.0	565.3	482.58	$\bar{v}$ h_g	0.8291 1219.0	0.8954 1250.5	0.9830 1291.7	1.0368 1316.7	1.0627 1328.8	1.1331 1352.3	1.1619 1375.1	1.2331 1408.6	1.3479 1463.2	1.4596 1517.3	1.6776 1626.0

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600.0	585.3	486.21	$\bar{V}$ h_p	0.7947 1215.7	0.8602 1248.1	0.9463 1289.9	0.9988 1315.2	1.0241 1327.4	1.0732 1351.1	1.1207 1374.0	1.1899 1407.7	1.3013 1462.5	1.4096 1516.7	1.6208 1625.5
620.0	606.3	489.76	$\bar{V}$ h_p	0.7624 1212.4	0.8272 1245.5	0.9118 1288.1	0.9633 1313.7	0.9880 1326.0	1.0358 1349.9	1.0821 1373.0	1.1494 1406.8	1.2577 1461.8	1.3828 1518.2	1.5876 1625.1
640.0	625.3	493.21	$\bar{V}$ h_p	0.7319 1209.0	0.7963 1243.0	0.8795 1286.2	0.9299 1312.2	0.9541 1324.6	1.0008 1348.6	1.0459 1371.9	1.1115 1405.9	1.2188 1461.1	1.3190 1515.6	1.5178 1624.7
660.0	645.3	496.58	$\bar{V}$ h_p	0.7032 1205.4	0.7670 1240.4	0.8491 1284.4	0.8985 1310.6	0.9222 1323.2	0.9679 1347.4	1.0119 1370.8	1.0759 1405.0	1.1784 1460.4	1.2778 1515.0	1.4709 1624.3
680.0	666.3	499.88	$\bar{V}$ h_p	0.6759 1201.8	0.7395 1237.7	0.8206 1282.5	0.8690 1309.1	0.8922 1321.7	0.9369 1346.2	0.9800 1369.8	1.0424 1404.1	1.1423 1459.7	1.2390 1514.5	1.4269 1623.9
700.0	685.3	503.10	$\bar{V}$ h_p	...	0.7134 1235.0	0.7934 1280.6	0.8411 1307.5	0.8639 1320.3	0.9077 1345.0	0.9498 1368.7	1.0108 1403.2	1.1082 1459.0	1.2024 1513.9	1.3853 1623.5
750.0	735.3	510.86	$\bar{V}$ h_p	...	0.6540 1227.9	0.7319 1275.7	0.7778 1303.5	0.7996 1316.6	0.8414 1341.8	0.8813 1366.0	0.9391 1400.9	1.0310 1457.2	1.1196 1512.4	1.2912 1622.4
800.0	785.3	518.23	$\bar{V}$ h_p	...	0.6015 1220.5	0.6779 1270.7	0.7223 1299.4	0.7433 1312.9	0.7833 1338.6	0.8215 1363.2	0.8763 1398.6	0.9633 1455.4	1.0470 1511.0	1.2088 1621.4
850.0	835.3	525.26	$\bar{V}$ h_p	...	0.5546 1212.7	0.6301 1265.5	0.6732 1295.2	0.6934 1309.0	0.7320 1335.4	0.7685 1360.4	0.8209 1396.3	0.9037 1463.6	0.9830 1509.5	1.1360 1620.4
900.0	885.3	531.98	$\bar{V}$ h_p	...	0.5124 1204.4	0.5873 1260.1	0.6294 1290.9	0.6491 1305.1	0.6863 1332.1	0.7215 1357.5	0.7716 1393.9	0.8506 1451.8	0.9262 1508.1	1.0714 1619.3
950.0	935.3	538.42	$\bar{V}$ h_p	...	0.4740 1195.5	0.5489 1254.6	0.5901 1286.4	0.6092 1301.1	0.6453 1328.7	0.6793 1354.7	0.7275 1391.6	0.8031 1450.0	0.8753 1506.6	1.0136 1618.3
1000.0	985.3	544.61	$\bar{V}$ h_p	...	...	0.5140 1248.8	0.5546 1281.9	0.5733 1297.0	0.6084 1325.3	0.6413 1351.7	0.6878 1389.2	0.7604 1448.2	0.8294 1505.1	0.9615 1617.3

- Continued -

Properties of Superheated Steam (Continued)

$\bar{v}$ = specific volume, cubic feet per pound

h_g = total heat of steam, Btu per pound

PRESSURE (LBS PER SQ IN.)		SAT. TEMP. t		TOTAL TEMPERATURE—DEGREES FAHRENHEIT (t)										
Absolute P'	Gauge P			660°	700°	740°	760°	780°	800°	860°	900°	1000°	1100°	1200°
1100.0	1085.3	556.31	$\bar{v}$ h_g	0.5110 1288.5	0.5445 1318.3	0.5755 1345.8	0.5904 1358.9	0.6049 1371.7	0.6191 1384.3	0.6601 1420.8	0.6866 1444.5	0.7503 1502.2	0.8117 1558.8	0.8716 1615.2
1200.0	1185.3	567.22	$\bar{v}$ h_g	0.4586 1279.6	0.4909 1311.0	0.5206 1339.6	0.5347 1353.2	0.5484 1366.4	0.5617 1379.3	0.6003 1416.7	0.6250 1440.7	0.6843 1499.2	0.7412 1556.4	0.7967 1613.1
1300.0	1285.3	577.46	$\bar{v}$ h_g	0.4139 1270.2	0.4454 1303.4	0.4739 1333.3	0.4874 1347.3	0.5004 1361.0	0.5131 1374.3	0.5498 1412.5	0.5728 1437.0	0.6284 1496.2	0.6816 1553.9	0.7333 1611.0
1400.0	1385.3	587.10	$\bar{v}$ h_g	0.3753 1260.3	0.4062 1295.5	0.4338 1326.7	0.4468 1341.3	0.4593 1355.4	0.4714 1369.1	0.5061 1408.2	0.5281 1433.1	0.5805 1493.2	0.6305 1551.4	0.6789 1608.9
1500.0	1485.3	596.23	$\bar{v}$ h_g	0.3413 1249.8	0.3719 1287.2	0.3989 1320.0	0.4114 1335.2	0.4235 1349.7	0.4352 1363.8	0.4684 1403.9	0.4893 1429.3	0.5390 1490.1	0.5862 1548.9	0.6318 1606.8
1600.0	1585.3	604.90	$\bar{v}$ h_g	0.3112 1238.7	0.3417 1278.7	0.3682 1313.0	0.3804 1328.8	0.3921 1343.9	0.4034 1358.4	0.4353 1399.5	0.4553 1425.3	0.5027 1487.0	0.5474 1546.4	0.5906 1604.6
1700.0	1685.3	613.15	$\bar{v}$ h_g	0.2842 1226.8	0.3148 1269.7	0.3410 1305.8	0.3529 1322.3	0.3643 1337.9	0.3753 1352.9	0.4081 1395.0	0.4253 1421.4	0.4706 1484.0	0.5132 1543.8	0.5542 1602.5
1800.0	1785.3	621.03	$\bar{v}$ h_g	0.2597 1214.0	0.2907 1260.3	0.3166 1298.4	0.3284 1315.5	0.3395 1331.8	0.3502 1347.2	0.3801 1390.4	0.3986 1417.4	0.4421 1480.8	0.4828 1541.3	0.5218 1600.4
1900.0	1885.3	628.58	$\bar{v}$ h_g	0.2371 1200.2	0.2688 1250.4	0.2947 1290.6	0.3063 1308.6	0.3173 1325.4	0.3277 1341.5	0.3568 1385.8	0.3747 1413.3	0.4165 1477.7	0.4556 1538.8	0.4929 1598.2
2000.0	1985.3	635.82	$\bar{v}$ h_g	0.2161 1184.9	0.2489 1240.0	0.2748 1282.6	0.2863 1301.4	0.2972 1319.0	0.3074 1335.5	0.3358 1381.2	0.3532 1409.2	0.3935 1474.5	0.4311 1536.2	0.4668 1596.1
2100.0	2085.3	642.77	$\bar{v}$ h_g	0.1962 1167.7	0.2306 1229.0	0.2567 1274.3	0.2682 1294.0	0.2789 1312.3	0.2890 1329.5	0.3167 1376.4	0.3337 1405.0	0.3727 1471.4	0.4089 1533.6	0.4433 1593.9

- Continued -

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2200.0	2185.3	649.46	$\bar{V}$ h_p	0.1768 1147.8	0.2135 1217.4	0.2400 1265.7	0.2514 1286.3	0.2621 1305.4	0.2721 1323.3	0.2994 1371.5	0.3159 1400.8	0.3538 1468.2	0.3887 1531.1	0.4218 1591.8
2300.0	2285.3	655.91	$\bar{V}$ h_p	0.1575 1123.8	0.1978 1204.9	0.2247 1256.7	0.2362 1278.4	0.2468 1298.4	0.2567 1316.9	0.2835 1366.6	0.2997 1396.5	0.3365 1464.9	0.3703 1528.5	0.4023 1589.6
2400.0	2385.3	662.12	$\bar{V}$ h_p	...	0.1828 1191.5	0.2105 1247.3	0.2221 1270.2	0.2327 1291.1	0.2425 1310.3	0.2689 1361.6	0.2848 1392.2	0.3207 1461.7	0.3534 1525.9	0.3843 1587.4
2500.0	2485.3	668.13	$\bar{V}$ h_p	...	0.1686 1176.8	0.1973 12-7.6	0.2090 1261.8	0.2196 1283.6	0.2294 1303.6	0.2555 1366.5	0.2710 1387.8	0.3061 1458.4	0.3379 1523.2	0.3678 1585.3
2600.0	2585.3	673.94	$\bar{V}$ h_p	...	0.1549 1160.6	0.1849 1227.3	0.1987 1252.9	0.2074 1275.8	0.2172 1296.8	0.2431 1361.4	0.2584 1383.4	0.2926 1455.1	0.3236 1520.6	0.3526 1583.1
2700.0	2685.3	679.55	$\bar{V}$ h_p	...	0.1415 1142.5	0.1732 1216.5	0.1853 1243.8	0.1960 1267.9	0.2059 1289.7	0.2315 1346.1	0.2466 1378.9	0.2801 1451.8	0.3103 1518.0	0.3385 1580.9
2800.0	2785.3	684.99	$\bar{V}$ h_p	...	0.1261 1121.4	0.1622 1205.1	0.1745 1234.2	0.1854 1259.6	0.1953 1282.4	0.2208 1340.8	0.2356 1374.3	0.2685 1448.5	0.2979 1515.4	0.3254 1578.7
2900.0	2885.3	690.26	$\bar{V}$ h_p	...	0.1143 1095.9	0.1517 1193.0	0.1644 1224.3	0.1754 1251.1	0.1853 1274.9	0.2108 1335.3	0.2254 1369.7	0.2577 1445.1	0.2864 1512.7	0.3132 1576.5
3000.0	2985.3	695.36	$\bar{V}$ h_p	...	0.0984 1080.7	0.1416 1180.1	0.1548 1213.8	0.1660 1242.2	0.1760 1267.2	0.2014 1329.7	0.2159 1365.0	0.2476 1441.8	0.2757 1510.0	0.3018 1574.3
3100.0	3085.3	700.31	$\bar{V}$ h_p	...	...	0.1320 1166.2	0.1456 1202.9	0.1571 1233.0	0.1672 1259.3	0.1926 1324.1	0.2070 1360.3	0.2382 1438.4	0.2657 1507.4	0.2911 1572.1
3200.0	3185.3	705.11	$\bar{V}$ h_p	...	...	0.1228 1151.1	0.1369 1191.4	0.1488 1223.5	0.1589 1251.1	0.1843 1318.3	0.1986 1355.5	0.2293 1434.9	0.2563 1504.7	0.2811 1569.9
3206.2	3191.5	705.40	$\bar{V}$ h_p	...	...	0.1220 1150.2	0.1363 1190.6	0.1480 1222.9	0.1583 1250.5	0.1838 1317.9	0.1981 1355.2	0.2288 1434.7	0.2557 1504.5	0.2806 1569.8

Velocity of Liquids in Pipe

The mean velocity of any flowing liquid can be calculated from the following formula, or, from the nomograph on the opposite page. The nomograph is a graphical solution of the formula.

$$v = 183.3 \frac{q}{d^2} = 0.408 \frac{Q}{d^2} = 0.0509 \frac{W}{d^2 \rho}$$

(For values of d , see pages 166-174.)

The pressure drop per 100 feet and the velocity in Schedule 40 pipe, for water at 60°F, have been calculated for commonly used flow rates for pipe sizes of 1/8 to 24-inch; these values are tabulated on pages 156-159.

Example 1

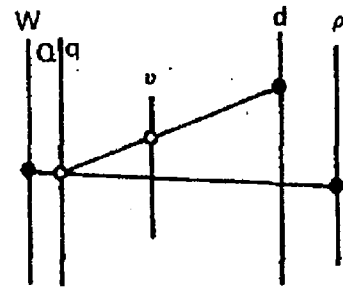
Given: No. 3 Fuel Oil of 0.898 specific gravity at 60°F flows through a 2-inch Schedule 40 pipe at the rate of 45,000 pounds per hour.

Find: The rate of flow in gallons per minute and the mean velocity in the pipe.

Solution:

1. $\rho = 56.02$ = weight density in pounds per cubic foot (specific gravity of fluid times weight density of water at same temperature.)

	Connect		Read
2.	$W = 45,000$	$\rho = 56.02$	$Q = 100$
3.	$Q = 100$	2" Sched 40	$v = 10$

**Example 2**

Given: Maximum flow rate of a liquid will be 300 gallons per minute with maximum velocity limited to 12 feet per second through Schedule 40 pipe.

Find: The smallest suitable pipe size and the velocity through the pipe.

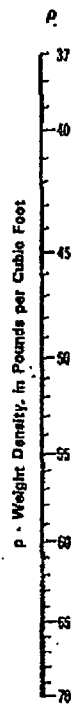
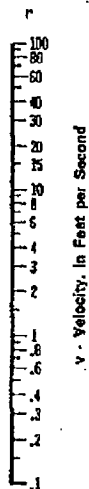
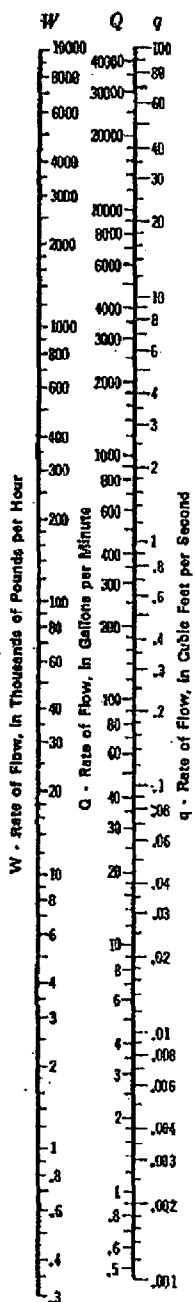
Solution:

	Connect		Read
1.	$Q = 300$	$v = 12$	$d = 3.2$
2.	3-1/2" Schedule 40 pipe suitable		
3.	$Q = 300$	3-1/2" Sched 40	$v = 10$

**Reasonable Velocities
For the Flow of Water through Pipe**

Service Condition	Reasonable Velocity (feet per second)
Boiler Feed	8 to 15
Pump Suction and Drain Lines	4 to 7
General Service	4 to 10
City	to 7

Velocity of Liquids in Pipe (Continued)



Flow of Water Through Schedule 40 Steel Pipe

DISCHARGE		PRESSURE DROP PER 100 FEET AND VELOCITY IN SCHEDULE 40 PIPE FOR WATER AT 60 F													
		Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)
		1/8"		1/4"		3/8"		1/2"		3/4"		1"		1-1/4"	
.2	0.000448	1.13	1.86	0.616	0.359										
.3	0.000668	1.69	4.22	0.924	0.903	0.504	0.159	0.317	0.061						
.4	0.000891	2.26	6.98	1.23	1.61	0.672	0.345	0.422	0.086						
.5	0.00111	2.82	10.5	1.54	2.39	0.840	0.539	0.528	0.167	0.301	0.033				
.6	0.00134	3.39	14.7	1.85	3.29	1.01	0.751	0.633	0.240	0.361	0.041				
.8	0.00178	4.52	25.0	2.46	5.44	1.34	1.25	0.844	0.408	0.481	0.102				
1	0.00223	5.65	37.2	3.08	8.28	1.68	1.85	1.06	0.600	0.602	0.155	0.371	0.048	1-1/2"	
2	0.00446	11.29	134.4	6.16	30.1	3.36	6.58	2.11	2.10	1.20	0.526	0.743	0.164	0.429	0.044
3	0.00668			9.25	64.1	5.04	13.9	3.17	4.33	1.81	1.09	1.114	0.336	0.644	0.090
4	0.00891			12.33	111.2	6.72	23.9	4.22	7.42	2.41	1.83	1.49	0.565	0.858	0.150
5	0.01114	2"				8.40	36.7	5.28	11.2	3.01	2.75	1.86	0.835	1.073	0.223
6	0.01337	0.574	0.044	2-1/2"		10.08	51.9	6.33	15.8	3.61	3.84	2.23	1.17	1.29	0.309
8	0.01782	0.765	0.073			13.44	91.1	8.45	27.7	4.81	6.60	2.97	1.99	1.72	0.518
10	0.02228	0.956	0.108	0.670	0.046			10.56	42.4	6.02	9.99	3.71	2.99	2.15	0.774
15	0.03342	1.43	0.224	1.01	0.094	3"				9.03	21.6	5.57	6.36	3.22	1.63
20	0.04456	1.91	0.375	1.34	0.158	0.868	0.056	3-1/2"		12.03	37.8	7.43	10.9	4.29	2.78
25	0.05570	2.39	0.561	1.68	0.234	1.09	0.083	0.812	0.041	4"		9.28	16.7	5.37	4.22
30	0.06684	2.87	0.786	2.01	0.327	1.30	0.114	0.974	0.066			11.14	23.8	6.44	5.92
35	0.07798	3.35	1.05	2.35	0.436	1.52	0.161	1.14	0.071	0.882	0.041	12.99	32.2	7.51	7.90
40	0.08912	3.83	1.35	2.68	0.556	1.74	0.192	1.30	0.095	1.01	0.052	14.85	41.6	8.59	10.24
45	0.1003	4.30	1.67	3.02	0.668	1.95	0.239	1.46	0.117	1.13	0.064			9.67	12.90

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		(2")		(2-1/2")		(3")		(3-1/2")		(4")				(1-1/4")		(1-1/2")	
50	0.1114	4.78	2.03	3.35	0.839	2.17	0.288	1.62	0.142	1.26	0.076	5"		10.74	15.66	7.88	7.15
60	0.1337	5.74	2.87	4.02	1.18	2.60	0.46	1.95	0.204	1.51	0.107			12.89	22.2	9.47	10.21
70	0.1560	6.70	3.84	4.69	1.59	3.04	0.540	2.27	0.261	1.76	0.143	1.12	0.047			11.05	13.71
80	0.1782	7.65	4.97	5.36	2.03	3.47	0.687	2.60	0.334	2.02	0.180	1.28	0.060			12.62	17.59
90	0.2005	8.60	6.20	6.03	2.53	3.91	0.861	2.92	0.416	2.27	0.224	1.44	0.074	6"		14.20	22.0
100	0.2228	9.56	7.69	6.70	3.09	4.34	1.05	3.25	0.509	2.52	0.272	1.60	0.090	1.11	0.036	15.78	26.9
125	0.2786	11.97	11.76	8.38	4.71	5.43	1.61	4.06	0.769	3.15	0.415	2.01	0.135	1.39	0.055	19.72	41.4
150	0.3342	14.36	16.70	10.05	6.69	6.51	2.24	4.87	1.08	3.78	0.580	2.41	0.190	1.67	0.077		
175	0.3899	16.75	22.3	11.73	8.97	7.60	3.00	5.68	1.44	4.41	0.774	2.81	0.253	1.94	0.102		
200	0.4456	19.14	28.8	13.42	11.68	8.68	3.87	6.49	1.85	5.04	0.985	3.21	0.323	2.22	0.130	8"	
225	0.5013	...	...	15.09	14.63	9.77	4.83	7.30	2.32	5.67	1.23	3.61	0.401	2.50	0.162	1.44	0.043
250	0.557	...	...	...	...	10.85	5.93	8.12	2.84	6.30	1.46	4.01	0.495	2.78	0.195	1.60	0.051
275	0.6127	...	...	...	...	11.94	7.14	8.93	3.40	6.93	1.79	4.41	0.583	3.05	0.234	1.76	0.061
300	0.6684	...	...	...	...	13.00	8.36	9.74	4.02	7.56	2.11	4.81	0.683	3.33	0.275	1.92	0.072
325	0.7241	...	...	...	...	14.12	9.89	10.53	4.09	8.19	2.47	5.21	0.797	3.61	0.320	2.08	0.083
350	0.7798			...	...	...	...	11.36	5.41	8.82	2.84	5.62	0.919	3.89	0.367	2.24	0.096
375	0.8356			...	...	...	...	12.17	6.18	9.45	3.25	6.02	1.06	4.18	0.416	2.40	0.108
400	0.8912			...	...	...	...	12.98	7.03	10.08	3.68	6.42	1.19	4.44	0.471	2.56	0.121
425	0.9469			...	...	...	...	13.80	7.89	10.71	4.12	6.82	1.33	4.72	0.529	2.73	0.136
450	1.003	10"		...	...	...	...	14.61	8.80	11.34	4.60	7.22	1.48	5.00	0.590	2.89	0.151
475	1.059	1.93	0.054			...	...	...	...	11.97	5.12	7.62	1.64	5.27	0.653	3.04	0.166
500	1.114	2.03	0.059			...	...	...	...	12.60	5.65	8.02	1.81	5.55	0.720	3.21	0.182
550	1.225	2.24	0.071			...	...	...	...	13.85	6.79	8.82	2.17	6.11	0.861	3.53	0.219
600	1.337	2.44	0.083			...	...	...	...	15.12	8.04	9.63	2.55	6.66	1.02	3.85	0.258
650	1.448	2.64	0.097			...	...	...	...	...	...	10.43	2.98	7.22	1.18	4.17	0.301

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Extracted from Technical Paper No. 410, *Flow of Fluids*, with permission of Crane Co.

Flow of Water Through Schedule 40 Steel Pipe (Continued)

DISCHARGE		PRESSURE DROP PER 100 FEET AND VELOCITY IN SCHEDULE 40 PIPE FOR WATER AT 60 F															
Gallons per Minute	Cubic Ft. per Second	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)	Veloc- ity (Feet per Sec.)	Press. Drop (PSI)
		10"		12"		14"		16"		18"		20"		24"		30"	
700	1.560	2.85	0.112	2.01	0.047	...	...	...	...	...	...	11.23	3.43	7.78	1.35	4.49	0.343
750	1.671	3.05	0.127	2.15	0.054	...	...	...	...	...	...	12.03	3.92	8.33	1.55	4.81	0.392
800	1.782	3.25	0.143	2.29	0.061	...	...	...	...	...	...	12.83	4.43	8.88	1.75	5.13	0.443
850	1.894	3.46	0.160	2.44	0.068	2.02	0.042	...	...	...	...	13.64	5.00	9.44	1.96	5.45	0.497
900	2.005	3.66	0.179	2.58	0.075	2.13	0.047	...	...	...	...	14.44	5.58	9.99	2.18	5.77	0.554
950	2.117	3.86	0.198	2.72	0.083	2.25	0.052	...	...	...	...	15.24	6.21	10.55	2.42	6.09	0.613
1000	2.228	4.07	0.218	2.87	0.091	2.37	0.057	...	...	...	...	16.04	6.84	11.10	2.68	6.41	0.675
1100	2.451	4.48	0.260	3.15	0.110	2.61	0.068	...	...	...	...	17.65	8.23	12.22	3.22	7.05	0.807
1200	2.674	4.88	0.306	3.44	0.128	2.85	0.080	2.18	0.042	...	...	...	...	13.33	3.81	7.70	.948
1300	2.896	5.29	0.355	3.73	0.150	3.08	0.093	2.36	0.048	...	...	...	...	14.43	4.45	8.33	1.11
1400	3.119	5.70	0.409	4.01	0.171	3.32	0.107	2.54	0.055	...	...	...	...	15.55	5.13	8.98	1.28
1500	3.342	6.10	0.466	4.30	0.195	3.56	0.122	2.72	0.063	...	...	...	...	16.66	5.85	9.62	1.46
1600	3.565	6.51	0.527	4.59	0.219	3.79	0.138	2.90	0.071	...	...	...	...	17.77	6.61	10.26	1.65
1800	4.010	7.32	0.663	5.16	0.278	4.27	0.172	3.27	0.088	2.58	0.050	...	...	19.99	8.37	11.54	2.08
2000	4.456	8.14	0.808	5.73	0.339	4.74	0.209	3.63	0.107	2.87	0.060	...	...	22.21	10.3	12.82	2.55
2500	5.570	10.17	1.24	7.17	0.515	5.93	0.321	4.54	0.163	3.59	0.091	...	...	...	...	16.03	3.94
3000	6.684	12.20	1.76	8.60	0.731	7.11	0.451	5.45	0.232	4.30	0.129	3.46	0.075	...	...	19.24	5.59
3500	7.798	14.24	2.38	10.03	0.982	8.30	0.607	6.35	0.312	5.02	0.173	4.04	0.101	...	...	22.44	7.56
4000	8.912	16.27	3.08	11.47	1.27	9.48	0.787	7.26	0.401	5.74	0.222	4.62	0.129	3.19	0.052	25.65	9.80
4500	10.03	18.31	3.87	12.90	1.60	10.67	0.990	8.17	0.503	6.46	0.280	5.20	0.162	3.59	0.065	28.87	12.2

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		(10")	(12")	(14")	(16")	(18")	(20")	(24")									
5000	11.14	20.35	4.71	14.33	1.95	11.85	1.21	9.08	0.617	7.17	0.340	5.77	0.199	3.99	0.079	...	...
6000	13.37	24.41	6.74	17.20	2.77	14.23	1.71	10.89	0.877	8.61	0.483	6.93	0.280	4.79	0.111	...	...
7000	16.60	28.49	9.11	20.07	3.74	16.60	2.31	12.71	1.18	10.04	0.652	8.08	0.376	5.59	0.150	...	...
8000	17.82	...	...	22.93	4.84	18.96	2.99	14.52	1.51	11.47	0.839	9.23	0.488	6.38	0.192	...	...
9000	20.05	...	...	25.79	6.09	21.34	3.76	16.34	1.90	12.91	1.05	10.39	0.608	7.18	0.242	...	...
10,000	22.28	...	...	28.66	7.46	23.71	4.61	18.16	2.34	14.34	1.28	11.54	0.739	7.98	0.294	...	...
12,000	26.74	...	...	34.40	10.7	28.45	6.59	21.79	3.33	17.21	1.83	13.85	1.06	9.58	0.416	...	...
14,000	31.19	...	...	...	...	33.19	8.89	25.42	4.49	20.08	2.45	16.16	1.43	11.17	0.562	...	...
16,000	35.65	...	...	...	...	...	...	29.05	5.83	22.95	3.18	18.47	1.85	12.77	0.723	...	...
18,000	40.10	...	...	...	...	...	...	32.88	7.31	25.82	4.03	20.77	2.32	14.36	0.907	...	...
20,000	44.56	...	...	...	...	...	...	36.31	9.03	28.69	4.93	23.08	2.86	15.96	1.12	...	...
For pipe lengths other than 100 feet, the pressure drop is proportional to the length. Thus, for 50 feet of pipe, the pressure drop is approximately one-half the value given in the table ... for 300 feet, three times the given value, etc. Velocity is a function of the cross sectional flow area; thus, it is constant for a given flow rate and is independent of pipe length.																	

For calculations for pipe other than Schedule 40, see explanation on page 161.

Extracted from Technical Paper No. 410, *Flow of Fluids*, with permission of Crane Co.

For lengths of pipe other than 100 feet, the pressure drop is proportional to the length. Thus, for 50 feet of pipe, the pressure drop is approximately one-half the value given in the table . . . for 300 feet, three times the given value, etc.

The pressure drop is also inversely proportional to the absolute pressure and directly proportional to the absolute temperature.

Therefore, to determine the pressure drop for inlet or average pressures other than 100 psi and at temperatures other than 60°F, multiply the values given in the table by the ratio:

$$\left(\frac{100 + 14.7}{P + 14.7} \right) \left(\frac{460 + t}{520} \right)$$

where:

"P" is the inlet or average gauge pressure in pounds per square inch, and,

"t" is the temperature in degrees Fahrenheit under consideration.

The cubic feet per minute of compressed air at any pressure is inversely proportional to the absolute pressure and directly proportional to the absolute temperature.

Flow of Air Through Schedule 40 Steel Pipe

FREE AIR q'm	COMPRESSED AIR	PRESSURE DROP OF AIR IN POUNDS PER SQUARE INCH PER 100 FEET OF SCHEDULE 40 PIPE FOR AIR AT 100 POUNDS PER SQUARE INCH GAUGE PRESSURE AND 60°F TEMPERATURE									
Cubic Feet Per Minute at 60°F and 14.7 psia	Cubic Feet Per Minute at 60°F and 100 psig	1/8"	1/4"	3/8"	1/2"	3/4"	1"	1-1/4"	1-1/2"	2"	
1	0.128	0.361	0.083	0.018	0.020	3/4"	1"	1-1/4"	1-1/2"	2"	
2	0.256	1.31	0.285	0.064	0.020						
3	0.384	3.06	0.605	0.133	0.042						
4	0.513	4.83	1.04	0.226	0.071						
5	0.641	7.45	1.58	0.343	0.108						
6	0.769	10.6	2.23	0.408	0.148	0.037	1-1/4"	1-1/2"	2"		
8	1.025	18.6	3.89	0.848	0.255	0.062				0.019	
10	1.282	28.7	5.96	1.26	0.356	0.094				0.029	
15	1.922	...	13.0	2.73	0.834	0.201				0.062	
20	2.563	...	22.8	4.76	1.43	0.345				0.102	
25	3.204	...	35.6	7.34	2.21	0.526	0.156	0.039	0.019		
30	3.845	...	...	10.5	3.15	0.748	0.219	0.055	0.026		
35	4.486	...	...	14.2	4.24	1.00	0.293	0.073	0.035		
40	5.126	...	...	18.4	5.49	1.30	0.379	0.095	0.044		
45	5.767	...	...	23.1	6.90	1.62	0.474	0.116	0.055		
50	6.408	2-1/2"	...	28.5	8.49	1.99	0.578	0.149	0.067	0.019	
60	7.690			40.7	12.2	2.85	0.819	0.200	0.094	0.027	
70	8.971			...	16.5	3.83	1.10	0.270	0.126	0.036	
80	10.25			...	21.4	4.86	1.43	0.350	0.162	0.046	
90	11.53			...	27.0	6.25	1.80	0.437	0.203	0.058	

(Continued on facing page.)

To determine the cubic feet per minute of compressed air at any temperature and pressure other than standard conditions, multiply the value of cubic feet per minute of free air by the ratio:

$$\left(\frac{14.7}{14.7 + P} \right) \left(\frac{460 + t}{520} \right)$$

Calculations for Pipe Other than Schedule 40

To determine the velocity of water, or the pressure drop of water or air, through pipe other than Schedule 40, use the following formulas:

$$v_a = v_{40} \left(\frac{d_{40}}{d_a} \right)^2$$

$$\Delta P_a = \Delta P_{40} \left(\frac{d_{40}}{d_a} \right)^5$$

Subscript "a" refers to the Schedule of pipe through which velocity or pressure drop is desired.

Subscript "40" refers to the velocity or pressure drop through Schedule 40 pipe, as given in the tables on pages 156 through 163.

		(2-1/2")			(1/2")	(3/4")	(1")	(1-1/4")	(1-1/2")	(2")
100	12.82	0.029	3"		33.2	7.69	2.21	0.534	0.247	0.070
125	18.02	0.044			...	11.9	3.39	0.828	0.380	0.107
150	19.22	0.062			...	17.0	4.87	1.17	0.537	0.151
175	22.43	0.083			...	23.1	6.80	1.58	0.727	0.205
200	25.63	0.107	3-1/2"		...	30.0	8.54	2.05	0.937	0.264
225	28.84	0.134				37.9	10.8	2.59	1.19	0.331
250	32.04	0.164				...	13.3	3.18	1.45	0.404
275	35.24	0.191				...	16.0	3.83	1.75	0.484
300	38.45	0.232	4"			...	19.0	4.56	2.07	0.573
325	41.65	0.270				...	22.3	5.32	2.42	0.673
350	44.87	0.313				...	25.8	6.17	2.80	0.776
375	48.06	0.356			0.030	...	29.6	7.05	3.20	0.887
400	51.28	0.402	4-1/2"		0.034	...	33.6	8.02	3.64	1.00
425	54.47	0.452			0.038	...	37.9	9.01	4.09	1.13
450	57.67	0.507			0.042	...	...	10.2	4.59	1.26
475	60.88	0.562			0.047	...	...	11.3	5.09	1.40
500	64.08	0.623	5"		0.052	...	...	12.5	5.61	1.55
550	70.49	0.749			0.062	...	...	15.1	6.79	1.87
600	76.90	0.887			0.073	...	...	18.0	8.04	2.21
650	83.30	1.04			0.086	...	...	21.1	9.43	2.60
700	89.71	1.19	6"		0.099	0.032	...	24.3	10.9	3.00
750	96.12	1.36			0.118	0.036	...	27.9	12.6	3.44
800	102.5	1.55			0.127	0.041	...	31.8	14.2	3.90
850	108.9	1.74			0.144	0.046	...	35.9	16.0	4.40
900	115.3	1.95	8"		0.160	0.051	...	40.2	18.0	4.91
950	121.8	2.18			0.178	0.057	0.023	...	20.0	5.47
1,000	128.2	2.40			0.197	0.063	0.025	...	22.1	6.06
1,100	141.0	2.89			0.236	0.075	0.030	...	26.7	7.29
1,200	153.8	3.44	10"		0.279	0.089	0.035	...	31.8	8.63
1,300	166.6	4.01			0.327	0.103	0.041	...	37.3	10.1

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Extracted from Technical Paper No. 410, *Flow of Fluids*, with permission of Crane Co.

Flow of Air Through Schedule 40 Steel Pipe (Continued)

FREE AIR q' _m	COMPRESSED AIR	PRESSURE DROP OF AIR IN POUNDS PER SQUARE INCH PER 100 FEET OF SCHEDULE 40 PIPE FOR AIR AT 100 POUNDS PER SQUARE INCH GAUGE PRESSURE AND 60°F TEMPERATURE									
Cubic Feet Per Minute at 60°F and 14.7 psia	Cubic Feet Per Minute at 60°F and 100 psig	2-1/2"	3"	3-1/2"	4"	5"	6"	8"	10"	12"	
1,400	179.4	4.65	1.52	0.718	0.377	0.119	0.047			11.8	
1,500	192.2	5.31	1.74	0.824	0.431	0.136	0.054			13.5	
1,600	205.1	6.04	1.97	0.932	0.490	0.154	0.061			15.3	
1,800	230.7	7.65	2.50	1.18	0.616	0.193	0.075			19.3	
2,000	256.3	9.44	3.06	1.45	0.757	0.237	0.094	0.023		23.9	
2,500	320.4	14.7	4.76	2.25	1.17	0.366	0.143	0.035	10"	37.3	
3,000	384.5	21.1	6.82	3.20	1.67	0.524	0.204	0.051	0.016		
3,500	448.6	28.8	9.23	4.33	2.26	0.709	0.276	0.068	0.022		
4,000	512.6	37.6	12.1	5.66	2.94	0.919	0.358	0.088	0.028		
4,500	576.7	47.6	15.3	7.16	3.69	1.16	0.450	0.111	0.035	12"	
5,000	640.8	...	18.8	8.88	4.56	1.42	0.552	0.136	0.043	0.018	
6,000	769.0	...	27.1	12.7	6.57	2.03	0.794	0.196	0.061	0.025	
7,000	897.1	...	36.9	17.2	8.94	2.76	1.07	0.262	0.082	0.034	
8,000	1026	...	...	22.5	11.7	3.59	1.39	0.339	0.107	0.044	
9,000	1153	...	...	28.5	14.9	4.84	1.76	0.427	0.134	0.055	
10,000	1282	...	...	35.2	18.4	5.60	2.16	0.526	0.164	0.067	
11,000	1410	...	...	...	22.2	6.78	2.62	0.633	0.197	0.081	
12,000	1538	...	...	...	26.4	8.07	3.09	0.753	0.234	0.096	
13,000	1666	...	...	...	31.0	9.47	3.63	0.884	0.273	0.112	
14,000	1794	...	...	...	36.0	11.0	4.21	1.02	0.316	0.129	

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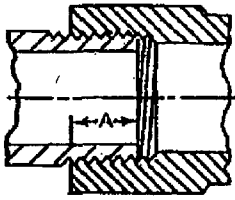
						(5")	(6")	(8")	(10")	(12")
15,000	1922	...	...	...	...	12.6	4.84	1.17	0.364	0.148
16,000	2051	...	...	...	...	14.3	5.50	1.33	0.411	0.167
18,000	2307	...	...	...	...	18.2	6.96	1.68	0.520	0.213
20,000	2563	...	...	...	...	22.4	8.60	2.01	0.642	0.260
22,000	2820	...	...	...	...	27.1	10.4	2.50	0.771	0.314
24,000	3076	...	...	...	...	32.3	12.4	2.97	0.918	0.371
26,000	3332	...	...	...	...	37.9	14.5	3.49	1.12	0.435
28,000	3588	...	...	...	...	...	16.9	4.04	1.25	0.505
30,000	3845	...	...	...	...	...	19.3	4.64	1.42	0.520

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Section 8

Pipe Data

Pipe Engagement Length of Thread on Pipe to Make a Tight Joint

	Nominal Pipe Size (Inches)	Dimension A (Inches)	Nominal Pipe Size (Inches)	Dimension A (Inches)
	1/8	1/4	1-1/2	11/16
	1/4	3/8	2	3/4
	3/8	3/8	2-1/2	15/16
	1/2	1/2	3	1
	3/4	9/16	4	1-1/8
	1	11/16	5	1-1/4
	1-1/4	11/16	6	1-5/16

Dimensions do not allow for variation in tapping or threading.

Drill Sizes for Pipe Taps

Nominal Pipe Size (Inches)	Tap Drill Size (Inches)	Nominal Pipe Size (Inches)	Tap Drill Size (Inches)
1/8	11/32	1-1/2	1-23/32
1/4	7/16	2	2-3/16
3/8	19/32	2-1/2	2-9/16
1/2	23/32	3	3-3/16
3/4	15/16	4	4-3/16
1	1-5/32	5	5-5/16
1-1/4	1-1/2	6	6-5/16

Pipe Data

Carbon and Alloy Steel—Stainless Steel

Identification, wall thickness and weights are extracted from ANSI B36.10 and B39.19. The notations STD, XS, and XXS indicate Standard, Extra Strong, and Double Extra Strong pipe respectively.

Transverse internal area values listed in "square feet" also represent volume in cubic feet per foot of pipe length.

NOMINAL PIPE SIZE (INCHES)	OUTSIDE DIAM. (INCHES)	IDENTIFICATION			WALL THICK- NESS (t) (INCHES)	INSIDE DIAM- ETER (d) (INCHES)	AREA OF METAL (SQUARE INCHES)	TRANSVERSE INTERNAL AREA		WEIGHT PIPE (POUNDS PER FOOT)	WEIGHT WATER (POUNDS PER FOOT OF PIPE)
		Steel		Stainless Steel Sched. No.				(a) (Square Inches)	(A) (Square Feet)		
		Iron Pipe Size	Sched. No.								
1/8	0.405	...	...	10S	0.049	0.307	0.0548	0.0740	0.00051	0.19	0.032
		STD	40	40S	0.068	0.269	0.0720	0.0568	0.00040	0.24	0.025
		XS	80	80S	0.095	0.215	0.0925	0.0364	0.00025	0.31	0.016
1/4	0.540	...	...	10S	0.065	0.410	0.0970	0.1320	0.00091	0.33	0.057
		STD	40	40S	0.088	0.364	0.1250	0.1041	0.00072	0.42	0.045
		XS	80	80S	0.119	0.302	0.1574	0.0718	0.00050	0.54	0.031
3/8	0.675	...	...	10S	0.065	0.545	0.1246	0.2333	0.00162	0.42	0.101
		STD	40	40S	0.091	0.493	0.1670	0.1910	0.00133	0.57	0.083
		XS	80	80S	0.126	0.423	0.2173	0.1405	0.00098	0.74	0.061
1/2	0.840	...	...	5S	0.065	0.710	0.1583	0.3959	0.00275	0.54	0.172
		...	...	10S	0.083	0.674	0.1974	0.3568	0.00248	0.67	0.155
		STD	40	40S	0.109	0.622	0.2503	0.3040	0.00211	0.85	0.132
		XS	80	80S	0.147	0.546	0.3200	0.2340	0.00163	1.09	0.102
		...	160	...	0.187	0.466	0.3835	0.1706	0.00118	1.31	0.074
		XXS	...	...	0.294	0.252	0.5043	0.050	0.00035	1.71	0.022

Pipe Data
Carbon and Alloy Steel—Stainless Steel

NOMINAL PIPE SIZE (INCHES)	OUTSIDE DIAM. (INCHES)	IDENTIFICATION			WALL THICK- NESS (t) (INCHES)	INSIDE DIAM- ETER (d) (INCHES)	AREA OF METAL (SQUARE INCHES)	TRANSVERSE INTERNAL AREA		WEIGHT PIPE (POUNDS PER FOOT)	WEIGHT WATER (POUNDS PER FOOT OF PIPE)
		Steel		Stainless Steel Sched. No.				(a) (Square Inches)	(A) (Square Feet)		
		Iron Pipe Size	Sched. No.								
2-1/2	2.875	...	...	5S	0.083	2.709	0.7280	5.764	0.04002	2.48	2.50
		...	...	10S	0.120	2.635	1.039	5.453	0.03787	3.53	2.36
		STD	40	40S	0.203	2.469	1.704	4.788	0.03322	5.79	2.07
		XS	80	80S	0.276	2.323	2.254	4.238	0.02942	7.66	1.87
		...	160	...	0.375	2.125	2.945	3.546	0.02463	10.01	1.54
		XXS	...	...	0.552	1.771	4.028	2.464	0.01710	13.69	1.07
3	3.500	...	...	5S	0.083	3.334	0.8910	8.730	0.06063	3.03	3.78
		...	...	10S	0.120	3.260	1.274	8.347	0.05796	4.33	3.62
		STD	40	40S	0.216	3.068	2.228	7.393	0.05130	7.68	3.20
		XS	80	80S	0.300	2.900	3.016	6.605	0.04587	10.25	2.86
		...	160	...	0.438	2.624	4.205	5.408	0.03755	14.32	2.35
		XXS	...	...	0.600	2.300	5.466	4.155	0.02885	18.58	1.80
3-1/2	4.000	...	...	5S	0.083	3.834	1.021	11.545	0.08017	3.48	5.00
		...	...	10S	0.120	3.760	1.463	11.104	0.07711	4.97	4.81
		STD	40	40S	0.226	3.548	2.680	9.886	0.06870	9.11	4.29
		XS	80	80S	0.318	3.364	3.678	8.888	0.06170	12.50	3.84
4	4.500	...	...	5S	0.083	4.334	1.152	14.75	0.10245	3.92	6.39
		...	...	10S	0.120	4.260	1.651	14.25	0.09898	5.61	6.18
		STD	40	40S	0.237	4.026	3.174	12.73	0.08840	10.79	5.50
		XS	80	80S	0.337	3.826	4.407	11.50	0.07986	14.98	4.98
		...	120	...	0.438	3.624	5.595	10.31	0.0716	19.00	4.47
		...	160	...	0.531	3.438	6.621	9.28	0.0645	22.51	4.02
		XXS	...	...	0.674	3.152	8.101	7.80	0.0542	27.54	3.38

5	5.563	...	...	5S	0.109	5.345	1.868	22.44	0.1558	6.36	9.72
		...	...	10S	0.134	5.295	2.285	22.02	0.1529	7.77	9.54
		STD	40	40S	0.258	5.047	4.300	20.01	0.1390	14.62	8.67
		XS	80	80S	0.375	4.813	6.112	18.19	0.1283	20.78	7.88
		...	120	...	0.500	4.583	7.953	16.35	0.1136	27.04	7.09
		...	160	...	0.625	4.313	9.696	14.61	0.1015	32.96	6.33
6	6.625	XXS	...	...	0.750	4.063	11.340	12.97	0.0901	38.55	5.61
		...	...	5S	0.109	6.407	2.231	32.24	0.2239	7.60	13.97
		...	...	10S	0.134	6.357	2.733	31.74	0.2204	9.29	13.75
		STD	40	40S	0.280	6.065	5.581	28.89	0.2006	18.97	12.51
		XS	80	80S	0.432	5.761	8.405	26.07	0.1810	28.57	11.29
		...	120	...	0.562	5.501	10.70	23.77	0.1650	36.39	10.30
8	8.625	...	160	...	0.719	5.187	13.32	21.15	0.1469	45.35	9.16
		XXS	...	...	0.864	4.897	15.64	18.84	0.1308	53.16	8.16
		...	...	5S	0.109	8.407	2.916	55.51	0.3855	9.93	24.06
		...	...	10S	0.148	8.329	3.941	54.48	0.3784	13.40	23.61
		...	20	...	0.250	8.125	6.57	51.85	0.3601	22.36	22.47
		...	30	...	0.277	8.071	7.26	51.16	0.3553	24.70	22.17
		STD	40	40S	0.322	7.981	8.40	50.03	0.3474	28.55	21.70
		...	60	...	0.406	7.813	10.48	47.94	0.3329	35.64	20.77
		XS	80	80S	0.500	7.625	12.76	45.66	0.3171	43.39	19.78
		...	100	...	0.594	7.437	14.96	43.46	0.3018	50.95	18.83
		...	120	...	0.719	7.187	17.84	40.59	0.2819	60.71	17.59
		...	140	...	0.812	7.001	19.93	38.50	0.2673	67.76	16.68
10 (Cont.)	10.750	XXS	...	...	0.875	6.875	21.30	37.12	0.2578	72.42	16.10
		...	160	...	0.906	6.813	21.97	36.46	0.2532	74.69	15.80
		...	...	5S	0.134	10.482	4.36	86.29	0.5992	15.19	37.39
		...	...	10S	0.165	10.420	5.49	85.28	0.5922	18.65	36.95
		...	20	...	0.250	10.250	8.24	82.52	0.5731	28.04	35.76
		...	30	...	0.307	10.138	10.07	80.69	0.5603	34.24	34.96
		STD	40	40S	0.365	10.020	11.90	78.86	0.5475	40.48	34.20

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Pipe Data
Carbon and Alloy Steel—Stainless Steel

NOMINAL PIPE SIZE (INCHES)	OUTSIDE DIAM. (INCHES)	IDENTIFICATION			WALL THICK- NESS (t) (INCHES)	INSIDE DIAM- ETER (d) (INCHES)	AREA OF METAL (SQUARE INCHES)	TRANSVERSE INTERNAL AREA		WEIGHT PIPE (POUNDS PER FOOT)	WEIGHT WATER (POUNDS PER FOOT OF PIPE)
		Steel		Stainless Steel Sched. No.				(a) (Square Inches)	(A) (Square Feet)		
		Iron Pipe Size	Sched. No.								
10 (Cont.)	10.750	XS	60	80S	0.500	9.750	16.10	74.66	0.5185	54.74	32.35
		...	80	...	0.594	9.562	18.92	71.84	0.4989	64.43	31.13
		...	100	...	0.719	9.312	22.63	68.13	0.4732	77.03	29.53
		...	120	...	0.844	9.062	26.24	64.53	0.4481	89.29	27.96
		XXS	140	...	1.000	8.750	30.63	60.13	0.4176	104.13	26.06
		...	160	...	1.125	8.500	34.02	56.75	0.3941	115.64	24.59
12	12.75	...	...	5S	0.156	12.438	6.17	121.50	0.8438	20.98	52.65
		...	...	10S	0.180	12.390	7.11	120.57	0.8373	24.17	52.25
		...	20	...	0.250	12.250	9.82	117.86	0.8186	33.38	51.07
		...	30	...	0.330	12.090	12.87	114.80	0.7972	43.77	49.74
		STD	...	40S	0.375	12.000	14.58	113.10	0.7854	49.56	49.00
		...	40	...	0.406	11.938	15.77	111.93	0.7773	53.52	48.50
		XS	...	80S	0.500	11.750	19.24	108.43	0.7528	65.42	46.92
		...	60	...	0.562	11.626	21.52	106.16	0.7372	73.15	46.00
		...	80	...	0.688	11.374	26.03	101.64	0.7058	88.63	44.04
		...	100	...	0.844	11.062	31.53	96.14	0.6677	107.32	41.66
		XXS	120	...	1.000	10.750	36.91	90.76	0.6303	125.49	39.33
		...	140	...	1.125	10.500	41.08	86.59	0.6013	139.67	37.52
		...	160	...	1.312	10.126	47.14	80.53	0.5592	160.27	34.89
14 (Cont.)	14.00	...	...	5S	0.156	13.688	6.78	147.15	1.0219	23.07	63.77
		...	...	10S	0.188	13.624	8.16	145.78	1.0124	27.73	63.17
		...	10	...	0.250	13.500	10.80	143.14	0.9940	36.71	62.03
		...	20	...	0.312	13.376	13.42	140.52	0.9758	45.61	60.89
		STD	30	...	0.375	13.250	16.05	137.88	0.9575	54.67	59.75
		...	40	...	0.438	13.124	18.66	135.28	0.9394	63.44	58.64

14 (Cont.)	14.00	XS	...	...	0.500	13.000	21.21	132.73	0.9217	72.09	57.46
		...	60	...	0.594	12.812	24.98	128.96	0.8958	85.05	55.86
		...	80	...	0.750	12.500	31.22	122.72	0.8522	106.13	53.18
		...	100	...	0.938	12.124	38.45	115.49	0.8020	130.85	50.04
		...	120	...	1.094	11.812	44.32	109.62	0.7612	150.79	47.45
		...	140	...	1.250	11.500	50.07	103.87	0.7213	170.28	45.01
		...	160	...	1.406	11.188	55.63	98.31	0.6827	189.11	42.60
16	16.00	...	...	5S	0.165	15.670	8.21	192.85	1.3393	27.90	83.57
		...	...	10S	0.188	15.624	9.34	191.72	1.3314	31.75	83.08
		...	10	...	0.250	15.500	12.37	188.69	1.3103	42.05	81.74
		...	20	...	0.312	15.376	15.38	185.69	1.2895	52.27	80.50
		STD	30	...	0.375	15.250	18.41	182.65	1.2684	62.58	79.12
		XS	40	...	0.500	15.000	24.35	176.72	1.2272	82.77	76.58
		...	60	...	0.656	14.688	31.62	169.44	1.1766	107.50	73.42
		...	80	...	0.844	14.312	40.14	160.92	1.1176	136.81	69.73
		...	100	...	1.031	13.938	48.48	152.58	1.0596	164.82	66.12
		...	120	...	1.219	13.562	56.56	144.50	1.0035	192.43	62.62
		...	140	...	1.438	13.124	65.78	135.28	0.9394	223.64	58.64
		...	160	...	1.694	12.812	72.10	128.96	0.8956	245.25	55.83
18	18.00	...	...	5S	0.165	17.670	9.25	245.22	1.7029	31.43	106.26
		...	...	10S	0.188	17.624	10.52	243.95	1.6941	35.76	105.71
		...	10	...	0.250	17.500	13.94	240.53	1.6703	47.39	104.21
		...	20	...	0.312	17.376	17.34	237.13	1.6467	58.94	102.77
		STD	...	...	0.375	17.250	20.76	233.71	1.6230	70.59	101.18
		...	30	...	0.438	17.124	24.17	230.30	1.5990	82.15	99.84
		XS	...	...	0.500	17.000	27.49	226.88	1.5763	93.45	98.27
		...	40	...	0.562	16.876	30.79	223.68	1.5533	104.67	96.93
		...	60	...	0.750	16.500	40.64	213.83	1.4849	138.17	92.57
		...	80	...	0.938	16.124	50.23	204.24	1.4183	170.92	88.50
		...	100	...	1.156	15.688	61.17	193.30	1.3423	207.98	83.76
		...	120	...	1.375	15.250	71.81	182.66	1.2684	244.14	79.07
		...	140	...	1.562	14.876	80.66	173.80	1.2070	274.22	75.32
		...	160	...	1.781	14.438	90.75	163.72	1.1368	308.50	70.88

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Pipe Data
Carbon and Alloy Steel—Stainless Steel

NOMINAL PIPE SIZE (INCHES)	OUTSIDE DIAM. (INCHES)	IDENTIFICATION			WALL THICK- NESS (t) (INCHES)	INSIDE DIAM- ETER (d) (INCHES)	AREA OF METAL (SQUARE INCHES)	TRANSVERSE INTERNAL AREA		WEIGHT PIPE (POUNDS PER FOOT)	WEIGHT WATER (POUNDS PER FOOT OF PIPE)
		Steel		Stainless Steel Sched. No.				(a) (Square Inches)	(A) (Square Feet)		
		Iron Pipe Size	Sched. No.								
20	20.00	...	...	5S	0.188	19.824	11.70	302.46	2.1004	39.78	131.06
		...	...	10S	0.218	19.564	13.55	300.61	2.0876	46.06	130.27
		...	10	...	0.250	19.500	15.51	298.65	2.0740	52.73	129.42
		STD	20	...	0.375	19.250	23.12	290.04	2.0142	78.60	125.67
		XS	30	...	0.500	19.000	30.63	283.53	1.9890	104.13	122.87
		...	40	...	0.594	18.812	36.15	278.00	1.9305	123.11	120.46
		...	60	...	0.812	18.376	48.95	265.21	1.8417	166.40	114.92
		...	80	...	1.031	17.938	61.44	252.72	1.7550	208.87	109.51
		...	100	...	1.281	17.438	75.33	238.83	1.6586	256.10	103.39
		...	120	...	1.500	17.000	87.18	226.98	1.5762	296.37	98.35
		...	140	...	1.750	16.500	100.33	213.82	1.4849	341.09	92.66
		...	160	...	1.989	16.062	111.49	202.67	1.4074	379.17	87.74
22	22.00	...	...	5S	0.188	21.624	12.88	367.25	2.5503	43.80	159.14
		...	...	10S	0.218	21.564	14.92	365.21	2.5362	50.71	158.26
		...	10	...	0.250	21.500	17.08	363.05	2.5212	58.07	157.32
		STD	20	...	0.375	21.250	25.48	354.66	2.4629	86.61	153.68
		XS	30	...	0.500	21.000	33.77	346.36	2.4053	114.81	150.09
		...	60	...	0.875	20.250	58.07	322.06	2.2365	197.41	139.56
		...	80	...	1.125	19.75	73.78	306.35	2.1275	250.81	132.76
		...	100	...	1.375	19.25	89.09	291.04	2.0211	302.88	126.12
		...	120	...	1.625	18.75	104.02	276.12	1.9175	353.61	119.65
		...	140	...	1.875	18.25	118.55	261.59	1.8166	403.00	113.86
		...	160	...	2.125	17.75	132.68	247.45	1.7184	451.06	107.23

24	24.00	...	...	5S	0.218	23.564	16.29	436.10	3.0285	55.37	188.98
		...	10	10S	0.250	23.500	18.65	433.74	3.0121	63.41	187.95
		STD	20	...	0.375	23.250	27.83	424.56	2.9483	94.62	183.95
		XS	...	...	0.500	23.000	36.91	415.48	2.8853	125.49	179.87
		...	30	...	0.562	22.876	41.39	411.00	2.8542	140.68	178.09
		...	40	...	0.688	22.624	50.31	402.07	2.7921	171.29	174.23
		...	80	...	0.969	22.062	70.04	382.35	2.6552	238.35	165.52
		...	80	...	1.219	21.562	87.17	365.22	2.5362	296.58	168.26
		...	100	...	1.531	20.938	108.07	344.32	2.3911	367.39	149.06
		...	120	...	1.812	20.376	126.31	326.08	2.2645	429.39	141.17
26	26.00	...	10	...	0.312	25.376	25.18	505.75	3.5122	85.60	219.16
		STD	...	...	0.375	25.250	30.19	500.74	3.4774	102.63	216.99
		XS	20	...	0.500	25.000	40.08	490.87	3.4088	136.17	212.71
		...	30	...	0.625	24.750	53.75	482.00	3.3028	182.73	203.53
28	28.00	...	10	...	0.312	27.376	27.14	588.81	4.0876	92.26	255.07
		STD	...	...	0.375	27.250	32.54	583.21	4.0501	110.64	252.73
		XS	20	...	0.500	27.000	43.20	572.56	3.9761	146.85	248.11
		...	30	...	0.625	26.750	53.75	562.00	3.9028	182.73	243.53
30	30.00	...	...	5S	0.250	29.500	23.37	683.49	4.7465	79.43	296.18
		...	10	10S	0.312	29.376	28.10	677.76	4.7067	98.93	293.70
		STD	...	...	0.375	29.250	34.90	671.96	4.6664	118.85	291.18
		XS	20	...	0.500	29.000	46.34	660.52	4.5869	157.53	286.22
		...	30	...	0.625	28.750	57.68	649.18	4.5082	196.08	281.31
32	32.00	...	10	...	0.312	31.376	31.06	773.19	5.3694	105.59	335.05
		STD	...	...	0.375	31.250	37.26	766.99	5.3263	126.66	332.36
		XS	20	...	0.500	31.000	49.48	754.77	5.2414	168.21	327.06
		...	30	...	0.625	30.750	61.60	742.64	5.1572	209.43	321.81
		...	40	...	0.688	30.624	67.68	736.57	5.1151	230.08	319.18

- Continued -

Extracted from Technical Paper No. 410, *Flow of Fluids*, with permission of Crane Co.

American Pipe Flange Dimensions
Diameter of Bolt Circle—Inches
Per ANSI B16.1, B16.5, and B16.24

Nominal Pipe Size (Inches)	ANSI Class* 125 (Cast Iron) or Class 150 (Steel)	ANSI Class† 250 (Cast Iron) or Class 300 (Steel)	ANSI Class 600	ANSI Class 900	ANSI Class 1500	ANSI Class 2500
1	3.12	3.50	3.50	4.00	4.00	4.25
1-1/4	3.50	3.88	3.88	4.38	4.38	5.12
1-1/2	3.88	4.50	4.50	4.88	4.88	5.75
2	4.75	5.00	5.00	6.50	6.50	6.75
2-1/2	5.50	5.88	5.88	7.50	7.50	7.75
3	6.00	6.62	6.62	7.50	8.00	9.00
4	7.60	7.88	8.50	9.25	9.50	10.75
5	8.50	9.25	10.50	11.00	11.50	12.75
6	9.50	10.62	11.50	12.50	12.50	14.50
8	11.75	13.00	13.75	15.50	15.50	17.25
10	14.25	15.25	17.00	18.50	19.00	21.75
12	17.00	17.75	19.25	21.00	22.50	24.38
14	18.75	20.25	20.75	22.00	25.00	...
16	21.25	22.50	23.75	24.25	27.75	...
18	22.75	24.75	25.75	27.00	30.50	...
20	25.00	27.00	28.50	29.50	32.75	...
24	29.50	32.00	33.00	35.50	39.00	...
30	36.00	39.25	...	...	...	...
36	42.75	46.00	...	...	...	...
42	49.50	52.75	...	...	...	...
48	56.00	60.75	...	...	...	...

* Sizes 1-inch through 12-inch also apply to ANSI Class 150 bronze flanges.
† Sizes 1-inch through 8-inch also apply to ANSI Class 300 bronze flanges.

American Pipe Flange Dimensions
Number of Stud Bolts and Diameter in Inches
Per ANSI B16.1, B16.5, and B16.24

NOMINAL PIPE SIZE (INCHES)	ANSI CLASS* 125 (CAST IRON) OR CLASS 150 (STEEL)		ANSI CLASS† 250 (CAST IRON) OR CLASS 300 (STEEL)		ANSI CLASS 600		ANSI CLASS 900		ANSI CLASS 1500		ANSI CLASS 2500	
	No.	Dia.	No.	Dia.	No.	Dia.	No.	Dia.	No.	Dia.	No.	Dia.
1	4	0.50	4	0.62	4	0.62	4	0.88	4	0.88	4	0.88
1-1/4	4	0.50	4	0.62	4	0.62	4	0.88	4	0.88	4	1.00
1-1/2	4	0.50	4	0.75	4	0.75	4	1.00	4	1.00	4	1.12
2	4	0.62	8	0.62	8	0.62	8	0.88	8	0.88	8	1.00
2-1/2	4	0.62	8	0.75	8	0.75	8	1.00	8	1.00	8	1.12
3	4	0.62	8	0.75	8	0.75	8	0.88	8	1.12	8	1.25
4	8	0.62	8	0.75	8	0.75	8	1.12	8	1.25	8	1.50
5	8	0.75	8	0.75	8	1.00	8	1.25	8	1.50	8	1.75
6	8	0.75	12	0.75	12	1.00	12	1.12	12	1.38	8	2.00
8	8	0.75	12	0.88	12	1.12	12	1.38	12	1.62	12	2.00
10	12	0.88	16	1.00	16	1.25	16	1.38	12	1.88	12	2.50
12	12	0.88	16	1.12	20	1.25	20	1.38	16	2.00	12	2.75
14	12	1.00	20	1.12	20	1.38	20	1.50	16	2.25	...	...
16	16	1.00	20	1.25	20	1.50	20	1.62	16	2.50	...	...
18	16	1.12	24	1.25	20	1.62	20	1.88	16	2.75	...	...
20	20	1.12	24	1.25	24	1.62	20	2.00	16	3.00	...	...
24	20	1.25	24	1.50	24	1.88	20	2.50	16	3.50	...	...
30	28	1.25	28	1.75	...	...	...	...	...	...	...	...
36	32	1.50	32	2.00	...	...	...	...	...	...	...	...
42	36	1.50	36	2.00	...	...	...	...	...	...	...	...
48	44	1.50	40	2.00	...	...	...	...	...	...	...	...

* Sizes 1-inch through 12-inch also apply to ANSI Class 150 bronze flanges.
† Sizes 1-inch through 8-inch also apply to ANSI Class 300 bronze flanges.

American Pipe Flange Dimensions
Flange Diameter—Inches
Per ANSI B16.1, B16.5, and B16.24

Nominal Pipe Size	ANSI Class* 125 (Cast Iron) or Class 150 (Steel)	ANSI Class† 250 (Cast Iron) or Class 300 (Steel)	ANSI Class 600	ANSI Class 900	ANSI Class 1500	ANSI Class 2500
1	4.25	4.88	4.88	5.88	5.88	6.25
1-1/4	4.62	5.25	5.25	6.25	6.25	7.25
1-1/2	5.00	6.12	6.12	7.00	7.00	8.00
2	6.00	6.50	6.50	8.50	8.50	9.25
2-1/2	7.00	7.50	7.50	9.62	9.62	10.50
3	7.50	8.25	8.25	9.50	10.50	12.00
4	9.00	10.00	10.75	11.50	12.25	14.00
5	10.00	11.00	13.00	13.75	14.75	16.50
6	11.00	12.50	14.00	15.00	15.50	19.00
8	13.50	15.00	16.50	18.50	19.00	21.75
10	16.00	17.50	20.00	21.50	23.00	26.50
12	19.00	20.50	22.00	24.00	26.50	30.00
14	21.00	23.00	23.75	25.25	29.50	...
16	23.50	25.50	27.00	27.75	32.50	...
18	25.00	28.00	29.25	31.00	36.00	...
20	27.50	30.50	32.00	33.75	38.75	...
24	32.00	36.00	37.00	41.00	46.00	...
30	38.75	43.00	...	...	...	...
36	46.00	50.00	...	...	...	...
42	53.00	57.00	...	...	...	...
48	59.50	65.00	...	...	...	...

*Sizes 1-inch through 12-inch also apply to ANSI Class 150 bronze flanges.
†Sizes 1-inch through 8-inch also apply to ANSI Class 300 bronze flanges.

American Pipe Flange Dimensions
 Flange Thickness—Inches
 Per ANSI B16.1, B16.5, and B16.24

NOMINAL PIPE SIZE	ANSI CLASS 125 CAST IRON (FF) CLASS 150 STEEL (RF)	ANSI CLASS 150 STEEL (RTJ)	ANSI CLASS 150 BRONZE	ANSI CLASS 250 CAST IRON AND CLASS 300 STEEL	ANSI CLASS 300 STEEL	ANSI CLASS 300 BRONZE	ANSI CLASS 600		ANSI CLASS 900		ANSI CLASS 1500		ANSI CLASS 2500	
				RF	RTJ		RF	RTJ	RF	RTJ	RF	RTJ	RF	RTJ
1	0.44	0.69	0.38	0.69	0.94	0.69	0.94	0.94	1.38	1.38	1.38	1.38	1.62	1.62
1-1/4	0.50	0.75	0.41	0.75	1.00	0.82	1.08	1.08	1.38	1.38	1.38	1.38	1.75	1.81
1-1/2	0.56	0.81	0.44	0.81	1.06	0.89	1.12	1.12	1.50	1.50	1.50	1.50	2.00	2.06
2	0.62	0.88	0.50	0.88	1.19	0.75	1.25	1.31	1.75	1.81	1.75	1.81	2.25	2.31
2-1/2	0.69	0.94	0.56	1.00	1.31	0.81	1.38	1.44	1.88	1.94	1.88	1.94	2.50	2.62
3	0.75	1.00	0.62	1.12	1.44	0.91	1.50	1.58	1.75	1.81	2.12	2.19	2.88	3.00
4	0.94	1.19	0.89	1.25	1.58	1.06	1.75	1.81	2.00	2.06	2.38	2.44	3.25	3.44
5	0.94	1.19	0.75	1.38	1.69	1.12	2.00	2.06	2.25	2.31	3.12	3.19	3.88	4.12
6	1.00	1.25	0.81	1.44	1.75	1.19	2.12	2.18	2.44	2.50	3.50	3.62	4.50	4.75
8	1.12	1.38	0.94	1.62	1.94	1.38	2.44	2.60	2.75	2.81	3.88	4.06	5.25	5.56
10	1.19	1.44	1.00	1.88	2.19	...	2.75	2.81	3.00	3.06	4.50	4.69	6.75	7.19
12	1.25	1.50	1.06	2.00	2.31	...	2.88	2.94	3.38	3.44	5.12	5.44	7.50	7.94
14	1.38	1.62	...	2.12	2.44	...	3.00	3.06	3.62	3.81	5.50	5.88	...	...
16	1.44	1.89	...	2.25	2.56	...	3.25	3.31	3.75	3.94	6.00	6.44	...	...
18	1.56	1.81	...	2.38	2.69	...	3.50	3.56	4.25	4.50	6.62	7.06	...	...
20	1.69	1.94	...	2.50	2.88	...	3.75	3.88	4.50	4.75	7.25	7.69	...	...
24	1.88	2.12	...	2.75	3.19	...	4.25	4.44	5.75	6.12	8.25	8.81	...	...
30	2.12	...	...	3.00	...	...	...	...	...	...	...	...	...	...
36	2.38	...	...	3.38	...	...	...	...	...	...	...	...	...	...
42	2.62	...	...	3.69	...	...	...	...	...	...	...	...	...	...
48	2.75	...	...	4.00	...	...	...	...	...	...	...	...	...	...

Section 8/Pipe Data

DIN Standards

DIN Cast Steel Valve Ratings*

NOMINAL PRESSURE (BAR)	PERMISSIBLE WORKING PRESSURE (BAR) AT TEMP. SHOWN					
	-10°C to 120°C	200°C	250°C	300°C	350°C	400°C
16	16	14	13	11	10	8
25	25	22	20	17	16	13
40	40	35	32	28	24	21
64	64	50	45	40	36	32
100	100	80	70	60	56	50
160	160	130	112	96	90	80
250	250	200	175	150	140	125
320	320	250	225	192	180	160
400	400	320	280	240	225	200

* Hydrostatic test pressure: 1.5 times rating at 20°C.

DIN Cast Steel Flange Standard

Neandruck 16 (Nominal Pressure 16 Bar)

NOMINAL BORE	PIPE THICK- NESS	FLANGE			BOLTING		
		Outside Diameter	Thickness	Bolt Circle Diameter	Number of Bolts	Thread	Bolt Hole Diameter
10	6	90	16	60	4	M12	14
16	6	95	16	65	4	M12	14
20	6.5	105	18	75	4	M12	14
25	7	115	18	85	4	M12	14
32	7	140	18	100	4	M16	18
40	7.5	150	18	110	4	M16	18
50	8	165	20	125	4	M16	18
65	8	185	18	145	4	M16	18
80	8.5	200	20	160	8	M16	18
100	9.5	220	20	180	8	M16	18
125	10	250	22	210	8	M16	18
150	11	285	22	240	8	M20	23
175	12	315	24	270	8	M20	23
200	12	340	24	295	12	M20	23
250	14	405	26	355	12	M24	27
300	15	460	28	410	12	M24	27
350	16	520	30	470	16	M24	27
400	18	580	32	525	16	M27	30
500	21	715	36	650	20	M30	33
600	23	840	40	770	20	M33	36
700	24	910	42	840	24	M33	36
800	26	1025	42	950	24	M36	39
900	27	1125	44	1050	28	M36	39
1000	29	1255	46	1170	28	M39	42
1200	32	1485	52	1390	32	M45	48
1400	34	1685	58	1590	36	M45	48
1600	36	1930	64	1820	40	M52	56
1800	39	2130	68	2020	44	M52	56
2000	41	2345	70	2230	48	M56	62
2200	43	2555	74	2440	52	M56	62

All dimensions in mm.

DIN Cast Steel Flange Standard
Herndruck 25 (Nominal Pressure 25 Bar)

NOMINAL BORE	PIPE THICK- NESS	FLANGE			BOLTING		
		Outside Diameter	Thickness	Bolt Circle Diameter	Number of Bolts	Thread	Bolt Hole Diameter
10	6	90	16	60	4	M12	14
15	6	95	16	65	4	M12	14
20	6.5	105	18	75	4	M12	14
25	7	115	18	85	4	M12	14
32	7	140	18	100	4	M16	18
40	7.5	150	18	110	4	M16	18
50	8	165	20	125	4	M16	18
65	8.5	185	22	145	8	M16	18
80	9	200	24	160	8	M16	18
100	10	235	24	190	8	M20	23
125	11	270	26	220	8	M24	27
150	12	300	28	250	8	M24	27
175	12	330	28	280	12	M24	27
200	12	360	30	310	12	M24	27
250	14	425	32	370	12	M27	30
300	15	485	34	430	16	M27	30
350	16	555	38	490	16	M30	33
400	18	620	40	550	16	M33	36
500	21	730	44	660	20	M33	36
600	23	845	46	770	20	M36	39
700	24	960	50	875	24	M39	42
800	26	1085	54	990	24	M45	48
900	27	1185	58	1090	28	M45	48
1000	29	1320	62	1210	28	M52	56
1200	32	1530	70	1420	32	M52	56
1400	34	1755	76	1640	36	M56	62
1600	37	1975	84	1860	40	M56	62
1800	40	2195	90	2070	44	M64	70
2000	43	2425	96	2300	48	M64	70

All dimensions in mm.

DIN Cast Steel Flange Standard
Nenndruck 40 (Nominal Pressure 40 Bar)

NOMINAL BORE	PIPE THICK- NESS	FLANGE			BOLTING		
		Outside Diameter	Thickness	Bolt Circle Diameter	Number of Bolts	Thread	Bolt Hole Diameter
10	6	90	16	60	4	M12	14
15	6	95	16	65	4	M12	14
20	6.5	105	18	75	4	M12	14
25	7	115	18	85	4	M12	14
32	7	140	18	100	4	M16	18
40	7.5	160	18	110	4	M16	18
50	8	165	20	125	4	M16	18
65	8.5	185	22	145	8	M16	18
80	9	200	24	160	8	M16	18
100	10	235	24	190	8	M20	23
125	11	270	26	220	8	M24	27
150	12	300	28	260	8	M24	27
175	13	350	32	295	12	M27	30
200	14	375	34	320	12	M27	30
250	16	450	38	385	12	M30	33
300	17	515	42	450	16	M30	33
350	19	580	46	510	16	M33	36
400	21	660	50	585	16	M36	39
450	21	685	50	610	20	M36	39
500	21	755	52	670	20	M39	42
600	24	890	60	795	20	M45	48
700	27	995	64	900	24	M45	48
800	30	1140	72	1030	24	M52	56
900	33	1250	76	1140	28	M52	56
1000	36	1360	80	1260	28	M52	56
1200	42	1575	88	1480	32	M56	62
1400	47	1795	98	1680	36	M56	62
1600	54	2025	108	1900	40	M64	70

All dimensions in mm.

DIN Cast Steel Flange Standard
Nenndruck 64 (Nominal Pressure 64 Bar)

NOMINAL BORE	PIPE THICK- NESS	FLANGE			BOLTING		
		Outside Diameter	Thickness	Bolt Circle Diameter	Number of Bolts	Thread	Bolt Hole Diameter
10	10	100	20	70	4	M12	14
15	10	105	20	75	4	M12	14
25	10	140	24	100	4	M16	18
32	12	155	24	110	4	M20	23
40	10	170	28	125	4	M20	22
50	10	180	26	135	4	M20	22
65	10	205	28	160	8	M20	22
80	11	215	28	170	8	M20	22
100	12	250	30	200	8	M24	26
125	13	295	34	240	8	M27	30
150	14	345	36	280	8	M30	33
175	15	375	40	310	12	M30	33
200	16	415	42	345	12	M33	36
250	19	470	46	400	12	M33	36
300	21	530	52	460	16	M33	36
350	23	600	56	525	16	M36	39
400	26	670	60	585	16	M39	42
500	31	800	68	705	20	M45	48
600	35	930	76	820	20	M52	56
700	40	1045	84	935	24	M52	56
800	45	1165	92	1050	24	M56	62
900	50	1285	98	1170	28	M56	62
1000	55	1415	108	1290	28	M64	70
1200	64	1665	126	1530	32	M72X6	78

All dimensions in mm.

DIN Cast Steel Flange Standard
Heendruck 100 (Nominal Pressure 100 Bar)

NOMINAL BORE	PIPE THICK- NESS	FLANGE			BOLTING		
		Outside Diameter	Thickness	Bolt Circle Diameter	Number of Bolts	Thread	Bolt Hole Diameter
10	10	100	20	70	4	M12	14
15	10	105	20	75	4	M12	14
25	10	140	24	100	4	M16	18
32	12	155	24	110	4	M20	23
40	10	170	28	125	4	M20	22
50	10	185	30	145	4	M24	26
65	11	220	34	170	8	M24	26
80	12	230	36	180	8	M24	26
100	14	265	40	210	8	M27	30
125	16	315	40	250	8	M30	33
150	18	355	44	290	12	M30	33
175	20	385	48	320	12	M30	33
200	21	430	52	360	12	M33	36
250	25	505	60	430	12	M36	39
300	29	585	68	500	16	M39	42
350	32	655	74	560	16	M45	48
400	36	715	78	620	16	M45	48
500	44	870	94	760	20	M52	56
600	51	990	104	875	20	M56	62
700	59	1145	120	1020	24	M64	70

All dimensions in mm.

DIN Cast Steel Flange Standard
Nenndruck 160 (Nominal Pressure 160 Bar)

NOMINAL BORE	PIPE THICK- NESS	FLANGE			BOLTING		
		Outside Diameter	Thickness	Bolt Circle Diameter	Number of Bolts	Thread	Bolt Hole Diameter
10	10	100	20	70	4	M12	14
15	10	105	20	75	4	M12	14
25	10	140	24	100	4	M16	18
40	10	170	28	125	4	M20	22
50	10	195	30	145	4	M24	26
85	11	220	34	170	8	M24	26
80	12	230	36	180	8	M24	26
100	14	265	40	210	8	M27	30
125	16	315	44	250	8	M30	33
150	18	355	50	290	12	M30	33
175	19	390	54	320	12	M33	36
200	21	430	60	360	12	M33	36
250	31	515	68	430	12	M39	42
300	36	585	78	500	16	M39	42

All dimensions in mm.

DIN Cast Steel Flange Standard
Nenndruck 250 (Nominal Pressure 250 Bar)

NOMINAL BORE	PIPE THICK- NESS	FLANGE			BOLTING		
		Outside Diameter	Thickness	Bolt Circle Diameter	Number of Bolts	Thread	Bolt Hole Diameter
10	10	125	24	85	4	M16	18
15	10	130	26	90	4	M16	18
25	11	150	28	105	4	M20	22
40	13	185	34	135	4	M24	26
50	13	200	38	150	8	M24	26
65	14	230	42	180	8	M24	26
80	16	265	48	200	8	M27	30
100	19	300	54	235	8	M30	33
125	22	340	60	275	12	M30	33
150	25	390	68	320	12	M33	36
175	28	430	74	355	12	M36	39
200	32	485	82	400	12	M39	42
250	38	585	100	490	16	M45	48
300	47	690	120	590	16	M48	52

All dimensions in mm.

DIN Cast Steel Flange Standard
Normdruck 320 (Nominal Pressure 320 Bar)

NOMINAL BORE	PIPE THICK- NESS	FLANGE			BOLTING		
		Outside Diameter	Thickness	Bolt Circle Diameter	Number of Bolts	Thread	Bolt Hole Diameter
10	11	125	24	85	4	M16	18
15	11	130	26	90	4	M16	18
25	11	160	34	115	4	M20	22
40	14	195	38	145	4	M24	26
50	15	210	42	160	8	M24	26
65	18	255	51	200	8	M27	30
80	19	275	55	220	8	M27	30
100	24	335	65	265	8	M33	36
125	27	380	75	310	12	M33	36
150	32	425	84	350	12	M36	39
175	36	485	95	400	12	M39	42
200	38	525	103	440	16	M39	42
250	49	640	125	540	16	M48	52

All dimensions in mm.

DIN Cast Steel Flange Standard
Normdruck 400 (Nominal Pressure 400 Bar)

NOMINAL BORE	PIPE THICK- NESS	FLANGE			BOLTING		
		Outside Diameter	Thickness	Bolt Circle Diameter	Number of Bolts	Thread	Bolt Hole Diameter
10	11	125	28	85	4	M16	18
15	11	145	30	100	4	M20	23
25	12	180	38	130	4	M24	26
40	15	220	48	165	4	M27	30
50	18	235	52	180	8	M27	30
65	22	290	64	225	8	M30	33
80	25	305	68	240	8	M30	33
100	30	370	80	295	8	M36	39
125	36	415	92	340	12	M36	39
150	41	475	105	390	12	M39	42
175	47	545	120	450	12	M45	48
200	53	585	130	490	16	M45	48

All dimensions in mm.

Section 9

General Reference Tables

Circumferences and Areas of Circles

Diameter (In.)	Circum. (In.)	Area (Sq In.)	Diameter (In.)	Circum. (In.)	Area (Sq In.)
1/32	.0982	.00077	13/16	2.5525	.51849
1/16	.1963	.00307	27/32	2.6507	.55914
3/32	.2945	.00690	7/8	2.7489	.60132
1/8	.3927	.01228	29/32	2.8471	.64504
5/32	.4909	.01916	15/16	2.9452	.69029
3/16	.5890	.02761	31/32	3.0434	.73708
7/32	.6872	.03758	1	3.1416	.7854
1/4	.7854	.04909	1-1/16	3.3379	.8866
9/32	.8836	.06213	1-1/8	3.5343	.9940
5/16	.9817	.07670	1-3/16	3.7306	1.1075
11/32	1.0799	.09281	1-1/4	3.9270	1.2272
3/8	1.1781	.11045	1-5/16	4.1233	1.3530
13/32	1.2763	.12962	1-3/8	4.3197	1.4849
7/16	1.3744	.15033	1-7/16	4.5160	1.6230
15/32	1.4726	.17257	1-1/2	4.7124	1.7671
1/2	1.5708	.19635	1-9/16	4.9087	1.9175
17/32	1.6690	.22166	1-5/8	5.1051	2.0739
9/16	1.7671	.24850	1-11/16	5.3014	2.2365
19/32	1.8653	.27688	1-3/4	5.4978	2.4053
5/8	1.9635	.30680	1-13/16	5.6941	2.5802
21/32	2.0617	.33824	1-7/8	5.8905	2.7612
11/16	2.1598	.37122	1-15/16	6.0868	2.9483
23/32	2.2580	.40574	2	6.2832	3.1416
3/4	2.3562	.44179	2-1/16	6.4796	3.3410
25/32	2.4544	.47937	2-1/8	6.6759	3.5486

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Circumferences and Areas of Circles (Continued)

Diameter (In.)	Circum. (In.)	Area (Sq In.)	Diameter (In.)	Circum. (In.)	Area (Sq In.)
2-3/16	6.8722	3.7583	5	15.7080	19.635
2-1/4	7.0686	3.9781	5-1/16	15.9043	20.129
2-5/16	7.2649	4.2000	5-1/8	16.1007	20.629
2-3/8	7.4613	4.4301	5-3/16	16.2970	21.135
2-7/16	7.6576	4.6664	5-1/4	16.4934	21.648
2-1/2	7.8540	4.9087	5-5/16	16.6897	22.166
2-9/16	8.0503	5.1572	5-3/8	16.8861	22.691
2-5/8	8.2467	5.4119	5-7/16	17.0824	23.221
2-11/16	8.4430	5.6727	5-1/2	17.2788	23.758
2-3/4	8.6394	5.9396	5-9/16	17.4751	24.301
2-13/16	8.8357	6.2126	5-5/8	17.6715	24.850
2-7/8	9.0321	6.4918	5-11/16	17.8678	25.406
2-15/16	9.2284	6.7771	5-3/4	18.0642	25.967
3	9.4248	7.0686	5-13/16	18.2605	26.535
3-1/16	9.6211	7.3662	5-7/8	18.4569	27.109
3-1/8	9.8175	7.6699	5-15/16	18.6532	27.688
3-3/16	10.0138	7.9798	6	18.8496	28.274
3-1/4	10.2102	8.2958	6-1/8	19.2423	29.465
3-5/16	10.4065	8.6179	6-1/4	19.6350	30.680
3-3/8	10.6029	8.9462	6-3/8	20.0277	31.919
3-7/16	10.7992	9.2808	6-1/2	20.4204	33.183
3-1/2	10.9956	9.6211	6-5/8	20.8131	34.472
3-9/16	11.1919	9.9678	6-3/4	21.2058	35.785
3-5/8	11.3883	10.321	6-7/8	21.5984	37.122
3-11/16	11.5846	10.680	7	21.9911	38.485
3-3/4	11.7810	11.045	7-1/8	22.3838	39.871
3-13/16	11.9773	11.418	7-1/4	22.7765	41.282
3-7/8	12.1737	11.793	7-3/8	23.1692	42.718
3-15/16	12.3700	12.177	7-1/2	23.5619	44.179
4	12.5664	12.566	7-5/8	23.9456	45.664
4-1/16	12.7627	12.962	7-3/4	24.3473	47.173
4-1/8	12.9591	13.364	7-7/8	24.7400	48.707
4-3/16	13.1554	13.772	8	25.1327	50.265
4-1/4	13.3518	14.186	8-1/8	25.5254	51.849
4-5/16	13.5481	14.607	8-1/4	25.9181	53.456
4-3/8	13.7445	15.033	8-3/8	26.3108	55.088
4-7/16	13.9408	15.466	8-1/2	26.7035	56.745
4-1/2	14.1372	15.904	8-5/8	27.0962	58.426
4-9/16	14.3335	16.349	8-3/4	27.4889	60.132
4-5/8	14.5299	16.800	8-7/8	27.8816	61.862
4-11/16	14.7262	17.257	9	28.2743	63.617
4-3/4	14.9226	17.721	9-1/8	28.6670	65.397
4-13/16	15.1189	18.190	9-1/4	29.0597	67.201
4-7/8	15.3153	18.665	9-3/8	29.4524	69.029
4-15/16	15.5116	19.147	9-1/2	29.8451	70.882

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Circumferences and Areas of Circles (Continued)

Diameter (In.)	Circum. (In.)	Area (Sq In.)	Diameter (In.)	Circum. (In.)	Area (Sq In.)
9-5/8	30.2378	72.760	20-1/2	64.4026	330.06
9-3/4	30.6305	74.662	20-3/4	65.1880	338.16
9-7/8	31.0232	76.589	21	65.9734	346.36
10	31.4159	78.540	21-1/4	66.7588	354.66
10-1/4	32.2013	82.516	21-1/2	67.5442	363.05
10-1/2	32.9867	86.590	21-3/4	68.3296	371.54
10-3/4	33.7721	90.763	22	69.1150	380.13
11	34.5575	95.033	22-1/4	69.9004	388.82
11-1/4	35.3429	99.402	22-1/2	70.6858	397.61
11-1/2	36.1283	103.87	22-3/4	71.4712	406.49
11-3/4	36.9137	108.43	23	72.2566	415.48
12	37.6991	113.10	23-1/4	73.0420	424.56
12-1/4	38.4845	117.86	23-1/2	73.8274	433.74
12-1/2	39.2699	122.72	23-3/4	74.6128	443.01
12-3/4	40.0553	127.68	24	75.3982	452.39
13	40.8407	132.73	24-1/4	76.1836	461.88
13-1/4	41.6261	137.89	24-1/2	76.9690	471.44
13-1/2	42.4115	143.14	24-3/4	77.7544	481.11
13-3/4	43.1969	148.49	25	78.5398	490.87
14	43.9823	153.94	25-1/4	79.3252	500.74
14-1/4	44.7677	159.48	25-1/2	80.1106	510.71
14-1/2	45.5531	165.13	25-3/4	80.8960	520.77
14-3/4	46.3385	170.87	26	81.6814	530.93
15	47.1239	176.71	26-1/4	82.4668	541.19
15-1/4	47.9093	182.65	26-1/2	83.2522	551.55
15-1/2	48.6947	188.69	26-3/4	84.0376	562.00
15-3/4	49.4801	194.83	27	84.8230	572.56
16	50.2655	201.06	27-1/4	85.6084	583.21
16-1/4	51.0509	207.39	27-1/2	86.3938	593.96
16-1/2	51.8363	213.82	27-3/4	87.1792	604.81
16-3/4	52.6217	220.35	28	87.9646	615.75
17	53.4071	226.98	28-1/4	88.7500	626.80
17-1/4	54.1925	233.71	28-1/2	89.5354	637.94
17-1/2	54.9779	240.53	28-3/4	90.3208	649.18
17-3/4	55.7633	247.45	29	91.1062	660.52
18	56.5487	254.47	29-1/4	91.8916	671.96
18-1/4	57.3341	261.59	29-1/2	92.6770	683.49
18-1/2	58.1195	268.80	29-3/4	93.4624	695.13
18-3/4	58.9049	276.12	30	94.2478	706.86
19	59.6903	283.53	30-1/4	95.0332	718.69
19-1/4	60.4757	291.04	30-1/2	95.8186	730.62
19-1/2	61.2611	298.65	30-3/4	96.6040	742.64
19-3/4	62.0465	306.35	31	97.3894	754.77
20	62.8319	314.16	31-1/4	98.1748	766.99
20-1/4	63.6173	322.06	31-1/2	98.9602	779.31

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Circumferences and Areas of Circles (Continued)

Diameter (In.)	Circum. (In.)	Area (Sq In.)	Diameter (In.)	Circum. (In.)	Area (Sq In.)
31-3/4	99.7456	791.73	41-3/4	131.161	1369.0
32	100.531	804.26	42	131.947	1385.4
32-1/4	101.316	816.86	42-1/4	132.732	1402.0
32-1/2	102.102	829.58	42-1/2	133.518	1418.6
32-3/4	102.887	842.39	42-3/4	134.303	1435.4
33	103.673	855.30	43	135.088	1452.2
33-1/4	104.458	868.31	43-1/4	135.874	1469.1
33-1/2	105.243	881.41	43-1/2	136.659	1486.2
33-3/4	106.029	894.62	43-3/4	137.445	1503.3
34	106.814	907.92	44	138.230	1520.5
34-1/4	107.600	921.32	44-1/4	139.015	1537.9
34-1/2	108.385	934.82	44-1/2	139.801	1555.3
34-3/4	109.170	948.42	44-3/4	140.586	1572.8
35	109.956	962.11	45	141.372	1590.4
35-1/4	110.741	975.91	45-1/4	142.157	1608.2
35-1/2	111.527	989.80	45-1/2	142.942	1626.0
35-3/4	112.312	1003.8	45-3/4	143.728	1643.9
36	113.097	1017.9	46	144.513	1661.9
36-1/4	113.883	1032.1	46-1/4	145.299	1680.0
36-1/2	114.668	1046.3	46-1/2	146.084	1698.2
36-3/4	115.454	1060.7	46-3/4	146.869	1716.5
37	116.239	1075.2	47	147.655	1734.9
37-1/4	117.024	1089.8	47-1/4	148.440	1753.5
37-1/2	117.810	1104.5	47-1/2	149.226	1772.1
37-3/4	118.596	1119.2	47-3/4	150.011	1790.8
38	119.381	1134.1	48	150.796	1809.6
38-1/4	120.166	1149.1	48-1/4	151.582	1828.5
38-1/2	120.951	1164.2	48-1/2	152.367	1847.5
38-3/4	121.737	1179.3	48-3/4	153.153	1866.5
39	122.522	1194.6	49	153.938	1885.7
39-1/4	123.308	1210.0	49-1/4	154.723	1905.0
39-1/2	124.093	1225.4	49-1/2	155.509	1924.4
39-3/4	124.878	1241.0	49-3/4	156.294	1943.9
40	125.664	1256.6	50	157.080	1963.5
40-1/4	126.449	1272.4			
40-1/2	127.235	1288.2			
40-3/4	128.020	1304.2			
41	128.805	1320.3			
41-1/4	129.591	1336.4			
41-1/2	130.376	1352.7			

Common Logarithms

No.	0	1	2	3	4	5	6	7	8	9
0	...	0000	3010	4771	6021	6990	7782	8451	9031	9542
1	0000	0414	0792	1139	1461	1761	2041	2304	2553	2788
2	3010	3222	3424	3617	3802	3979	4150	4314	4472	4624
3	4771	4914	5051	5185	5315	5441	5563	5682	5798	5911
4	6021	6128	6232	6335	6435	6532	6628	6721	6812	6902
5	6990	7076	7160	7243	7324	7404	7482	7559	7634	7709
6	7782	7853	7924	7993	8062	8129	8195	8261	8325	8388
7	8451	8513	8573	8633	8692	8751	8808	8865	8921	8976
8	9031	9085	9138	9191	9243	9294	9345	9395	9445	9494
9	9542	9590	9638	9685	9731	9777	9823	9868	9912	9956
10	0000	0043	0086	0128	0170	0212	0253	0294	0334	0374
11	0414	0453	0492	0531	0569	0607	0645	0682	0719	0755
12	0792	0828	0864	0899	0934	0969	1004	1038	1072	1106
13	1139	1173	1206	1239	1271	1303	1335	1367	1399	1430
14	1461	1492	1523	1553	1584	1614	1644	1673	1703	1732
15	1761	1790	1818	1847	1875	1903	1931	1959	1987	2014
16	2041	2068	2095	2122	2148	2175	2201	2227	2253	2279
17	2304	2330	2355	2380	2405	2430	2455	2480	2504	2529
18	2553	2577	2601	2625	2648	2672	2695	2718	2742	2765
19	2788	2810	2833	2856	2878	2900	2923	2945	2967	2989
20	3010	3032	3054	3075	3096	3118	3139	3160	3181	3201
21	3222	3243	3263	3284	3304	3324	3345	3365	3385	3404
22	3424	3444	3464	3483	3502	3522	3541	3560	3579	3598
23	3617	3636	3655	3674	3692	3711	3729	3747	3766	3784
24	3802	3820	3838	3856	3874	3892	3909	3927	3945	3962
25	3979	3997	4014	4031	4048	4065	4082	4099	4116	4133
26	4150	4166	4183	4200	4216	4232	4249	4265	4281	4298
27	4314	4330	4346	4362	4378	4393	4409	4425	4440	4456
28	4472	4487	4502	4518	4533	4548	4564	4579	4594	4609
29	4624	4639	4654	4669	4683	4698	4713	4728	4742	4757
30	4771	4786	4800	4814	4829	4843	4857	4871	4886	4900
31	4914	4928	4942	4955	4969	4983	4997	5011	5024	5038
32	5051	5065	5079	5092	5105	5119	5132	5145	5159	5172
33	5185	5198	5211	5224	5237	5250	5263	5276	5289	5302
34	5315	5328	5340	5353	5366	5378	5391	5403	5416	5428
35	5441	5453	5465	5478	5490	5502	5514	5527	5539	5551
36	5563	5575	5587	5599	5611	5623	5635	5647	5658	5670
37	5682	5694	5705	5717	5729	5740	5752	5763	5775	5786
38	5798	5809	5821	5832	5843	5855	5866	5877	5888	5899
39	5911	5922	5933	5944	5955	5966	5977	5988	5999	6010
40	6021	6031	6042	6053	6064	6075	6085	6096	6107	6117
41	6128	6138	6149	6160	6170	6180	6191	6201	6212	6222
42	6232	6243	6253	6263	6274	6284	6294	6304	6314	6325
43	6335	6345	6355	6365	6375	6385	6395	6405	6415	6425
44	6435	6444	6454	6464	6474	6484	6493	6503	6513	6522
45	6532	6542	6551	6561	6571	6580	6590	6599	6609	6618

- Continued -

Common Logarithms (Continued)

No.	0	1	2	3	4	5	6	7	8	9
46	6628	6637	6646	6656	6665	6675	6684	6693	6702	6712
47	6721	6730	6739	6749	6758	6767	6776	6785	6794	6803
48	6812	6821	6830	6839	6848	6857	6866	6875	6884	6893
49	6902	6911	6920	6928	6937	6946	6955	6964	6972	6981
50	6990	6998	7007	7016	7024	7033	7042	7050	7059	7067
51	7076	7084	7093	7101	7110	7118	7126	7135	7143	7152
52	7160	7168	7177	7185	7193	7202	7210	7218	7226	7235
53	7243	7251	7259	7267	7275	7284	7292	7300	7308	7316
54	7324	7332	7340	7348	7356	7364	7372	7380	7388	7396
55	7404	7412	7419	7427	7435	7443	7451	7459	7466	7474
56	7482	7490	7497	7505	7513	7520	7528	7536	7543	7551
57	7559	7566	7574	7582	7589	7597	7604	7612	7619	7627
58	7634	7642	7649	7657	7664	7672	7679	7686	7694	7701
59	7709	7718	7723	7731	7738	7745	7752	7760	7767	7774
60	7782	7789	7796	7803	7810	7818	7825	7832	7839	7846
61	7853	7860	7868	7875	7882	7889	7896	7903	7910	7917
62	7924	7931	7938	7945	7952	7959	7966	7973	7980	7987
63	7993	8000	8007	8014	8021	8028	8035	8041	8048	8055
64	8062	8069	8075	8082	8089	8096	8102	8109	8116	8122
65	8129	8136	8142	8149	8156	8162	8169	8176	8182	8189
66	8195	8202	8209	8215	8222	8228	8235	8241	8248	8254
67	8261	8267	8274	8280	8287	8293	8299	8306	8312	8319
68	8325	8331	8338	8344	8351	8357	8363	8370	8376	8382
69	8388	8395	8401	8407	8414	8420	8426	8432	8439	8445
70	8451	8457	8463	8470	8476	8482	8488	8494	8500	8506
71	8513	8519	8525	8531	8537	8543	8549	8555	8561	8567
72	8573	8579	8585	8591	8597	8603	8609	8615	8621	8627
73	8633	8639	8645	8651	8657	8663	8669	8675	8681	8686
74	8692	8698	8704	8710	8716	8722	8727	8733	8739	8745
75	8751	8756	8762	8768	8774	8779	8785	8791	8797	8802
76	8808	8814	8820	8825	8831	8837	8842	8848	8854	8859
77	8865	8871	8876	8882	8887	8893	8899	8904	8910	8915
78	8921	8927	8932	8938	8943	8949	8954	8960	8965	8971
79	8976	8982	8987	8993	8998	9004	9009	9015	9020	9025
80	9031	9036	9042	9047	9053	9058	9063	9069	9074	9079
81	9085	9090	9096	9101	9106	9112	9117	9122	9128	9133
82	9138	9143	9149	9154	9159	9165	9170	9175	9180	9186
83	9191	9196	9201	9206	9212	9217	9222	9227	9232	9238
84	9243	9248	9253	9258	9263	9269	9274	9279	9284	9289
85	9294	9299	9304	9309	9315	9320	9325	9330	9335	9340
86	9345	9350	9355	9360	9365	9370	9375	9380	9385	9390
87	9395	9400	9405	9410	9415	9420	9425	9430	9435	9440
88	9445	9450	9455	9460	9465	9469	9474	9479	9484	9489
89	9494	9499	9504	9509	9513	9518	9523	9528	9533	9538
90	9542	9547	9552	9557	9562	9566	9571	9576	9581	9586

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Common Logarithms (Continued)

No.	0	1	2	3	4	5	6	7	8	9
91	9590	9595	9600	9605	9609	9614	9619	9624	9628	9633
92	9638	9643	9647	9652	9657	9661	9666	9671	9675	9680
93	9685	9689	9694	9699	9703	9708	9713	9717	9722	9727
94	9731	9736	9741	9745	9750	9754	9759	9763	9768	9773
95	9777	9782	9786	9791	9795	9800	9805	9809	9814	9818
96	9823	9827	9832	9836	9841	9845	9850	9854	9859	9863
97	9868	9872	9877	9881	9886	9890	9894	9899	9903	9908
98	9912	9917	9921	9926	9930	9934	9939	9943	9948	9952
99	9956	9961	9965	9969	9974	9978	9983	9987	9991	9996
100	0000	0004	0009	0013	0017	0022	0026	0030	0035	0039

Metric Prefixes and Symbols

Multiplication Factor	Prefix	Symbol
1 000 000 000 000 000 000 = 10^{18}	exa	E
1 000 000 000 000 000 = 10^{15}	peta	P
1 000 000 000 000 = 10^{12}	tera	T
1 000 000 000 = 10^9	giga	G
1 000 000 = 10^6	mega	M
1 000 = 10^3	kilo	k
100 = 10^2	hecto*	h
10 = 10^1	deka*	da
0.1 = 10^{-1}	deci*	d
0.01 = 10^{-2}	centi*	c
0.001 = 10^{-3}	milli	m
0.000 001 = 10^{-6}	micro	μ
0.000 000 001 = 10^{-9}	nano	n
0.000 000 000 001 = 10^{-12}	pico	p
0.000 000 000 000 001 = 10^{-15}	femto	f
0.000 000 000 000 000 001 = 10^{-18}	atto	a

* Avoid usage, if possible.

Greek Alphabet

Caps	Lower Case	Greek Name	Caps	Lower Case	Greek Name	Caps	Lower Case	Greek Name
A	a	Alpha	I	ι	Iota	P	p	Rho
B	β	Beta	K	κ	Kappa	Σ	σ	Sigma
Γ	γ	Gamma	Λ	λ	Lambda	T	τ	Tau
Δ	δ	Delta	M	μ	Mu	Υ	υ	Upsilon
E	ε	Epsilon	N	ν	Nu	Φ	φ ϕ	Phi
Z	ζ	Zeta	Ξ	ξ	Xi	X	χ	Chi
H	η	Eta	O	ο	Omicron	Ψ	ψ	Psi
Θ	θ	Theta	Π	π	Pi	Ω	ω	Omega

Natural Trigonometric Functions

Deg	Function	0.0°	0.1°	0.2°	0.3°	0.4°	0.5°	0.6°	0.7°	0.8°	0.9°
0	sin	0.0000	0.0017	0.0035	0.0052	0.0070	0.0087	0.0105	0.0122	0.0140	0.0157
	cos	1.0000	1.0000	1.0000	1.0000	1.0000	1.0000	0.9999	0.9999	0.9999	0.9999
	tan	0.0000	0.0017	0.0035	0.0052	0.0070	0.0087	0.0105	0.0122	0.0140	0.0157
1	sin	0.0175	0.0192	0.0209	0.0227	0.0244	0.0262	0.0279	0.0297	0.0314	0.0332
	cos	0.9998	0.9998	0.9998	0.9997	0.9997	0.9997	0.9996	0.9996	0.9995	0.9995
	tan	0.0175	0.0192	0.0209	0.0227	0.0244	0.0262	0.0279	0.0297	0.0314	0.0332
2	sin	0.0349	0.0366	0.0384	0.0401	0.0419	0.0436	0.0454	0.0471	0.0488	0.0506
	cos	0.9994	0.9993	0.9993	0.9992	0.9991	0.9990	0.9990	0.9989	0.9988	0.9987
	tan	0.0349	0.0367	0.0384	0.0402	0.0419	0.0437	0.0454	0.0472	0.0489	0.0507
3	sin	0.0523	0.0541	0.0558	0.0576	0.0593	0.0600	0.0628	0.0645	0.0663	0.0680
	cos	0.9986	0.9985	0.9984	0.9983	0.9982	0.9981	0.9980	0.9979	0.9978	0.9977
	tan	0.0524	0.0542	0.0559	0.0577	0.0594	0.0612	0.0629	0.0647	0.0664	0.0682
4	sin	0.0698	0.0716	0.0732	0.0750	0.0767	0.0785	0.0802	0.0819	0.0837	0.0854
	cos	0.9978	0.9974	0.9973	0.9972	0.9971	0.9969	0.9968	0.9966	0.9965	0.9963
	tan	0.0699	0.0717	0.0734	0.0752	0.0769	0.0787	0.0805	0.0822	0.0840	0.0857
5	sin	0.0872	0.0889	0.0906	0.0924	0.0941	0.0958	0.0976	0.0993	0.1011	0.1028
	cos	0.9962	0.9960	0.9959	0.9957	0.9956	0.9954	0.9952	0.9951	0.9949	0.9947
	tan	0.0875	0.0892	0.0910	0.0928	0.0945	0.0963	0.0981	0.0998	0.1016	0.1033
6	sin	0.1045	0.1063	0.1080	0.1097	0.1115	0.1132	0.1149	0.1167	0.1184	0.1201
	cos	0.9945	0.9943	0.9942	0.9940	0.9938	0.9936	0.9934	0.9932	0.9930	0.9928
	tan	0.1051	0.1069	0.1086	0.1104	0.1122	0.1139	0.1157	0.1175	0.1192	0.1210
7	sin	0.1219	0.1236	0.1253	0.1271	0.1288	0.1305	0.1323	0.1340	0.1357	0.1374
	cos	0.9925	0.9923	0.9921	0.9919	0.9917	0.9914	0.9912	0.9910	0.9907	0.9905
	tan	0.1228	0.1246	0.1263	0.1281	0.1299	0.1317	0.1334	0.1352	0.1370	0.1388

8	sin	0.1392	0.1409	0.1426	0.1444	0.1461	0.1478	0.1495	0.1513	0.1530	0.1547
	cos	0.9903	0.9900	0.9898	0.9895	0.9893	0.9890	0.9888	0.9885	0.9882	0.9880
	tan	0.1405	0.1423	0.1441	0.1459	0.1477	0.1495	0.1512	0.1530	0.1548	0.1566
9	sin	0.1564	0.1582	0.1599	0.1616	0.1633	0.1650	0.1668	0.1685	0.1702	0.1719
	cos	0.9877	0.9874	0.9871	0.9869	0.9866	0.9863	0.9860	0.9857	0.9854	0.9851
	tan	0.1584	0.1602	0.1620	0.1638	0.1655	0.1673	0.1691	0.1709	0.1727	0.1745
10	sin	0.1736	0.1754	0.1771	0.1788	0.1805	0.1822	0.1840	0.1857	0.1874	0.1891
	cos	0.9848	0.9845	0.9842	0.9839	0.9836	0.9833	0.9829	0.9826	0.9823	0.9820
	tan	0.1763	0.1781	0.1799	0.1817	0.1835	0.1853	0.1871	0.1890	0.1908	0.1926
11	sin	0.1908	0.1925	0.1942	0.1959	0.1977	0.1994	0.2011	0.2028	0.2045	0.2062
	cos	0.9816	0.9813	0.9810	0.9806	0.9803	0.9799	0.9796	0.9792	0.9789	0.9785
	tan	0.1944	0.1962	0.1980	0.1998	0.2016	0.2035	0.2053	0.2071	0.2089	0.2107
12	sin	0.2079	0.2096	0.2113	0.2130	0.2147	0.2164	0.2181	0.2198	0.2215	0.2232
	cos	0.9781	0.9778	0.9774	0.9770	0.9767	0.9763	0.9759	0.9755	0.9751	0.9748
	tan	0.2126	0.2144	0.2162	0.2180	0.2199	0.2217	0.2235	0.2254	0.2272	0.2290
13	sin	0.2250	0.2267	0.2284	0.2300	0.2318	0.2334	0.2351	0.2368	0.2385	0.2402
	cos	0.9744	0.9740	0.9736	0.9732	0.9728	0.9724	0.9720	0.9715	0.9711	0.9707
	tan	0.2309	0.2327	0.2345	0.2364	0.2382	0.2401	0.2419	0.2438	0.2456	0.2475
14	sin	0.2419	0.2436	0.2453	0.2470	0.2487	0.2504	0.2521	0.2538	0.2554	0.2571
	cos	0.9703	0.9699	0.9694	0.9690	0.9686	0.9681	0.9677	0.9673	0.9668	0.9664
	tan	0.2493	0.2512	0.2530	0.2549	0.2568	0.2586	0.2605	0.2623	0.2642	0.2661
15	sin	0.2588	0.2605	0.2622	0.2639	0.2656	0.2672	0.2689	0.2706	0.2723	0.2740
	cos	0.9659	0.9655	0.9650	0.9646	0.9641	0.9636	0.9632	0.9627	0.9622	0.9617
	tan	0.2679	0.2698	0.2717	0.2736	0.2754	0.2773	0.2792	0.2811	0.2830	0.2849

- Continued -

Natural Trigonometric Functions (Continued)

Deg	Function	0.0°	0.1°	0.2°	0.3°	0.4°	0.5°	0.6°	0.7°	0.8°	0.9°
16	sin	0.2756	0.2773	0.2790	0.2807	0.2823	0.2840	0.2857	0.2874	0.2890	0.2907
	cos	0.9613	0.9608	0.9603	0.9598	0.9593	0.9588	0.9583	0.9578	0.9573	0.9568
	tan	0.2867	0.2886	0.2905	0.2924	0.2943	0.2962	0.2981	0.3000	0.3019	0.3038
17	sin	0.2924	0.2940	0.2957	0.2974	0.2990	0.3007	0.3024	0.3040	0.3057	0.3074
	cos	0.9563	0.9558	0.9553	0.9548	0.9542	0.9537	0.9532	0.9527	0.9521	0.9516
	tan	0.3057	0.3076	0.3096	0.3115	0.3134	0.3153	0.3172	0.3191	0.3211	0.3230
18	sin	0.3090	0.3107	0.3123	0.3140	0.3156	0.3173	0.3190	0.3206	0.3223	0.3239
	cos	0.9511	0.9505	0.9500	0.9494	0.9489	0.9483	0.9478	0.9472	0.9466	0.9461
	tan	0.3249	0.3268	0.3288	0.3307	0.3327	0.3346	0.3365	0.3385	0.3404	0.3424
19	sin	0.3256	0.3272	0.3289	0.3305	0.3322	0.3338	0.3355	0.3371	0.3387	0.3404
	cos	0.9455	0.9449	0.9444	0.9438	0.9432	0.9426	0.9421	0.9415	0.9409	0.9403
	tan	0.3443	0.3463	0.3482	0.3502	0.3522	0.3541	0.3561	0.3581	0.3600	0.3620
20	sin	0.3420	0.3437	0.3453	0.3469	0.3486	0.3502	0.3518	0.3535	0.3551	0.3567
	cos	0.9397	0.9391	0.9385	0.9379	0.9373	0.9367	0.9361	0.9354	0.9348	0.9342
	tan	0.3640	0.3659	0.3678	0.3699	0.3719	0.3739	0.3759	0.3779	0.3799	0.3819
21	sin	0.3584	0.3600	0.3616	0.3633	0.3649	0.3665	0.3681	0.3697	0.3714	0.3730
	cos	0.9336	0.9330	0.9323	0.9317	0.9311	0.9304	0.9298	0.9291	0.9285	0.9278
	tan	0.3839	0.3859	0.3879	0.3899	0.3919	0.3939	0.3959	0.3979	0.4000	0.4020
22	sin	0.3746	0.3762	0.3778	0.3795	0.3811	0.3827	0.3843	0.3859	0.3875	0.3891
	cos	0.9272	0.9265	0.9259	0.9252	0.9245	0.9239	0.9232	0.9225	0.9219	0.9212
	tan	0.4040	0.4061	0.4081	0.4101	0.4122	0.4142	0.4163	0.4183	0.4204	0.4224
23	sin	0.3907	0.3923	0.3939	0.3955	0.3971	0.3987	0.4003	0.4019	0.4035	0.4051
	cos	0.9205	0.9198	0.9191	0.9184	0.9178	0.9171	0.9164	0.9157	0.9150	0.9143
	tan	0.4245	0.4265	0.4286	0.4307	0.4327	0.4348	0.4369	0.4390	0.4411	0.4431

24	sin	0.4067	0.4083	0.4099	0.4115	0.4131	0.4147	0.4163	0.4179	0.4195	0.4210
	cos	0.9135	0.9128	0.9121	0.9114	0.9107	0.9100	0.9092	0.9085	0.9078	0.9070
	tan	0.4452	0.4473	0.4494	0.4515	0.4536	0.4557	0.4578	0.4599	0.4621	0.4642
25	sin	0.4226	0.4242	0.4258	0.4274	0.4289	0.4305	0.4321	0.4337	0.4352	0.4368
	cos	0.9063	0.9056	0.9048	0.9041	0.9033	0.9026	0.9018	0.9011	0.9003	0.8996
	tan	0.4663	0.4684	0.4706	0.4727	0.4748	0.4770	0.4791	0.4813	0.4834	0.4856
26	sin	0.4384	0.4399	0.4415	0.4431	0.4446	0.4462	0.4478	0.4493	0.4509	0.4524
	cos	0.8988	0.8980	0.8973	0.8965	0.8957	0.8949	0.8942	0.8934	0.8926	0.8918
	tan	0.4877	0.4899	0.4921	0.4942	0.4964	0.4986	0.5008	0.5029	0.5051	0.5073
27	sin	0.4540	0.4555	0.4571	0.4586	0.4602	0.4617	0.4633	0.4648	0.4664	0.4679
	cos	0.8910	0.8902	0.8894	0.8886	0.8878	0.8870	0.8862	0.8854	0.8846	0.8838
	tan	0.5095	0.5117	0.5139	0.5161	0.5184	0.5206	0.5228	0.5250	0.5272	0.5295
28	sin	0.4695	0.4710	0.4726	0.4741	0.4756	0.4772	0.4787	0.4802	0.4818	0.4833
	cos	0.8829	0.8821	0.8813	0.8805	0.8796	0.8788	0.8780	0.8771	0.8763	0.8755
	tan	0.5317	0.5340	0.5362	0.5384	0.5407	0.5430	0.5452	0.5475	0.5498	0.5520
29	sin	0.4848	0.4863	0.4879	0.4894	0.4909	0.4924	0.4939	0.4955	0.4970	0.4985
	cos	0.8746	0.8738	0.8729	0.8721	0.8712	0.8704	0.8695	0.8686	0.8678	0.8669
	tan	0.5543	0.5566	0.5589	0.5612	0.5635	0.5658	0.5681	0.5704	0.5727	0.5750
30	sin	0.5000	0.5015	0.5030	0.5045	0.5060	0.5075	0.5090	0.5105	0.5120	0.5135
	cos	0.8660	0.8652	0.8643	0.8634	0.8625	0.8616	0.8607	0.8599	0.8590	0.8581
	tan	0.5774	0.5797	0.5820	0.5844	0.5867	0.5890	0.5914	0.5938	0.5961	0.5985
31	sin	0.5150	0.5165	0.5180	0.5195	0.5210	0.5225	0.5240	0.5255	0.5270	0.5284
	cos	0.8572	0.8563	0.8554	0.8545	0.8536	0.8526	0.8517	0.8508	0.8499	0.8490
	tan	0.6009	0.6032	0.6056	0.6080	0.6104	0.6128	0.6152	0.6176	0.6200	0.6224

- Continued -

Natural Trigonometric Functions (Continued)

Deg	Function	0.0°	0.1°	0.2°	0.3°	0.4°	0.5°	0.6°	0.7°	0.8°	0.9°
32	sin	0.5299	0.5314	0.5329	0.5344	0.5358	0.5373	0.5388	0.5402	0.5417	0.5432
	cos	0.8480	0.8471	0.8462	0.8453	0.8443	0.8434	0.8425	0.8415	0.8406	0.8398
	tan	0.6249	0.6273	0.6297	0.6322	0.6346	0.6371	0.6395	0.6420	0.6445	0.6469
33	sin	0.5446	0.5461	0.5476	0.5490	0.5505	0.5519	0.5534	0.5548	0.5563	0.5577
	cos	0.8387	0.8377	0.8368	0.8358	0.8348	0.8339	0.8329	0.8320	0.8310	0.8300
	tan	0.6494	0.6519	0.6544	0.6569	0.6594	0.6619	0.6644	0.6669	0.6694	0.6720
34	sin	0.5592	0.5606	0.5621	0.5635	0.5650	0.5664	0.5678	0.5693	0.5707	0.5721
	cos	0.8290	0.8281	0.8271	0.8261	0.8251	0.8241	0.8231	0.8221	0.8211	0.8202
	tan	0.6745	0.6771	0.6796	0.6822	0.6847	0.6873	0.6899	0.6924	0.6950	0.6976
35	sin	0.5736	0.5750	0.5764	0.5779	0.5793	0.5807	0.5821	0.5835	0.5850	0.5864
	cos	0.8192	0.8181	0.8171	0.8161	0.8151	0.8141	0.8131	0.8121	0.8111	0.8100
	tan	0.7002	0.7028	0.7054	0.7080	0.7107	0.7133	0.7159	0.7186	0.7212	0.7239
36	sin	0.5878	0.5892	0.5906	0.5920	0.5934	0.5948	0.5962	0.5976	0.5990	0.6004
	cos	0.8090	0.8080	0.8070	0.8060	0.8049	0.8039	0.8028	0.8018	0.8007	0.7997
	tan	0.7265	0.7292	0.7319	0.7346	0.7373	0.7400	0.7427	0.7454	0.7481	0.7508
37	sin	0.6018	0.6032	0.6046	0.6060	0.6074	0.6088	0.6101	0.6115	0.6129	0.6143
	cos	0.7986	0.7976	0.7965	0.7955	0.7944	0.7934	0.7923	0.7912	0.7902	0.7891
	tan	0.7536	0.7563	0.7590	0.7618	0.7646	0.7673	0.7701	0.7729	0.7757	0.7785
38	sin	0.6157	0.6170	0.6184	0.6198	0.6211	0.6225	0.6239	0.6252	0.6266	0.6280
	cos	0.7880	0.7869	0.7859	0.7848	0.7837	0.7826	0.7815	0.7804	0.7793	0.7782
	tan	0.7813	0.7841	0.7869	0.7898	0.7926	0.7954	0.7983	0.8012	0.8040	0.8069
39	sin	0.6293	0.6307	0.6320	0.6334	0.6347	0.6361	0.6374	0.6388	0.6401	0.6414
	cos	0.7771	0.7760	0.7749	0.7738	0.7727	0.7716	0.7705	0.7694	0.7683	0.7672
	tan	0.8098	0.8127	0.8156	0.8185	0.8214	0.8243	0.8273	0.8302	0.8332	0.8361

40	sin	0.6428	0.6441	0.6455	0.6468	0.6481	0.6494	0.6508	0.6521	0.6534	0.6547
	cos	0.7660	0.7649	0.7638	0.7627	0.7616	0.7604	0.7593	0.7581	0.7570	0.7559
	tan	0.8391	0.8421	0.8451	0.8481	0.8511	0.8541	0.8571	0.8601	0.8632	0.8662
41	sin	0.6561	0.6574	0.6587	0.6600	0.6613	0.6626	0.6639	0.6652	0.6665	0.6678
	cos	0.7547	0.7536	0.7524	0.7513	0.7501	0.7490	0.7478	0.7466	0.7455	0.7443
	tan	0.8693	0.8724	0.8754	0.8785	0.8816	0.8847	0.8878	0.8910	0.8941	0.8972
42	sin	0.6691	0.6704	0.6717	0.6730	0.6743	0.6756	0.6769	0.6782	0.6794	0.6807
	cos	0.7431	0.7420	0.7408	0.7396	0.7385	0.7373	0.7361	0.7349	0.7337	0.7325
	tan	0.9004	0.9036	0.9067	0.9099	0.9131	0.9163	0.9195	0.9228	0.9260	0.9293
43	sin	0.6820	0.6833	0.6845	0.6858	0.6871	0.6884	0.6896	0.6909	0.6921	0.6934
	cos	0.7314	0.7302	0.7290	0.7278	0.7266	0.7254	0.7242	0.7230	0.7218	0.7206
	tan	0.9325	0.9358	0.9391	0.9424	0.9457	0.9490	0.9523	0.9556	0.9590	0.9623
44	sin	0.6947	0.6959	0.6972	0.6984	0.6997	0.7009	0.7022	0.7034	0.7046	0.7059
	cos	0.7193	0.7181	0.7169	0.7157	0.7145	0.7133	0.7120	0.7108	0.7096	0.7083
	tan	0.9657	0.9691	0.9725	0.9759	0.9793	0.9827	0.9861	0.9896	0.9930	0.9965
45	sin	0.7071	0.7083	0.7096	0.7108	0.7120	0.7133	0.7145	0.7157	0.7169	0.7181
	cos	0.7071	0.7059	0.7046	0.7034	0.7022	0.7009	0.6997	0.6984	0.6972	0.6959
	tan	1.0000	1.0035	1.0070	1.0105	1.0141	1.0176	1.0212	1.0247	1.0283	1.0319
46	sin	0.7193	0.7206	0.7218	0.7230	0.7242	0.7254	0.7266	0.7278	0.7290	0.7302
	cos	0.6947	0.6934	0.6921	0.6909	0.6896	0.6884	0.6871	0.6858	0.6845	0.6833
	tan	1.0355	1.0392	1.0428	1.0464	1.0501	1.0538	1.0575	1.0612	1.0649	1.0686
47	sin	0.7314	0.7325	0.7337	0.7349	0.7361	0.7373	0.7385	0.7396	0.7408	0.7420
	cos	0.6820	0.6807	0.6794	0.6782	0.6769	0.6756	0.6743	0.6730	0.6717	0.6704
	tan	1.0724	1.0761	1.0799	1.0837	1.0875	1.0913	1.0951	1.0990	1.1028	1.1067

- Continued -

Natural Trigonometric Functions (Continued)

Deg	Function	0.0°	0.1°	0.2°	0.3°	0.4°	0.5°	0.6°	0.7°	0.8°	0.9°
48	sin	0.7431	0.7443	0.7455	0.7466	0.7478	0.7490	0.7501	0.7513	0.7524	0.7536
	cos	0.6691	0.6678	0.6665	0.6652	0.6639	0.6626	0.6613	0.6600	0.6587	0.6574
	tan	1.1106	1.1145	1.1184	1.1224	1.1263	1.1303	1.1343	1.1383	1.1423	1.1463
49	sin	0.7547	0.7559	0.7570	0.7581	0.7593	0.7604	0.7615	0.7627	0.7638	0.7649
	cos	0.6561	0.6547	0.6534	0.6521	0.6508	0.6494	0.6481	0.6468	0.6455	0.6441
	tan	1.1504	1.1544	1.1585	1.1626	1.1667	1.1708	1.1750	1.1792	1.1833	1.1875
50	sin	0.7660	0.7672	0.7683	0.7694	0.7705	0.7716	0.7727	0.7738	0.7749	0.7760
	cos	0.6428	0.6414	0.6401	0.6388	0.6374	0.6361	0.6347	0.6334	0.6320	0.6307
	tan	1.1918	1.1960	1.2002	1.2045	1.2088	1.2131	1.2174	1.2218	1.2261	1.2305
51	sin	0.7771	0.7782	0.7793	0.7804	0.7815	0.7826	0.7837	0.7848	0.7859	0.7869
	cos	0.6293	0.6280	0.6266	0.6252	0.6239	0.6225	0.6211	0.6198	0.6184	0.6170
	tan	1.2349	1.2393	1.2437	1.2482	1.2527	1.2572	1.2617	1.2662	1.2708	1.2753
52	sin	0.7880	0.7891	0.7902	0.7912	0.7923	0.7934	0.7944	0.7955	0.7965	0.7976
	cos	0.6157	0.6143	0.6129	0.6115	0.6101	0.6088	0.6074	0.6060	0.6046	0.6032
	tan	1.2799	1.2846	1.2892	1.2938	1.2985	1.3032	1.3079	1.3127	1.3175	1.3222
53	sin	0.7986	0.7997	0.8007	0.8018	0.8028	0.8039	0.8049	0.8059	0.8070	0.8080
	cos	0.6018	0.6004	0.5990	0.5976	0.5962	0.5948	0.5934	0.5920	0.5906	0.5892
	tan	1.3270	1.3319	1.3367	1.3416	1.3465	1.3514	1.3564	1.3613	1.3663	1.3713
54	sin	0.8090	0.8100	0.8111	0.8121	0.8131	0.8141	0.8151	0.8161	0.8171	0.8181
	cos	0.5878	0.5864	0.5850	0.5835	0.5821	0.5807	0.5793	0.5779	0.5764	0.5750
	tan	1.3764	1.3814	1.3865	1.3916	1.3968	1.4019	1.4071	1.4124	1.4176	1.4229
55	sin	0.8182	0.8202	0.8211	0.8221	0.8231	0.8241	0.8251	0.8261	0.8271	0.8281
	cos	0.5736	0.5721	0.5707	0.5693	0.5678	0.5664	0.5650	0.5635	0.5621	0.5606
	tan	1.4281	1.4335	1.4388	1.4442	1.4496	1.4550	1.4605	1.4659	1.4715	1.4770

56	sin	0.8290	0.8300	0.8310	0.8320	0.8329	0.8339	0.8348	0.8358	0.8368	0.8377
	cos	0.5592	0.5577	0.5563	0.5548	0.5534	0.5519	0.5505	0.5490	0.5476	0.5461
	tan	1.4826	1.4882	1.4938	1.4994	1.5051	1.5108	1.5166	1.5224	1.5282	1.5340
57	sin	0.8387	0.8398	0.8406	0.8415	0.8425	0.8434	0.8443	0.8453	0.8462	0.8471
	cos	0.5446	0.5432	0.5417	0.5402	0.5388	0.5373	0.5358	0.5344	0.5329	0.5314
	tan	1.5399	1.5458	1.5517	1.5577	1.5637	1.5697	1.5757	1.5818	1.5880	1.5941
58	sin	0.8480	0.8490	0.8499	0.8508	0.8517	0.8526	0.8536	0.8545	0.8554	0.8563
	cos	0.5299	0.5284	0.5270	0.5255	0.5240	0.5225	0.5210	0.5195	0.5180	0.5165
	tan	1.6003	1.6066	1.6128	1.6191	1.6255	1.6319	1.6383	1.6447	1.6512	1.6577
59	sin	0.8572	0.8581	0.8590	0.8599	0.8607	0.8616	0.8625	0.8634	0.8643	0.8652
	cos	0.5150	0.5135	0.5120	0.5105	0.5090	0.5075	0.5060	0.5045	0.5030	0.5015
	tan	1.6643	1.6709	1.6775	1.6842	1.6909	1.6977	1.7045	1.7113	1.7182	1.7251
60	sin	0.8660	0.8669	0.8678	0.8686	0.8695	0.8704	0.8712	0.8721	0.8729	0.8738
	cos	0.5000	0.4985	0.4970	0.4955	0.4939	0.4924	0.4909	0.4894	0.4879	0.4863
	tan	1.7321	1.7391	1.7461	1.7532	1.7603	1.7675	1.7747	1.7820	1.7893	1.7966
61	sin	0.8746	0.8755	0.8763	0.8771	0.8780	0.8788	0.8796	0.8806	0.8813	0.8821
	cos	0.4848	0.4833	0.4818	0.4802	0.4787	0.4772	0.4756	0.4741	0.4726	0.4710
	tan	1.8040	1.8115	1.8190	1.8265	1.8341	1.8418	1.8495	1.8572	1.8650	1.8728
62	sin	0.8829	0.8838	0.8846	0.8854	0.8862	0.8870	0.8878	0.8886	0.8894	0.8902
	cos	0.4686	0.4679	0.4664	0.4648	0.4633	0.4617	0.4602	0.4586	0.4571	0.4555
	tan	1.8807	1.8887	1.8967	1.9047	1.9128	1.9210	1.9262	1.9375	1.9458	1.9542
63	sin	0.8910	0.8918	0.8926	0.8934	0.8942	0.8949	0.8957	0.8965	0.8973	0.8980
	cos	0.4540	0.4524	0.4509	0.4493	0.4478	0.4462	0.4446	0.4431	0.4415	0.4399
	tan	1.9626	1.9711	1.9797	1.9883	1.9970	2.0057	2.0146	2.0233	2.0323	2.0413

- Continued -

Natural Trigonometric Functions (Continued)

Deg	Function	0.0°	0.1°	0.2°	0.3°	0.4°	0.5°	0.6°	0.7°	0.8°	0.9°
64	sin	0.8988	0.8996	0.9003	0.9011	0.9018	0.9026	0.9033	0.9041	0.9048	0.9056
	cos	0.4384	0.4388	0.4352	0.4337	0.4321	0.4305	0.4289	0.4274	0.4258	0.4242
	tan	2.0503	2.0594	2.0686	2.0778	2.0872	2.0965	2.1060	2.1155	2.1251	2.1348
65	sin	0.9063	0.9070	0.9078	0.9085	0.9092	0.9100	0.9107	0.9114	0.9121	0.9128
	cos	0.4226	0.4210	0.4195	0.4179	0.4163	0.4147	0.4131	0.4115	0.4099	0.4083
	tan	2.1445	2.1543	2.1642	2.1742	2.1842	2.1943	2.2045	2.2148	2.2251	2.2355
66	sin	0.9135	0.9143	0.9150	0.9157	0.9164	0.9171	0.9178	0.9184	0.9191	0.9198
	cos	0.4067	0.4051	0.4035	0.4019	0.4003	0.3987	0.3971	0.3955	0.3939	0.3923
	tan	2.2460	2.2566	2.2673	2.2781	2.2889	2.2998	2.3109	2.3220	2.3332	2.3445
67	sin	0.9206	0.9212	0.9219	0.9226	0.9232	0.9239	0.9246	0.9252	0.9259	0.9265
	cos	0.3907	0.3891	0.3875	0.3859	0.3843	0.3827	0.3811	0.3795	0.3778	0.3762
	tan	2.3559	2.3673	2.3789	2.3906	2.4023	2.4142	2.4262	2.4383	2.4504	2.4627
68	sin	0.9272	0.9278	0.9285	0.9291	0.9298	0.9304	0.9311	0.9317	0.9323	0.9330
	cos	0.3746	0.3730	0.3714	0.3697	0.3681	0.3665	0.3649	0.3633	0.3616	0.3600
	tan	2.4751	2.4876	2.5002	2.5129	2.5257	2.5386	2.5517	2.5649	2.5782	2.5916
69	sin	0.9336	0.9342	0.9348	0.9354	0.9361	0.9367	0.9373	0.9379	0.9385	0.9391
	cos	0.3584	0.3567	0.3551	0.3535	0.3518	0.3502	0.3486	0.3469	0.3453	0.3437
	tan	2.6051	2.6187	2.6325	2.6464	2.6605	2.6746	2.6889	2.7034	2.7179	2.7326
70	sin	0.9397	0.9403	0.9409	0.9415	0.9421	0.9426	0.9432	0.9438	0.9444	0.9449
	cos	0.3420	0.3404	0.3387	0.3371	0.3355	0.3338	0.3322	0.3305	0.3289	0.3272
	tan	2.7475	2.7625	2.7776	2.7929	2.8083	2.8239	2.8397	2.8556	2.8716	2.8878
71	sin	0.9455	0.9461	0.9466	0.9472	0.9478	0.9483	0.9489	0.9494	0.9500	0.9505
	cos	0.3256	0.3239	0.3223	0.3206	0.3190	0.3173	0.3156	0.3140	0.3123	0.3107
	tan	2.9042	2.9208	2.9375	2.9544	2.9714	2.9887	3.0061	3.0237	3.0415	3.0595

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Section 9/General Reference Tables

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72	sin	0.9511	0.9516	0.9521	0.9527	0.9532	0.9537	0.9542	0.9548	0.9553	0.9558
	cos	0.3090	0.3074	0.3057	0.3040	0.3024	0.3007	0.2990	0.2974	0.2957	0.2940
	tan	3.0777	3.0981	3.1146	3.1334	3.1524	3.1716	3.1910	3.2106	3.2305	3.2508
73	sin	0.9563	0.9568	0.9573	0.9578	0.9583	0.9588	0.9593	0.9598	0.9603	0.9608
	cos	0.2924	0.2907	0.2890	0.2874	0.2857	0.2840	0.2823	0.2807	0.2790	0.2773
	tan	3.2709	3.2914	3.3122	3.3332	3.3544	3.3759	3.3977	3.4197	3.4420	3.4646
74	sin	0.9613	0.9617	0.9622	0.9627	0.9632	0.9636	0.9641	0.9646	0.9650	0.9655
	cos	0.2756	0.2740	0.2723	0.2706	0.2689	0.2672	0.2656	0.2639	0.2622	0.2605
	tan	3.4874	3.5105	3.5339	3.5576	3.5816	3.6059	3.6305	3.6554	3.6806	3.7062
75	sin	0.9659	0.9664	0.9668	0.9673	0.9677	0.9681	0.9686	0.9690	0.9694	0.9699
	cos	0.2588	0.2571	0.2554	0.2538	0.2521	0.2504	0.2487	0.2470	0.2453	0.2436
	tan	3.7321	3.7583	3.7848	3.8118	3.8391	3.8667	3.8947	3.9232	3.9520	3.9812
76	sin	0.9703	0.9707	0.9711	0.9715	0.9720	0.9724	0.9728	0.9732	0.9736	0.9740
	cos	0.2419	0.2402	0.2385	0.2368	0.2351	0.2334	0.2317	0.2300	0.2284	0.2267
	tan	4.0108	4.0408	4.0713	4.1022	4.1335	4.1653	4.1978	4.2303	4.2635	4.2972
77	sin	0.9774	0.9748	0.9751	0.9755	0.9759	0.9763	0.9767	0.9770	0.9774	0.9778
	cos	0.2250	0.2232	0.2215	0.2198	0.2181	0.2164	0.2147	0.2130	0.2113	0.2096
	tan	4.3315	4.3662	4.4015	4.4374	4.4737	4.5107	4.5483	4.5864	4.6252	4.6646
78	sin	0.9781	0.9785	0.9789	0.9792	0.9796	0.9799	0.9803	0.9806	0.9810	0.9813
	cos	0.2079	0.2062	0.2045	0.2028	0.2011	0.1994	0.1977	0.1959	0.1942	0.1925
	tan	4.7046	4.7453	4.7867	4.8288	4.8716	4.9152	4.9594	5.0045	5.0504	5.0970
79	sin	0.9816	0.9820	0.9823	0.9826	0.9829	0.9833	0.9836	0.9839	0.9842	0.9845
	cos	0.1908	0.1891	0.1874	0.1857	0.1840	0.1822	0.1805	0.1788	0.1771	0.1754
	tan	5.1446	5.1929	5.2422	5.2924	5.3435	5.3955	5.4486	5.5026	5.5578	5.6140

- Continued -

Natural Trigonometric Functions (Continued)

Deg	Function	0.0°	0.1°	0.2°	0.3°	0.4°	0.5°	0.6°	0.7°	0.8°	0.9°
80	sin	0.9848	0.9851	0.9854	0.9857	0.9860	0.9863	0.9866	0.9869	0.9871	0.9874
	cos	0.1736	0.1719	0.1702	0.1685	0.1668	0.1650	0.1633	0.1616	0.1599	0.1582
	tan	5.6713	5.7297	5.7894	5.8502	5.9124	5.9758	6.0405	6.1066	6.1742	6.2432
81	sin	0.9877	0.9880	0.9882	0.9885	0.9888	0.9890	0.9893	0.9895	0.9898	0.9900
	cos	0.1564	0.1547	0.1530	0.1513	0.1495	0.1478	0.1461	0.1444	0.1426	0.1409
	tan	6.3138	6.3859	6.4596	6.5350	6.6122	6.6912	6.7720	6.8548	6.9395	7.0264
82	sin	0.9903	0.9905	0.9907	0.9910	0.9912	0.9914	0.9917	0.9919	0.9921	0.9923
	cos	0.1392	0.1374	0.1357	0.1340	0.1323	0.1305	0.1288	0.1271	0.1253	0.1236
	tan	7.1154	7.2066	7.3002	7.3962	7.4947	7.5958	7.6996	7.8062	7.9158	8.0285
83	sin	0.9925	0.9928	0.9930	0.9932	0.9934	0.9936	0.9938	0.9940	0.9942	0.9943
	cos	0.1219	0.1201	0.1184	0.1167	0.1149	0.1132	0.1115	0.1097	0.1080	0.1063
	tan	8.1443	8.2636	8.3863	8.5126	8.6427	8.7769	8.9152	9.0579	9.2052	9.3572
84	sin	0.9945	0.9947	0.9949	0.9951	0.9952	0.9954	0.9956	0.9957	0.9959	0.9960
	cos	0.1045	0.1028	0.1011	0.0993	0.0976	0.0958	0.0941	0.0924	0.0906	0.0889
	tan	9.5144	9.6768	9.8448	10.02	10.20	10.39	10.58	10.78	10.99	11.20
85	sin	0.9962	0.9963	0.9965	0.9966	0.9968	0.9969	0.9971	0.9972	0.9973	0.9974
	cos	0.0872	0.0854	0.0837	0.0819	0.0802	0.0785	0.0767	0.0750	0.0732	0.0715
	tan	11.43	11.66	11.91	12.16	12.43	12.71	13.00	13.30	13.62	13.95
86	sin	0.9976	0.9977	0.9978	0.9979	0.9980	0.9981	0.9982	0.9983	0.9984	0.9985
	cos	0.0698	0.0680	0.0663	0.0645	0.0628	0.0610	0.0593	0.0576	0.0558	0.0541
	tan	14.30	14.67	15.06	15.46	15.89	16.35	16.83	17.34	17.89	18.46
87	sin	0.9986	0.9987	0.9988	0.9989	0.9990	0.9990	0.9991	0.9992	0.9993	0.9993
	cos	0.0523	0.0506	0.0488	0.0471	0.0454	0.0436	0.0419	0.0401	0.0384	0.0366
	tan	19.08	19.74	20.45	21.20	22.02	22.90	23.86	24.90	26.03	27.27

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88	sin	0.9994	0.9995	0.9995	0.9996	0.9996	0.9997	0.9997	0.9997	0.9998	0.9998
	cos	0.0349	0.0332	0.0314	0.0297	0.0279	0.0262	0.0244	0.0227	0.0209	0.0192
	tan	28.64	30.14	31.82	33.69	35.80	38.19	40.92	44.07	47.74	52.08
89	sin	0.9998	0.9999	0.9999	0.9999	0.9999	1.000	1.000	1.000	1.000	1.000
	cos	0.0175	0.0157	0.0140	0.0122	0.0105	0.0087	0.0070	0.0052	0.0035	0.0017
	tan	57.29	63.66	71.62	81.85	95.49	114.6	143.2	191.0	286.5	573.0
Deg	Function	0'	6'	12'	18'	24'	30'	36'	42'	48'	54'

Standard Twist Drill Sizes

Designation	Diam. (In.)	Area (Sq. In.)	Designation	Diam. (In.)	Area (Sq. In.)	Designation	Diam. (In.)	Area (Sq. In.)
1/2	0.5000	0.1963	3	0.213	0.03563	3/32	0.0938	0.00890
31/64	0.4844	0.1843	4	0.209	0.03431	42	0.0935	0.00887
15/32	0.4688	0.1726	5	0.2055	0.03317	43	0.0890	0.00822
29/64	0.4531	0.1613	6	0.204	0.03269	44	0.0860	0.00881
7/16	0.4375	0.1503	13/64	0.2031	0.03241	45	0.0820	0.00828
27/64	0.4219	0.1398	7	0.201	0.03173	46	0.0810	0.00815
Z	0.413	0.1340	8	0.199	0.03110	47	0.0785	0.00784
13/32	0.4063	0.1296	9	0.198	0.03017	5/64	0.0781	0.00479
Y	0.404	0.1282	10	0.1935	0.02940	48	0.0760	0.00454
X	0.397	0.1238	11	0.191	0.02865	49	0.0730	0.00419
25/64	0.3906	0.1198	12	0.189	0.02808	50	0.0700	0.00385
W	0.386	0.1170	3/16	0.1875	0.02761	51	0.0670	0.00353
V	0.377	0.1116	13	0.185	0.02688	52	0.0638	0.00317
3/8	0.375	0.1104	14	0.182	0.02602	1/16	0.0625	0.00307
U	0.368	0.1064	15	0.1800	0.02554	53	0.0595	0.00278
23/64	0.3594	0.1014	16	0.1770	0.02461	54	0.0550	0.00238
T	0.358	0.1006	17	0.1730	0.02351	55	0.0520	0.00212
S	0.348	0.09511	11/64	0.1719	0.02320	3/64	0.0473	0.00173
11/32	0.3438	0.09281	18	0.1695	0.02258	56	0.0465	0.001698
R	0.339	0.09026	19	0.1660	0.02164	57	0.0430	0.001452
Q	0.332	0.08657	20	0.1610	0.02036	58	0.0420	0.001385
21/64	0.3281	0.08456	21	0.1590	0.01988	59	0.0410	0.001320
P	0.323	0.08194	22	0.1570	0.01936	60	0.0400	0.001257
O	0.316	0.07843	5/32	0.1563	0.01917	61	0.039	0.001195
5/16	0.3125	0.07670	23	0.1540	0.01863	62	0.038	0.001134
N	0.302	0.07163	24	0.1520	0.01815	63	0.037	0.001075
19/64	0.2969	0.06922	25	0.1495	0.01755	64	0.036	0.001018
M	0.295	0.06835	26	0.1470	0.01697	65	0.035	0.000962
L	0.29	0.06605	27	0.1440	0.01629	66	0.033	0.000855
9/32	0.2813	0.06213	9/64	0.1406	0.01553	67	0.032	0.000804
K	0.281	0.06202	28	0.1405	0.01549	1/32	0.0313	0.000765
J	0.277	0.06026	29	0.1360	0.01453	68	0.031	0.000755
I	0.272	0.05811	30	0.1285	0.01296	69	0.0292	0.000670
H	0.266	0.05557	1/8	0.1250	0.01227	70	0.028	0.000616
17/64	0.2656	0.05542	31	0.1200	0.01131	71	0.026	0.000531
G	0.261	0.05350	32	0.1160	0.01057	72	0.025	0.000491
F	0.257	0.05187	33	0.1130	0.01003	73	0.024	0.000452
E 1/4	0.2500	0.04909	34	0.1110	0.00968	74	0.0225	0.000398
D	0.246	0.04753	35	0.1100	0.00950	75	0.021	0.000346
C	0.242	0.04600	7/64	0.1094	0.00940	76	0.020	0.000314
B	0.238	0.04448	36	0.1085	0.00891	77	0.018	0.000254
15/64	0.2344	0.04314	37	0.1040	0.00849	78	0.016	0.000201
A	0.234	0.04301	38	0.1015	0.00809	1/64	0.0156	0.000191
1	0.228	0.04083	39	0.0995	0.00778	79	0.0145	0.000165
2	0.221	0.03836	40	0.0980	0.00754	80	0.0135	0.000143
7/32	0.2188	0.03758	41	0.0960	0.00724			

Note: Designations are in fractions of an inch, in standard twist drill letters, or in standard twist drill numbers, the latter being the same as steel wire gauge numbers.

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CURRICULUM VITAE

NAME:

John Coulter Maddox

Birthdate:

January 30, 1950, In Bedford, VA

COLLEGE:

University of Virginia, College of Arts & Sciences
BA with Distinction in Biology in 1972
Dean's List 6 of 8 semesters
Phi Sigma Society (Biology Honorary)

MEDICAL SCHOOL:

University of Virginia, School of Medicine M.D. in 1976

BOARD CERTIFICATION:

Anatomic and Clinical Pathology (American Board of Pathology, 1982)
Voluntary Recertification (American Board of Pathology, 1998)
Hematology (Pathology) (American Board of Pathology, 1998)

LICENSURE:

Virginia # 0101032554

POST GRADUATE TRAINING:

Stanford University Medical Center, Stanford, California.
Department of Pathology: *Intern and Resident in Anatomic Pathology, 1976-1979, Chief Resident, 1978.*

M D Anderson Hospital & Tumor Institute, Houston, Texas
Branch of the University of Texas: *Fellow in Anatomic Pathology, 1979-1980.*

Medical College of Virginia, Richmond, Virginia. Branch of Virginia Commonwealth University, Department of Pathology: *Resident in Clinical Pathology, 1980-1981, and Fellow in Hematopathology, 1981-1982.*

CURRENT PRACTICE:

Riverside Regional Medical Center
Pathology Department
500 J Clyde Morris Blvd.
Newport News, VA 23601
(757) 594-2870 -2951 FAX
john.maddox@rvhs.com

rev. 3-15-2016



- ARTICLES:** Roggli, Hammar, Maddox, and Henderson: Re: The "Helsinki Criteria" for attribution of lung cancer to asbestos exposure: how robust are the criteria? Arch Pathol Lab Med. 2008 Sep;132(9):1386-1387.
- Green, Maddox & Huttenbach: Linezolid and Reversible Myelosuppression (Research Letter) JAMA 285(10):1291, March 2001. In reply JAMA 286(16):1974, Oct.2001.
- Legier & Maddox: Massive Ovarian Lymphatic Displacement of Granulosa Cells. Journal of Surgical Pathology 2 1-2,1996
- Roggli, Hammar, Pratt, Maddox, Legier, Mark & Brody: Commentary - Does Asbestos or Asbestosis Cause Carcinoma of the Lung? American Journal of Industrial Medicine 26: 835-838 1994
- Legier & Maddox: "Immunohistochemical Diagnosis of Mesothelioma," in the monograph The Mesothelial Cell and Mesothelioma, Marie-Claude Jaurand and Jean Bignon, editors, in the series Lung Biology in Health and Disease vol 78, Claude Lenfant, executive editor Marcel Dekker, Inc. New York, 1994, pages 103-119.
- Craighead, Calore, Corson, Copeland, Maddox, and Sporn: The pathogenic role of growth factors in human and rat malignant mesotheliomas. Eur Respir Rev. 1993, 3:11, 159-160.
- McClellan, Maddox & Innes: Platelet Vacuoles in Acute Megakaryoblastic Leukemia. American Journal of Clinical Pathology 92:700-702,1989
- Behm, Maddox & deBlois: Systemic Mastocytosis. ASCP Check Sample in Anatomic Pathology 10(10), AP82-10, 1982.
- Maddox & Evans: Angiosarcoma of Skin and Soft Tissues: A Study of 44 Cases. Cancer 48:1907-1921, 1981.
- Ryning, McLeod, Maddox, Hunt & Remington: Probable Transmission of *Toxoplasma gondii* by Organ Transplantation. Ann Intern Med 90:47-49, 1979.

ABSTRACTS:

- Finkelstein & Maddox Needle Biopsy with Flow Cytometry in the Diagnosis of Lymph Node Malignancies. Virginia Society of Hematology & Oncology, June 1998.
- Maddox & Harden: The Riverside Lymphoma Experience, 1986 - 1994 Virginia Society of Hematology & Oncology, June 1996.
- Maddox & Behm: Immunoblastic Lymphoma of the Breast in a Patient with Waldenstrom's Macroglobulinemia. Virginia Society of Hematology, June 1982.
- Maddox & Behm: Coexisting Mycosis Fungoides and Hodgkin's Disease. Virginia Society of Hematology, June 1981 (also printed in Virginia Medical Monthly 108(10) 673, October 1981. rev. 3-15-2016

SPEAKER: Perrin Asbestos Conference, September 19-21, 2011. San Francisco, CA. "Advancement in Asbestos Medicine." Invited panelist, along with Drs. Roggill, Graham, and Brody.

AWARDS: Honorable Mention (5th Place), M D. Anderson Hospital 1980 Annual Clinical Research Project Competition.

Clinical Fellowship of the American Cancer Society (Pathology - Hematology, 1981-1982).

PROFESSIONAL ORGANIZATIONS: Houston Society of Clinical Pathologists, 1979-80.
Richmond Blood Club, 1980-1982.
Tissue Culture Association, National Capitol Area Branch, 1981-1982
College of American Pathologists, 1982-present
Newport News Medical Society, 1982-present
Virginia Society for Pathology, 1981-present; Program Director, 1988 & 1991, Delegate to Medical Society of Virginia, 1989-1993; Board of Directors, 1989-1995, President, 1991
Virginia Society of Hematology and Oncology, 1980-present
American Society of Hematology, 1987-present
Medical Society of Virginia, 1989-present
Tidewater Pathology Society, 1982-present
Pulmonary Pathology Society, 2001-present

PROFESSIONAL ACTIVITIES: Flow cytometry - read 300 cases / year
Bone marrow exams - draw 175+ / year, read 275 / year
Molecular genetics - read 175+ FISH evaluations / year
Lung pathology (Asbestos related disease), about 100 consults per year
Mansville Trust Review Panel, member, 1989-present.

Hematology Section Director (RRMC)- 358,000 automated procedures/ yr

Electron Microscopy - started and directed service from 1984-2000, JEOL 100CX TEM, SEM; Also, Energy Dispersive X-ray Microanalysis, using Kevex 7000, EDAX 9900, and JEOL Electron Microprobe.

Flow Cytometry - started and developed service from 1988-present, Certificate from Coulter School of Flow Cytometry.

HOSPITAL COMMITTEES: Surgical Case and Blood Utilization Review Committee, 1984-1993; Chairman 1985-90.
Oncology Committee, member 1989 - 2007.
Medical Quality of Patient Care Committee, member 2007 - present.
Radiation Safety Committee, member 1990 - 2003.
Executive Committee, Hampton Roads Specialty Hospital, 2006-present.

rev.3-15-2016

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MEMORANDA

1. Plaintiffs' Exhibit 1008.9774:
07/15/1985 - Fisher memo to Plant Managers, subject *Asbestos Elimination Program*
2. Plaintiffs' Exhibit 1008.1497:
09/26/1985 - Fisher memo to All Sales Reps (US, Asia, & Latin America), subject *Asbestos Elimination Program*
3. Plaintiffs' Exhibit 1008.1498:
11/01/1985 - Fisher memo: remaining stock of asbestos gaskets, subject *Asbestos Replacement Program*
4. Plaintiffs' Exhibit 1008.1496:
12/17/1985 - Fisher memo, subject Asbestos Elimination Program (update)
5. Plaintiffs' Exhibit 1008.1495:
01/05/1987 - Fisher memo, subject Asbestos Gaskets and Packing (update)
6. Plaintiffs' Exhibit 1008.1494:
03/03/1987 - Fisher memo, subject Asbestos Elimination Program, beginning to phase out A-C packing.
7. Plaintiffs' Exhibit 1008.1493:
April 1987 -- Fisher Control's *The Control Line*, Fisher employee newsletter, Issue No. 251, subject Asbestos Elimination Program
8. Plaintiffs' Exhibit 1008.1492:
11/03/1987 - Fisher memo from Roy Brodin, subject Asbestos in Fisher Products
9. Plaintiffs' Exhibit 1008.1490:
01/26/1985 - Fisher memo from Dale Stepanek, subject Asbestos Elimination Program

MATERIAL SPECIFICATIONS

1. Plaintiffs' Exhibit 1008.1955:

02/15/1988 - Fisher Mat. Spec.: High Grade Long Fibre Asbestos Sheet Gasket material

2. Plaintiffs' Exhibit 1008.1956:

02/22/1988 - Fisher Mat. Spec.: High Grade Long Fibre Asbestos Sheet Gasket material

3. Plaintiffs' Exhibit 1008.1957:

09/13/1983 - Fisher Mat. Spec.: High Grade Long Fibre Asbestos Sheet Gasket material

- Shows approved materials: Durabla and Johns Manville JM78

4. Plaintiffs' Exhibit 1008.1959:

02/15/1988 - Fisher Mat. Spec.: Asbestos Gasket Sheet with Non-Sticking Qualities

**Specifically mentions "when clamped between flanges it must not stick to the flanges"

5. Plaintiffs' Exhibit 1008.1960:

02/15/1988 - Fisher Mat. Spec.: Asbestos Gasket Sheet with Non-Sticking Qualities

- Shows approved materials: Garlock Style No. 900/7735 and Nicollet No. 240.

6. Plaintiffs' Exhibit 1008.1964:

02/15/1988 - Fisher Mat. Spec.: Heavy Duty Elastomer-Bound Asbestos Gasket Material

Specification listing approved sources of nitrile elastomer bound asbestos gasket material.

*Shows approved materials: Armstrong Accobest AN-8012.

7. Plaintiffs' Exhibit 1008.1963:

02/15/1988 - Fisher Mat. Spec.: Heavy Duty Elastomer-Bound Asbestos Gasket Material

Specification listing approved sources of nitrile elastomer bound asbestos gasket material.

- Shows approved materials: Armstrong Accobest AN-8012.

8. Plaintiffs' Exhibit 1008.1964:

02/15/1988 - Fisher Mat. Spec.: Heavy Duty Elastomer-Bound Asbestos Gasket Material
Specification listing approved sources of nitrile elastomer bound asbestos gasket material.

- Shows approved materials: Armstrong Accobest AN-8012; John Crane Super-Seal No. 3; Garlock No. 235; Garlock No. 233; Palmetto String Packing

9. Plaintiffs' Exhibit 1008.1971:

04/15/1987 - Fisher Mat. Spec.: Graphited Asbestos Packing
Specification listing approved sources of graphited asbestos packing material.

- Shows approved materials: Argo Packing Co.

10. Plaintiffs' Exhibit 1008.1972:

04/15/1987 - Fisher Mat. Spec.: TFE Asbestos Packing. (Graphited Asbestos Packing)
Specification listing approved sources of graphited asbestos packing material

- Shows approved sources of materials: Argo Packing Co. and Martin Merkel Packings

11. Plaintiffs' Exhibit 1008.1973.

04/11/1986 - Fisher Mat. Spec.: High Temperature Aluminum Packing
Specification listing approved sources of graphited asbestos packing material

- Shows approved sources of materials: Durametallic Style D-110 or D-10 for metallic rings and Durametallic Style D-222 or D-2 for plastic rings.

12. Plaintiffs' Exhibit 1008.1977.

04/22/1987 - Fisher Mat. Spec.: Square Braided Asbestos - Graphite Packing
Specification listing approved sources of graphited asbestos packing material

- Argo Packing Co.
- Johns-Manville Style No. 2014
- Garlock, Inc. No. 5561
- Martin Merkel, Inc.

13. Plaintiffs' Exhibit 1008.2331

07/01/1986 - Fisher Mat. Spec.: Special Handling for Low-Chloride Gasket Material

Specification listing approved sources: Flexitallic spiral wound gaskets

14. Plaintiffs' Exhibit 1008.2332

07/25/1985 - Fisher Mat. Spec.: Special Handling for Low-Chloride Gasket Material

Specification listing approved sources: Flexitallic spiral wound gaskets

CONFIDENTIAL

FISHER

Memorandum

To: Plant Coordinators

From: Dale Stepanek -
Marshalltown
cc: Tony Casciato
Larry Solley

July 15, 1985

Date: Asbestos Elimination Program

Subject:

drafts
cc: Clem Johnson
Cliff Lister
Tom Blazek - G2WB
Ken Winter - G57W
Ken Miller
gms
ms

Congratulations on your selection as Plant Coordinator for the Asbestos Elimination Program at your location. I look forward to working with you on this important corporate objective. As a Plant Coordinator, you are requested to assume the responsibility for implementing this program in your area. Your efforts will be vital to the success of this project.

The Asbestos Elimination Program was initiated as a result of the increasing safety and liability concerns of our customers and suppliers, many of whom have already eliminated asbestos from their products. Our goal on this program is to eliminate asbestos from all Fisher products by the end of 1985.

Enclosed, you will find an asbestos elimination timetable. This graphically shows key events and the estimated durations required to meet our year-end mandate. Specific activities and timeframes will vary from site to site, but generally, each site will need to:

1. Identify affected in-house parts.
2. Procure approved substitutes.
3. Phase-in new parts/phase-out old parts.*
4. Modify local literature, if applicable.
5. Publicize program where appropriate.

*We have targeted November 1, 1985, as the date we will begin to scrap any remaining asbestos stock. This will allow us two months to resolve any problems before our year-end deadline.

I would like each of you to submit a Site Activity Plan by August 15, 1985. I have enclosed, as an example, the Site Activity Plan for Marshalltown. These plans are not intended to be binding contracts, but a way for us to identify the key activities and individuals involved at each plant. They will also help us recognize any situation at your site requiring special support or coordination.

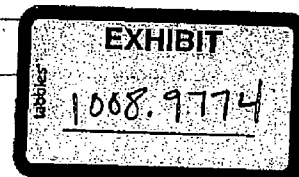
No 5
Enclos.

EXHIBIT

10

hp Litigation Services

calafish_09774



CONFIDENTIAL

-2-

You will find product release documents included in this packet covering flat sheet, spiral wound, and metal jacketed gaskets. The description explains how substitute gaskets are to be handled. Please read this document carefully and determine how these changes relate to your location. The attached parts list includes all affected gaskets within the Fisher system. You will later receive similar documents covering valve packing. Only approved materials as described in the enclosed Fisher material specifications should be used for replacement.

I will be providing additional information and program updates as the year progresses. Let me know if I can answer any questions or provide assistance in any way. Thanks in advance for your support and cooperation.

Regards,

Dale Stepanek
Dale Stepanek

5520/DS:mc

Enclosure

calafish_09775--

ROA_03534

ROA_03535

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FISHER

Memorandum

To: ALL NORTH AMERICA, EMA,
ASIA-PACIFIC AND LATIN AMERICA
SALES REPRESENTATIVES

From: Dale Stepanek -
Marshalltown
cc: Larry Mueller
Larry Solley
Jim Teegarden

Date: September 26, 1985

Subject: Asbestos Elimination Program

*cc: Reg White - CS7W
Tom Blank - CS7W
10/1/85
ug
F*

All Fisher sales offices and representatives should be aware of a company-wide program to eliminate asbestos from Fisher products. This has come as the result of an industry-wide movement to discontinue the use of this controversial material. Many suppliers, manufacturers, and end-users have already implemented asbestos substitution programs within their companies. Fisher's goal is to remove asbestos containing parts from all stock and inventories by the end of this year. After that time, asbestos containing parts will be made available only on a special order basis to accommodate specific customer needs.

Parts affected by this program include gaskets and valve packing. Flat sheet gaskets containing asbestos will be replaced in all products by aramid, fiber/nitrile gaskets up to 450°F and graphite gaskets above 450°F. Asbestos fillers in spiral wound gaskets will be replaced by mineral based fillers. Users of oxygen-service products should be consulted on an individual basis to determine satisfactory gasket substitutes. Asbestos containing packing will not be available as a Price Book option after this year. Major suppliers, including Crane, Garlock, and Parker no longer offer asbestos containing packing and the material is becoming difficult to obtain. Fisher has initiated a project to identify and evaluate new packing substitutes and the results will be communicated as they become available. You are encouraged to discuss this matter with your customers, especially those who currently specify asbestos containing parts. We must be firm yet flexible in handling this situation with a minimum impact on our customers. Their sensitivity in accepting these changes must be determined and maximum efforts made to accommodate them during this transition. It is important that everyone realize Fisher is attempting to serve their interests in the best way possible.

Please keep us advised of problems and progress.

Dale Stepanek
Dale Stepanek

5520/ea

APPROVED BY:

A. C. Casciato
A. C. Casciato

FC_1497

PLAINTIFF'S
EXHIBIT

1808:1497

ROA_03536

CONFIDENTIAL

FISHER

Memorandum

To: Ron Patton
Kevin Mogard
Max Montz
Dale Dolezal

Herb Rickert
Neal Fogle
Rick Miller
Jane Tesar

From: Mike Wells

cc: Craig Anderson
Bill Landholt
Dale Stepanek
Fred Luthe
Gary Icenogle
Cliff Viers
Larry Fleetwood
Gary Petermeier

Date: November 1, 1985

Subject: Asbestos Replacement Program
October 23, 1985 Meeting Minutes

The meeting on October 23, 1985, was held to update the status of the asbestos elimination efforts at Fisher's Marshalltown site and to determine what steps need to be taken to finalize this project. Although the program initially addressed gaskets only, packing materials will now be included in the project scope.

GASKETS

By the end of May, 1985, Design Engineering had changed the material codes on all gaskets containing asbestos to non-asbestos codes. Any new orders for gaskets were purchased to the new gasket material specifications. Stores personnel were instructed to rotate gasket stock to use the asbestos containing gaskets first. It was anticipated that stocked gaskets would turn over quickly enough that normal stock rotation would deplete inventory of asbestos gaskets by the target date. Slow turn-over and non-stock items would be monitored by Inventory Control. If normal turnover did not deplete stock, gaskets to the new material specifications would be ordered and old stock would be purged. The process of purchasing non-asbestos gaskets to complete this phase was started early in October.

Two problems have been identified. The first involves oxygen service valves. No suitable non-asbestos gasket has been agreed upon between Fisher and our customers for this critical service. Until a replacement is found and adequately tested, we will continue to provide asbestos gasket material for oxygen service only. The second problem involved the need for a tighter tolerance on sixteen gaskets for E-bodies than was called out on the general specification. Changes have been made to correct this problem, and Cooper is sorting gaskets to provide us stock with the proper tolerances.

The following plan of action will be used to purge the remaining asbestos gaskets from stock and dispose of them:

1. Inventory Control will supply a list of part numbers of all asbestos containing gaskets to Herb Rickert.
2. Stores personnel will perform a physical inventory on these items. They will provide a count of asbestos and non-asbestos gaskets at each stock location. For metal jacketed gaskets, stores will count by package dates before and after June 1, 1985.
3. Inventory Control will determine if stock of non-asbestos gaskets is adequate to meet production needs. Where adequate stock of new gaskets is available, Inventory Control will provide those part numbers to Stores to purge the asbestos gaskets. For those part

FC-1498



ROA_03537

CONFIDENTIAL

numbers where stock is not available or is presently on order, those parts will be purged only when new gaskets are available.

4. Stores will remove all asbestos containing gaskets from stock and remove to a designated holding area for hazardous materials. They will also check that the non-asbestos gaskets left in stock are correctly labeled. Gaskets should be scrapped to the obsolete inventory account.
5. When all asbestos gaskets are purged, material will be disposed of at the landfill using proper handling and disposal procedures provided by Sam Cheng.

Additionally, operations needs to inform the shop to clean out all extra gaskets in bench stock and remove to the holding area for disposal.

Marketing needs to send out a note to service centers and representatives to stop returned goods for gaskets (restocking of asbestos gaskets at Fisher Marshalltown).

Cost accounting will be informed of increased gasket costs for the next implosion.

Harb Rickart will have his people purge any asbestos gaskets from the unallocated warehouse.

Parts kits and Supermarket items will not be torn down to change out gaskets. Gaskets that have been allocated for existing orders will not be changed over.

Cost impact of scrap will be available after the physical inventory by Stores.

PACKING

The original intent of engineering was to replace all asbestos containing packing materials with either Teflon (TFE) or grafoil type materials. Both of these materials are currently approved and used at Fisher. Neal Rinehart and Dale Stepanek recently attended a VMA Technical Seminar on New Packings and Gasket Materials. At this seminar, many companies expressed concern about eliminating asbestos packing materials without extensive testing on proposed replacement materials to assure compatibility with their processes. Because many of Fisher's major customers are in agreement with these views, we need to be able to continue to supply asbestos containing packing where requested. Customers will be directed toward using the non-asbestos packings where feasible. Further complicating matters, several of our major packing vendors (including Crane) have stopped producing asbestos containing packing.

Engineering has undertaken a two-part testing program to address the packing problem. The first part of the program is aimed at testing asbestos containing packing materials from new vendors. This will enable Fisher to supply packing materials until appropriate non-asbestos replacements can be found. The search for and approval of replacement packing is the second part of the testing program. This part will include in-house testing of non-asbestos substitutes over the next 3-6 months and possible field testing to assure customer acceptance.

FC_1499

CONFIDENTIAL

At this time, purchasing is involved in supporting the search for new vendors of both asbestos and non-asbestos packing. No stock will be purged until further direction is obtained from Engineering and Marketing.

If there are any questions concerning the direction being taken on the replacement of asbestos gaskets or packing, please contact me.

Sincerely,

Mike Wells

Mike Wells

/kt

FC_1500

ROA_03539

CONFIDENTIAL

FISHER

Memorandum

To: Distribution List

From: Dale Stepanek

cc: Tony Casciato
Larry Solley

Date: December 17, 1985

Subject: ASBESTOS ELIMINATION PROGRAM UPDATE

cc: Bill Johnson
Tom Bente-Bozals
Ziff

Fisher's asbestos elimination program is progressing smoothly with excellent cooperation from all plant locations. Existing inventories of asbestos containing gaskets and packing are being depleted. We will be in a position to effectively provide to customers Fisher products without asbestos containing parts by January 1. Although our program has progressed extremely well, it is now clear that many of our major customers are only just beginning to consider asbestos elimination programs. There is evidence that many customers are not willing to immediately make the transition from asbestos gaskets and packing until they have completed their own internal testing of alternate materials.

To ensure that we continue to be responsive to customer needs Fisher will be required to provide, on a special order basis, products containing asbestos materials for some time yet in the future. Recognizing this, and to ensure that we do not precipitously write-off unused inventories of gaskets and packing, we have extended the target date for transition on standard products to non-asbestos materials to April 1, 1986. After this date, products containing asbestos materials will be provided only on a customer order basis and we do not intend to maintain any inventory parts containing asbestos materials. Response to the asbestos elimination program has been very positive and it is important that Fisher assume a leadership role in executing this transition. Your continued support will be appreciated and if there are any questions or concerns please contact me.

Dale Stepanek

Dale Stepanek

/mak

FC-1496

ROA_03540



CONFIDENTIAL

TO: Ron Allen
Jeff Klatt

FROM: Roy Bredin

CC: Ted Insland
Herb Rich

DATE: January 5, 1987

SUBJECT: Asbestos Gaskets and Packing

At the December meeting of the LPPB, I was asked to check on the status of asbestos parts used in Fisher products. The status is as follows:

Packing

A non-asbestos substitute material has been identified. The problem is how to make the implementation, which is primarily a documentation problem. A main consideration is traceability. If we simply reassign the existing Material Reference Nos. and use the existing part numbers, we will not have traceability. However, we probably will do just that and scrap the old stock. It will probably be mid-1987 before the implementation is complete.

If a customer insists on asbestos packing we may still provide it if we can obtain the packing. However, some suppliers of packing, such as Crane, are getting out of the asbestos packing business, so we will reach the point where we simply refuse to provide it.

Gaskets

Asbestos containing gaskets have been replaced with gaskets that do not contain asbestos, except that several flat sheet asbestos gaskets that have been used in oxygen service are presently still active. These will be obsoleted as soon as Marketing can determine our oxygen service customers' preference for acceptable alternate materials.

All asbestos containing gasket stock was purged from the Marshalltown inventory on April 20, 1986, except that subsequently a small amount of sheet stock was purchased for making gaskets for oxygen service.

Listings of the affected part numbers were sent, by the Marketing Product Manager, to the assigned site coordinator at each Fisher site so that the asbestos elimination could be coordinated throughout all Fisher sites.

We will continue to provide asbestos gaskets if the customer insists. — *HW/CLC 7*

Roy

FC_1495



ROA_03541

CONFIDENTIAL

FISHER

Memorandum

To: All U.S. Representatives
(Main Offices Only)
ATTN: President

From: Kent Rummelhart -
Marshalltown
cc: Dale Stepanek
Dan Button
Kevin Mogard
Area Sales Directors

Date: March 23, 1987

Subject: Asbestos Elimination Program

Fisher Controls is in the final phase of our Asbestos Elimination Program. After this year, our policy will be to supply no parts or assemblies containing asbestos under any circumstances. This will require the elimination of all remaining asbestos containing inventories (primarily packing) during 1987.

Asbestos containing gaskets have already been removed from our worldwide inventories. With successful tests completed on packing substitutes, equal or superior materials have been identified for all previous asbestos containing valve parts. Engineering documentation on packing parts is currently being revised to reflect the new materials.

Effective immediately, Marshalltown and Sherman will begin phasing out asbestos containing packing. The complete elimination of asbestos containing packing inventories will be realized on or before July 1, 1987 in Sherman and Marshalltown.

All sites worldwide will dispose of any remaining asbestos containing parts once and for all by December 31, 1987.

For your reference, a list of affected packing part numbers and material codes are attached. Part numbers for the new packing will remain the same as the old material codes changing. Previous information has been distributed concerning asbestos packing discontinued by our suppliers and recommended substitutes.

If you have any questions regarding this correspondence or the Asbestos Elimination Program in general, please contact me at 515-754-3680 in Marshalltown.

Please see that this is distributed to the proper people within your organization. Thank you for your cooperation.

Kent Rummelhart
Kent Rummelhart
Application Engineer
5520/KR:mc

Attachment

APPROVED BY: *James A. Carey*
James A. Carey

FC_1494



ROA_03542

FISHER

The Control Line

Issue Number 251

April 1987

41

DALE STEPANEK

CVR MKTG

MO

CONFIDENTIAL

Asbestos Elimination Update

Fisher is in the final phase of its worldwide asbestos elimination program. Testing is complete and equal or superior non-asbestos materials have been identified for all asbestos containing valve parts.

Marshalltown and Sherman will begin phasing out asbestos containing packing immediately, with complete change over to be realized on or before July 1, 1987.

All sites worldwide will dispose of any remaining asbestos containing inventories on or before December 31, 1987. After December 31, 1987, our policy will be to supply no asbestos containing parts or assemblies under any circumstances.

If you have any questions regarding this program, call Kent Rummelhart, Don Steadham or Dale Stepanek in Marshalltown.

Rationalization: Regulators/Strainers/Filters

This is a reminder that Fisher is dropping some offerings due to extremely low sales volume. Orders for the following 'series' products will be filled only as long as inventory is available: 67G, 67GR, 67Y, 67YR, 122, 165, 289B, 413, 610, 611, 612, 613, 262C (1/4 & 1/2-inch sizes only), 260B, 260C (1/4, 3/8, 1/2 & 1 1/4-inch sizes only) and P595.

McKinney Phone System Adds D.I.D. Service

Effective Monday, April 6, McKinney telephone system will provide Direct-In-Dialing service for all incoming calls. It was necessary to change the existing 200-series internal extension numbers to 500-series numbers. (Example: Ext. 211 changed to Ext. 511.) The 100-series numbers will not change.

To place a D.I.D. call to McKinney, dial 214-548-3 + (3-digit ext.#).

If you have any questions or problems with this service, please call Barbara Fletcher (214-548-3114).

Training More Flexible With On-Site Schools

The Fisher Education courses as presented at the factory training centers are designed to satisfy the requirements of a broad client base. To satisfy the specific needs of an individual client, course content can be focused to specialized interest areas for delivery at the factory, at your office, or at the clients' locations.

Customized on-site schools have recently been conducted by the Educational Services group for GE, Amoco, 3M, Monsanto, Eastman Kodak, Chevron, Weyerhaeuser, Union Carbide, Mobay Chemical and others.

A price sheet with on-site school offerings for 1987 is included in the April mailing of catalog publications and should be added to your Order Entry Document Vol. II book. Commissions will be given for factory training conducted at a customer's location or at your office.

For further information on availability and pricing, contact Dorothy Holberg, Marshalltown Education at Ext. 3700.

School Status Report (As of 3-24-87)

Course #	Schools	Dates	Species Area
PROVOX HP Based			
4000	Configuration I	Apr. 20-24	8
		June 1-5	14
4100	Configuration II	June 8-12	16
4200	UOC	Mar. 18-27	1
		May 4-15	2
4300	CHIP	Apr. 6-10	13
4400	Maintenance	June 8-12	13
3000	not Maintenance	May 4-15	2
		Apr. 6-10	13
PROVOX DEC Based			
5000	Control	June 1-5	8
5100	Systems	Apr. 6-10	7
		Apr. 27-May 1	1
		May 4-8	10
		May 11-15	1
		June 8-12	13
5200	UOC +	Apr. 20-May 1	2
		June 1-12	8
		June 15-25	5
5300	IPC	June 15-18	6
5400	CHIP (DEC PRO)	Apr. 20-24	9
		May 10-22	10
5500	System Maintenance	Apr. 20-May 1	8
		June 15-28	0
FCS/MI/Internat			
8002	Chemical Industry Conference	May 4-8	45
1300	Valve Engineering	May 11-15	10
0230	Syn/UOC + Transition (Rep)	May 18-22	2
1100	Instrument Engineering	May 18-22	12
0020	Selling Skills	May 27-29	15
0210	DEC PRO 380 Maintenance	May 28-29	5
0220	DEC Console Maintenance	June 1-5	5
0115	Control Valve Seminar	June 2-3	45
1000	Gas Conference	June 15-19	34
1400	Valve Technician	June 22-26	14
1200	Pneumatic Inst. Tech.	June 29-July 2	19

*Austin school

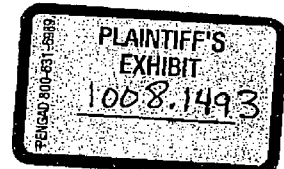
MI Success Stories On Video-Tape

To assist the field sales effort on behalf of MI products, a video-tape set titled "MI Success Stories" is being distributed to all North American representative offices. The stories are presented by Fisher inside and outside salespeople during MI schools.

The tapes discuss door-opening techniques, competitive selling, actual sales calls, problem solving and sales strategies used in bolstering MI sales and promoting Fisher as the total loop solution.

If you have not received your office's package by April 15, please contact Kevin Wilbeck in Austin (Ext. 7687).

FC_1493



ROA_03543

~~CONFIDENTIAL~~

FISHER

15a
11/4/87
ya: Glen
John Ellis
Lynn Flanagan
Memorandum

To: Ron Allen - GR
Terry Buzzbee GR

From: Roy Brodin

cc: Al Hays
Ted Insländ

Date: November 3, 1987

Subject: Asbestos in Fisher Products

At the October LPPB meeting, I reported that as of this past summer Marshalltown was not, and would not, ship any products containing asbestos. Terry raised the question about the 20" EH's for AEP that are shipped with non-asbestos packing knowing that AEP is replacing that with packing that contains asbestos.

I discussed this with Al Hays. We are experiencing field problems with the non-asbestos packing in that we are not getting the life we want. There is an active project to solve this problem. However, AEP wanted an 18 month life and found that they could achieve this with Argo packing, which contains asbestos. We have tested this packing and are using it for comparison purposes. Anyway, we are shipping these EH valves with non-asbestos packing that does work, but not as well as we would like.

Roy

Roy Brodin

FC_01492



ROA_03544

CONFIDENTIAL

FISHER

Memorandum

File 6.6

To: Milt Blevins
Caltrol

From: Dale Stepanek

-- FAX --

cc: K. Rummelhart

Date: January 26, 1989

Subject: ASBESTOS ELIMINATION PROGRAM

Attached is the last correspondence to the field regarding the asbestos elimination program. Total elimination of asbestos from Fisher parts and assemblies was completed on schedule as indicated on December 31, 1987. All Fisher products shipped after this date have been and will continue to be asbestos free.

Regards,

Dale Stepanek
Dale Stepanek

/jo



FC_01490

ROA_03545

Fisher Controls

Material Specification

HIGH GRADE LONG FIBRE ASBESTOS SHEET
GASKET MATERIAL

FISHER®

No. FMS 17A2 E

By CWW 8-7-73

Apvd TKB 9-14-82

Page 1 of 1

©Fisher Controls 1983

Rev WHH 2-15-88

1. SCOPE

OBSELETE

This specification lists the approved source(s) for elastomer bound asbestos gasketing and describes the composition of the approved source(s), their surface resistance, general usage, product name; and all approved substitutes for the approved sources.

2. MATERIAL REFERENCE NO. 0402

3. MATERIAL COMPOSITION

The material, as covered by this specification, shall be a compressed asbestos type sheet consisting of about 80-85% asbestos fibers with about 15-20% elastomeric binder.

4. SURFACE RESISTANCE OF MATERIAL

The material surfaces shall be resistant to sticking to metals such as brass, aluminum, and steel. The material shall be resistant to compression relaxation under heavy loads.

5. GENERAL USAGE OF MATERIAL

The material shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical, and general processing type industries.

6. MATERIAL SUBSTITUTION

The approved material(s) listed under FMS 17A4 may be substituted for the approved material(s) listed below. The substitution may be made provided:

- (a) The service conditions are acceptable to allow substitution.
- (b) The gasket cutter can furnish cut parts at prices equivalent to those for FMS 17A2 material.

FMS 17A2 material may not be substituted for FMS 17A4 material.

7. APPROVED SOURCE(S)

The following material(s) have been approved:

- (a) Durabla -
Durabla Manufacturing Co.
Paoli, PA 19301

FMS1-13/1

OBSELETE

Superseded by
FMS 17A5 or
17F38

FC_01955

Form FC3083/Printed in USA



ROA_03546

Fisher Controls

Material Specification

No. FMS 17A2 **(D)**HIGH GRADE LONG FIBRE ASBESTOS SHEET
GASKET MATERIAL**FISHER®**

By CWW 8-7-73

Apvd TKB 9-14-82

Page 1 of 1

©Fisher Controls 1983

Rev MRP 9-7-83

OBsolete1. SCOPE

This specification lists the approved source(s) for elastomer bound asbestos gasketing and describes the composition of the approved source(s), their surface resistance, general usage, product name; and all approved substitutes for the approved sources.

2. MATERIAL REFERENCE NO. 04023. MATERIAL COMPOSITION

The material, as covered by this specification, shall be a compressed asbestos type sheet consisting of about 80-85% asbestos fibers with about 15-20% elastomeric binder.

4. SURFACE RESISTANCE OF MATERIAL

The material surfaces shall be resistant to sticking to metals such as brass, aluminum, and steel. The material shall be resistant to compression relaxation under heavy loads.

5. GENERAL USAGE OF MATERIAL

The material shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical, and general processing type industries.

6. MATERIAL SUBSTITUTION

The approved material(s) listed under FMS 17A4 may be substituted for the approved material(s) listed below. The substitution may be made provided:

- (a) The service conditions are acceptable to allow substitution.
- (b) The gasket cutter can furnish cut parts at prices equivalent to those for FMS 17A2 material.

FMS 17A2 material may not be substituted for FMS 17A4 material.

7. APPROVED SOURCE(S)

FEB 22 1988

OBsolete
 SUPERSEDED BY
 FMS 17A2 OR
 17F28

The following material(s) have been approved:

- (a) Durabla -
Durabla Manufacturing Co.
Paoli, PA 19301

FMS1-13/1

MAJOR REVISION

ECR/W NO. DATE
 BY W/H CHD DRB APVD NFR
 840, OLD STOCK 830, REASON
 1 - USE 1 - SAFETY 8 - STOCK
 2 - REWORK 2 - MATL 8 - COST
 3 - SCRAP/NEW 3 - IMPROVE 7 - MKTD/
 4 - SCRAP NOW 4 - ERROR SELL
 Make obsolete - no longer
 use asbestos

FC_01956

Form FC0863/Printed in USA

ROA_03547



Fisher Controls

Material Specification

HIGH GRADE LONG FIBRE ASBESTOS SHEET
GASKET MATERIAL**FISHER®**

No. FMS 17A2 (C) D

By CWW 8-7-73

Apvd TKB 9-14-82

Page 1 of 1

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Rev 22W 9-14-82

1. SCOPE

This specification lists the approved source(s) for nitrile elastomer bound asbestos gasketing and describes the composition of the approved source(s), their surface resistance, general usage, product name; and all approved substitutes for the approved sources.

2. MATERIAL REFERENCE No. 0402

3. MATERIAL COMPOSITION

The material, as covered by this specification, shall be a compressed asbestos type sheet consisting of about 80-85% asbestos fibers with about 15-20% nitrile type elastomeric binder.

4. SURFACE RESISTANCE OF MATERIAL

The material surfaces shall be resistant to sticking to metals such as brass, aluminum, and steel. The material shall be resistant to compression relaxation under heavy loads.

5. GENERAL USAGE OF MATERIAL

The material shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical, and general processing type industries.

6. MATERIAL SUBSTITUTION

The approved material(s) listed under FMS17A4 may be substituted for the approved material(s) listed below. The substitution may be made provided:

- (a) The service conditions are acceptable to allow substitution.
- (b) The gasket cutter can furnish cut parts at prices equivalent to those for FMS17A2 material.

FMS17A2 material may not be substituted for FMS17A4 material.

7. APPROVED SOURCES

The following material(s) have been approved:

- (a) Durabla -
Durabla Manufacturing Co.
Wayne, PA (19087)
Paoli 19341

MAJOR REVISION

BY: NRP	CHKD: WWH	APVD: UFR	DATE: 9/1/83
840. OLD STOCK	830. REASON		
1 X USE	1 - SAFETY	5 - STDN	
2 - REBACHINE	2 - MAIL	6 - COST	
3 - SCRAP/NEW	3 X IMPROVE		
4 - SCRAP NOW	4 - ERROR		

MATERIAL UPDATE

MC4432

Form FC3803/Printed in USA

FC 01957

PLAINTIFF'S
EXHIBIT

1008, 1957

ROA_03548

T																			

The sheet is to be of best grade long fibre asbestos suitable for high pressure, high temperature service.

Material is to be an homogeneous construction.

The following commercial materials have been approved.

1. Durabia
2. Johns - Mansville JM78 with JM Parting Agent

SEP 21 1982

MAJOR REVISION

BY CHKD APVD TKB
 1 - USE 1 - SAFETY 5 - STDZ
 2 - REMACHINE 2 - MATL 6 - CUST
 3 - E 3 - IMPROVE 7 - IQ/
 4 - ERROR 4 - ERROR SALES

Completely new, written to new format - removed Johns-Mansville as approved source

FC_01958

High Grade Long Fibre Asbestos Sheet, Gasket Material				SIZE		TYPE	
CQ CWN 8-7-73 SUPERSEDED		 MARSHALLTOWN, IOWA CODE 22501		BY OWN. CHKD. APVD. SCALE		DATE DESIGN DWG. NO. FMS 17A2	
REVISIONS 1 2 3						REV. C- (B)	

Fisher Controls

Material Specification

ASBESTOS GASKET SHEET
WITH NON-STICKING QUALITIES

FISHER

No.	FMS 17A3	E
By	HW	5-20-53
Apvd	LFR	5-9-53
Page	1	of 1
Rev	WHH	2-15-88

©Fisher Controls 1983

1. SCOPE

OBSOLETE

This specification lists the approved source(s) for compressed asbestos sheet material used for general purpose gasketing.

2. MATERIAL REFERENCE NO. - 0403

3. MATERIAL COMPOSITION & PROPERTIES

The sheet is to be of the best grade long fiber asbestos and SBR elastomeric binder. When clamped between flanges it must not stick to the flanges, even though they are primed or painted.

4. APPROVED SOURCE(S)

- (a) Garlock Mechanical Packing Division
Palmyra, N.Y.
Style No. 900/7735
- (b) Nicolet Incorporated
Ambler, Pa.
Style No. 240

OBSOLETE

Superseded by
FMS 17AS or
17F38

FMS2-14/1

FC_01959

Form FC3883/Printed in USA

ROA_03550



Fisher Controls

Material Specification

No. FMS 17A3

FISHERASBESTOS GASKET SHEET
WITH NON-STICKING QUALITIES

By HW 5-20-53

Apvd NFR 9-9-83

Page 1 of 1

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Rev 112P 9-9-83

1. SCOPE

OBSELETE

This specification lists the approved source(s) for compressed asbestos sheet material used for general purpose gasketing.

2. MATERIAL REFERENCE NO. - 0403

3. MATERIAL COMPOSITION & PROPERTIES

The sheet is to be of the best grade long fiber asbestos and SBR elastomeric binder. When clamped between flanges it must not stick to the flanges, even though they are primed or painted.

4. APPROVED SOURCE(S)

(a) Garlock Mechanical Packing Division
Palmyra, N.Y.
Style No. 900/7735

(b) Nicolet Incorporated
Ambler, Pa.
Style No. 240

FEB 22 1988

OBSELETE

Superseded by
FMS 17A5 or
17F38

MAJOR REVISION

EDR/N NO. _____ DATE: _____
BY WHN CHKD DRB APVD NFR
BIB, OLD STOCK B3Q, REASON
1 - USE 1 - SAFETY 8 - STDZ
2 - REWORK 2 - MATL 6 - COST
3 - SCRAP/NEW 3 - IMPROVE 7 - MKTG/
4 - SCRAP NOW 4 - ERROR SALFR

Make obsolete - no longer
use asbestos

FMS2-14/1

FC_01960

Form FC3883/Printed in USA



ROA_03551

THE SHEET IS TO BE OF BEST GRADE LONG FIBRE ASBESTOS. WHEN CLAMPED BETWEEN FLANGES IT MUST NOT STICK TO THE FLANGES, EVEN THOUGH THEY ARE PRIMED OR PAINTED.

THE FOLLOWING MATERIALS HAVE BEEN APPROVED.

1. GARLOCK STYLE NO. 900/7735
2. NICOLLET NO. 240

SEP 13 1983

MAJOR REVISION
 BY CHD DATE 9/9/83
 840, OLD STOCK APD NFR
 1 USE REASON
 2 REWORK REASON
 3 REWORK REASON
 4 REWORK REASON

MONTHLY REVIEW
 PLACE IN NEW FORM
 Completely Retyped.

FC_01961

TITLE ASBESTOS GASKET SHEET WITH NON-STICKING QUALITIES				TYPE	
BY <u>CHD</u> DATE <u>9-20-83</u>				SIZE	
DWN. <u>TRCD</u>				DRAWER NO.	
CHKD. <u>CHD</u>				DWG. NO.	
APPR. <u>CHD</u>				SUPERSEDES DWG. NO.	
REVISIONS				REV.	
SCALE				FMS/TA3	

THE SHEET IS TO BE OF BEST GRADE LONG FIBRE ASBESTOS. WHEN CLAMPED BETWEEN FLANGES IT MUST NOT STICK TO THE FLANGES, EVEN THOUGH THEY ARE PRIMED OR PAINTED.

THE FOLLOWING MATERIALS HAVE BEEN APPROVED.

1. GARLOCK STYLE NO. 7735

900/7735

MAJOR REVISION

BY MPB CHKD Q APVD AK

640. OLD STOCK
1 - USE
2 - REMACHINE
3 - SCRAP/NEW
4 - SCRAP NOW

EXPLAN

10.22-29
1 - SAFETY
2 - MATL
3 - IMPROVE
4 - ERROR

UP-DATE APPROVED MATL

E. DIXSON

FC_01962

TITLE ASBESTOS GASKET SHEET WITH NON-STICKING QUALITIES				TYPE	
BY <u>DWN.</u> DATE <u>5-20-52</u>				DESIGN NO.	
TECH.				DRAWER NO.	
DATE <u>5-20-52</u> BY <u>CHD.</u>				DWG. NO. <u>FMS17A3A</u>	
REVISIONS				SUPERSEDES DWG. NO.	
SCALE				MARSHALLTOWN, IOWA	

Fisher Controls

Material Specification

HEAVY DUTY ELASTOMER-BOUND ASBESTOS
GASKET MATERIAL

FISHER

No.	FMS 17A4	C
By	RGR	2-19-69
Apvd	TKR	9-14-82
Page	1	of 1
Rev	WHH	2-15-88

©Fisher Controls 1982

OBsolete

1. SCOPE

This specification lists the approved source(s) for nitrile elastomer bound asbestos gasketing and describes the composition of the approved source(s), their product name; and all approved substitutes for the approved source(s).

2. MATERIAL COMPOSITION

The material, as covered by this specification, shall be a compressed asbestos type sheet consisting of about 80-85% asbestos fibers with about 15-20% nitrile type elastomeric binder.

3. SURFACE RESISTANCE OF MATERIAL

The material surfaces shall be resistant to sticking to metals such as brass, aluminum, and steel. The material shall be resistant to compression relaxation under heavy loads.

4. GENERAL USAGE OF MATERIAL

The material shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical, and general processing type industries.

5. MATERIAL SUBSTITUTION

The approved source(s) may be substituted for the material source(s) shown on FMS17A2 provided:

- (a) The service conditions are acceptable to allow substitution.
- (b) The gasket cutter can furnish cut parts at prices equivalent to those for FMS17A2 material.

There is no approved substitute for FMS17A4 material.

6. APPROVED SOURCE(S)

The following material(s) have been approved:

- (a) Armstrong Accobest, AN-8012
(Cooper Manufacturing Co.)
Armstrong Industry Products Div.
Lancaster, PA 17604

OBsolete

Superseded by
FMS 17A5
or 17F38

FC_01963

MC4204

Form FC3053/Printed in USA

ROA_03554



Fisher Controls

Material Specification

No. FMS 17A4 (B)

HEAVY DUTY ELASTOMER-BOUND ASBESTOS
GASKET MATERIAL**FISHER**

By RGR 2-19-69

Apvd TKB 9-14-82

Page 1 of 1

©Fisher Controls 1982

Rev. 2-14-82

OBSOLETE1. SCOPE

This specification lists the approved source(s) for nitrile elastomer bound asbestos gasketing and describes the composition of the approved source(s), their product name; and all approved substitutes for the approved source(s).

2. MATERIAL COMPOSITION

The material, as covered by this specification, shall be a compressed asbestos type sheet consisting of about 80-85% asbestos fibers with about 15-20% nitrile type elastomeric binder.

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The material shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical, and general processing type industries.

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The approved source(s) may be substituted for the material source(s) shown on FMS17A2 provided:

- (a) The service conditions are acceptable to allow substitution.
- (b) The gasket cutter can furnish cut parts at prices equivalent to those for FMS17A2 material.

There is no approved substitute for FMS17A4 material.

6. APPROVED SOURCE(S)

The following material(s) have been approved:

- (a) Armstrong Accobest AN-8012
(Cooper Manufacturing Co.)
Armstrong Industry Products Div.
Lancaster, PA 17604

OBSOLETE
superseded by
FMS 17A5 or
17F38

MAJOR REVISION

FOR/NO. DATE
BY WHH CHKD DRB APVD NFR
840, OLD STOCK BSO, REASON
1. USE 1. SAFETY 5. STDN
2. NEWORK 2. MATL 6. COST
3. SCRAP/NEW 3. IMPROVE 7. MKTG/
4. SCRAP/NEW 4. ERROR SALE

Make obsolete - no longer
use asbestos

FC 01964

MC4204

Form FC3889/Printed in USA

FEB 22 1988

ROA_03555



FISHER® GOVERNOR CO. MARSHALLTOWN, IOWA USA	MATERIAL SPECIFICATION		NO. FMS 17A4 B 
	HEAVY DUTY <u>RUBBER</u> ASBESTOS GASKET MATERIAL		ISSUED RSK 2-19-69
	<i>Elastomer-Bound</i>		REV.
			PAGE 1 OF 1

Heavy Duty Rubber-Asbestos

Nitrile - butadiene rubber binder

The following materials have been approved.

- 1) Armstrong Accobest AN-8012
Cooper Manufacturing Company

SEP 21 1982

MAJOR REVISION

BY CHKD NRP APVD TKB
 640, OLD STOCK 830, REASON
 1 - USE 1 - SAFETY 5 - STDZ
 2 - REMACHINE 2 - MATL 6 - 1-51
 3 - DESIGN 3 - IMPROVE 7 - 3/
 4 - 1-51 5 - 5

*Completely rewritten to agree
with new format.*

FC_01965

FORMED PACKING TO BE MADE OF METAL PARTICLES, OIL-PROOF
 BINDER, LONG FIBRE ASBESTOS AND MUST BE SUITABLE FOR USE
 ON OILS AND PETROLEUM DISTILLATES AT TEMPERATURES UP TO
 550°F.

THE FOLLOWING MATERIALS HAVE BEEN APPROVED:

1. JOHN CRANE SUPER-SEAL NO. 3.

FC_01966

				TITLE FORM PACKING-LONG FIBRE ASBESTOS, OIL-PROOF BOUND				TYPE	
				BY	DATE	DESIGN NO.		SIZE	
				DWN.	304 10-6-43				
DATE	BY	CHKD.	TRCD.			DRAWER NO.			
REVISIONS				CHKD.		FILE NO.		DWG. NO.	
SUPERSEDES DWG. NO. FMS3A1				APPR.				FMS17D1	
				SCALE					

PACKING SHALL BE MADE FROM LONG FIBRE ASBESTOS YARN BY THE BRAID OVER BRAID METHOD. PACKING IS TO BE LUBRICATED AND GRAPHITED. FINISHED PRODUCT SHALL BE RESISTANT TO STEAM, WEAK ACIDS, GAS, LYE AND CAUSTICS.

PACKING SHALL BE CUT FROM ROPE AND FORMED INTO RINGS OF THE OD, ID, AND LENGTH SPECIFIED.

THE FOLLOWING MATERIALS HAVE BEEN APPROVED:

1. GARLOCK NO. 235 (RING FORM-CUT TO SIZE BY MFG'R).

FC_01967

			TITLE		RING PACKING FOR STEAM, WEAK ACID, GAS, LYE OR CAUSTIC SODA.		TYPE	
			BY	DATE	DESIGN NO.		SIZE	
			DWN.	OR	10-6-43	DRAWER NO.		
DATE			BY	CHKD.	TRCD.	DWG. NO.		
REVISIONS			CHKD.			FILE NO.		
SUPERVISOR			APPR.			DWG. NO.		
DWG. NO. FMS 3AZ			SCALE			FMS 17DZ		
					FISHER GOVERNOR CO. MARSHALLTOWN, IOWA			

ROA_03558

INACTIVE

Packing shall be made from high grade Canadian white asbestos. The string shall be formed by twisting together lubricated single strands of asbestos.

Diameter of the packing shall be specified by the Fisher Governor Company.

The packing shall be suitable for use with air, hot water and steam up to 800°F.

The following materials have been approved:

1. Palmetto String Packing - Greene, Tweed & Company

INACTIVE BY *[Signature]*

FC_01969

String Packing For Air, Hot Water & Steam				SIZE	TYPE
FISHER® GOVERNOR CO. MARSHALLTOWN, IOWA	DWN.	BY	DATE	FILE	SUPERSEDES
	CHKD.	BRJ	10-6-43	SCALE	DESIGN
			6-22-59		
				DWG. NO.	REV.
				EMS17D4	B

ROA_03559

INACTIVE

Packing shall be made from high grade Canadian white asbestos. The string shall be formed by twisting together lubricated single strands of asbestos.

Diameter of the packing shall be specified by the Fisher Governor Company.

The packing shall be suitable for use with air, hot water and steam up to 800°F.

The following materials have been approved:

1. Palmetto String Packing - Greene, Tweed & Company

32-61
DATE
MAJOR REVISION
BY *CHKOZITZOW* APVD *[Signature]*
840. OLD STOCK 830. REASON
1 - X USE 1 - SAFETY 5 - STDZ
2 - REMACHINE 2 - MATL 6 - COST
3 - SCRAP/NEW 3 - IMPROVE
4 - SCRAP NOW 4 - ERROR
No longer Available

INACTIVE BY *[Signature]*

FC_01970

String Packing For Air, Hot Water & Steam				SIZE	TYPE
FISHER® GOVERNOR CO. MARSHALL TOWN IOWA	BY	DATE	FILE	SUPERSEDES	DWG. NO.
	DWN BRJ	10-6-43	SCALE	DESIGN	REV.
					FMS17D4 8-②

Fisher Controls 	Material Specification		No.	FMS 17D5	D
	GRAPHITED ASBESTOS PACKING		By	GFB	9-7-49
			Apvd	TKB	1-25-87
			Page	1 of	1
©Fisher Controls 1982, 1987			Rev	WHH	4-15-87

1. SCOPE

OBSOLETE

This specification covers a graphited asbestos compound for use as valve stem packing.

2. MATERIAL REFERENCE NO. 0105

3. COMPOSITION

Molded or die formed ring packing made of asbestos fiber, graphite and treated with a surface lubricant in braided jacket over core construction.

4. APPROVED SOURCE

Argo Packing Co.
P.O. Box 66
Oakmont, PA. 15139
Style No. 500

OBSOLETE REPERFECTED
BY QW/C. NA
FMS 17D28

FMS3-29/1

FC_01971

ROA_03562



Fisher Controls

Material Specification

No. FMS 17F30 ⑤

FISHERSPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL
(CERTIFIED 200 PPM OR LESS)

By DSG 12-11-72

Apvd BR 11-13-79

Page 1 of 2

©Fisher Controls 1984 1985 1986

Rev NRP 7-15-85

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 200 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel materials.

2. MATERIAL REFERENCE NUMBERS

MRN's are listed in parenthesis under Approved Materials (Section 6, below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed, and packaged in a manner which will justify certification.

Each order must be certified that the requirements have been met.

4. PACKAGING

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. APPROVED MATERIALS

FC_02331

The following gasket materials can be certified to contain 200 PPM or less leachable chlorides:

(a) Spiral Wound Gaskets

316L and asbestos, low chloride (9956)

321 and asbestos, low chloride (9971)

304 and asbestos, low chloride (9983)

316L and composition, FMS 17N2 (992T)

321 and composition, FMS 17N2 (993T)

304 and composition, FMS 17N2 (993U)

delete

JUL 1 1986

EXHIBIT

16

Duimstra 3-1D-06

Source(s): Flexitallic Gasket Company or as specified on FMS 17N2

MAJOR REVISION

FMS1-15/1

DELETE ASBESTOS
GASKET MATLS

ECR/N NO. DATE

BY NRP CHND W/H AFVD NRP

840, OLD STOCK 123, 123, 123

1 X USE 1 X USE 5 STON

2 REWORK 2 REWORK 6 CRST

3 REWORK 3 REWORK 7 CRST

Form FC3911/Printed in U.S.A.

ROA_03563

PLAINTIFF'S
EXHIBIT

1068.2331

Fisher Controls

Material Specification

No. FMS 17F30

(H)

FISHERSPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL

(CERTIFIED 200 PPM OR LESS)

By DSG

12-11-72

Apvd BR

11-13-79

Page 1 of

©Fisher Controls 1984

Rev NRP

Z-Z-84

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 200 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel materials.

2. MATERIAL REFERENCE NUMBERS

MRN's are listed in parenthesis under Approved Materials (Section 6, below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed, and packaged in a manner which will justify certification.

Each order must be certified that the requirements have been met.

4. PACKAGING

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. MATERIALS APPROVED MATERIALS

The following gasket materials can be certified to contain 200 PPM or less leachable chlorides:

- (a) Spiral Wound Gaskets 316L and asbestos, low chloride (9956)
321 and asbestos, low chloride (9971)
304 and asbestos, low chloride (9983)

Sources: Flexitallic Gasket Company or as specified on FMS 17N2

FMS1-15/1

316L and composition, FMS 17N2 (992T)
321 " " FMS 17N2 (993T)
304 " " FMS 17N2 (993U)

FC_02332

PLAINTIFF'S
EXHIBIT

008.2332

ROA_03565

Fisher Controls FISHER® ©Fisher Controls 1982, 1987	Material Specification		No.	FMS 1708	H
	TFE ASBESTOS - PACKING		By	MMP	8-12-54
			Apvd	TKB	2-18-82
			Page	1	of 1
			Rev	WHH	4-15-87

OBSOLETE

1. SCOPE

This specification covers square braided asbestos valve stem packing impregnated with TFE (polytetrafluoroethylene).

2. MATERIAL REFERENCE NO. 0104

3. COMPOSITION

Square braided asbestos impregnated with TFE and furnished in ring form with bevel joint.

3.1 Packing should be reasonably clean and free from graphite. Not for oxygen service.

3.2 Note: For oxygen service specify FMS 17D11

4. APPROVED SOURCE

(a) Argo Packing Co.
P.O. Box 66
Oakmont, PA. 15139
Style No. 715

(b) Martin Merkel Packings and Seals, Inc.
5375 Naiman Parkway, Suite B
Cleveland, OH. 44139
Style No. 5741

OBSOLETE SUPERSEDED
BY 17D26
FMS 17D26

FMS3-27/1

FC_01972

ROA_03566



Fisher Controls

Material Specification

OBSOLETE

No. FMS 1709

C-B

FISHER

HIGH TEMPERATURE ALUMINUM PACKING

By CMS 4-11-85

App'd NFR 4-11-86

Page 1 of 1

©Fisher Controls 1986

Rev NRP 4-11-86

1. SCOPE

This specification covers valve stem packing compounds for use where packing temperatures are in excess of 450°F.

2. MATERIAL REFERENCE NOS.

0106 for Metallic Rings
011R for Plastic Rings

3. COMPOSITION

3.1 Metallic Rings: Lubricated aluminum foil twisted over a resilient fiberglass core.

3.2 Plastic Rings: A semi-metallic plastic packing of pure long synthetic fibers and aluminum shreds lubricated with graphite in a resilient binder.

3.3 No asbestos in any form shall be contained in either packing.

4. TEMPERATURE RANGE

+450°F to +900°F

5. PACKING CONFIGURATIONS

5.1 Metallic Rings: Use one at the bottom of the box and one at the top. If lantern ring is specified, use one at each side of lantern ring.

5.2 Plastic Rings: Use to fill space between metallic rings to give proper packing depth.

6. APPROVED SOURCE(S)

- (a) Duralmetallic Corp.
2104 Factory St.
Kalamazoo, MI. 49001
Metallic Rings: Style D-110
Plastic Rings: Style D-222

MAJOR REVISION

ECR/N NO. DATE
BY W/H CHKD JLG ARVD: NFR
040, OLD STOCK 850, REASON
1. X USE 1. SAFETY 5. STDN
2. REWORK 2. X PCT. 6. COST
3. SCRAP/NEW 3. IMPROVE 7. MKTU/
4. SCRAP NOW 4. STAMP SALES

MATERIAL NO LONGER AVAILABLE

OBSOLETE ; see none

DEC 9 1986

FMS4-8/1

FC_01973

ROA_03567



HIGH TEMPERATURE PACKING

Used where packing temperatures are in excess of 450° F.
Recommended for service to 900° F.

Packing shall consist of two types of rings.

Metallic Rings: Use one at the bottom of the box and one at the top. If lantern gland is furnished use one on each side of the lantern gland. Metallic rings shall consist of a high grade asbestos core about which treated, crinkled aluminum alloy foil sheets are twisted.

Plastic Rings: Use to fill space between metallic rings to give proper packing depth. Plastic rings shall consist of pure, long asbestos fibres and aluminum shreds lubricated.

The following materials have been approved:

Metallic Rings

Durametallic Style D-110 or D-10 (Alternate)

Plastic Rings

Durametallic Style D-222 or D-2 (Bulk alternate)

REVISION 4.5.85
DATE
BY NRP WAM AND NER
1 X
2 X
3 X
4 X
REFORMAT & ELIMINATE
ASBESTOS

FC_01974

			TITLE High Temperature Packing			TYPE		
			BY DATE			DESIGN NO.		
			DWN. Cmf 4-11-65			DRAWER NO.		
			TRCD.			DWG. NO.		
			CHKD. WMP 4-11-65			FMS 17D9		
			APPR.			NO.		
REVISIONS			SCALE					

Fisher Controls

Material Specification

No. FMS 17F30

FISHERSPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL
(CERTIFIED 200 PPM OR LESS)

By DSG 12-11-72

Apvd BR 11-13-79

Page 1 of 2

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Rev NRP 7-15-85

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 200 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel materials.

2. MATERIAL REFERENCE NUMBERS.

MRN's are listed in parenthesis under Approved Materials (Section 6, below).

3. CERTIFICATION.

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed, and packaged in a manner which will justify certification.

Each order must be certified that the requirements have been met.

4. PACKAGING

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. APPROVED MATERIALS

FC_02331

The following gasket materials can be certified to contain 200 PPM or less leachable chlorides:

(a) Spiral Wound Gaskets

316L and asbestos, low chloride (9956)
321 and asbestos, low chloride (9971)
304 and asbestos, low chloride (9983)
316L and composition, FMS 17N2 (992T)
321 and composition, FMS 17N2 (993T)
304 and composition, FMS 17N2 (993U)

delete

JUL 1 1986

EXHIBIT

16

DWMstra 3-10-86

Source(s): Flexitallic Gasket Company or as specified in FMS 17N2

FMS1-15/1

DELETE ASBESTOS
GASKET MATLS

ECR/N NO. DATE
BY NRP CHKD W/H APVD NRP
640. OLD STOCK
1 X USE 1 X NEW 5 X STOCK
2 X REWORK 2 X BAIL 6 X COST
3 X IMPROVE 7 X BAIL

Form FC3911/Printed in U.S.A.

ROA_03569

PLAINTIFF'S
EXHIBIT

1068.2331

Fisher Controls

Material Specification

No. FMS 17F30

(4)

FISHERSPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL

(CERTIFIED 200 PPM OR LESS)

By DSG 12-11-72

Apvd BR 11-13-79

Page 1 of

©Fisher Controls 1984

Rev NRP 2-21-84

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 200 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel materials.

2. MATERIAL REFERENCE NUMBERS

MRN's are listed in parenthesis under Approved Materials (Section 6, below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed, and packaged in a manner which will justify certification.

Each order must be certified that the requirements have been met.

4. PACKAGING

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The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

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- (a) Spiral Wound Gaskets 316L and asbestos, low chloride (9956)
321 and asbestos, low chloride (9971)
304 and asbestos, low chloride (9983)

Sources: Flexitallic Gasket Company or as specified on FMS 17N2

316L and composition, FMS 17N2 (992T)
321 " " FMS 17N2 (993T)
304 " " FMS 17N2 (993U)

FMS1-15/1

FC_02332

ROA_03571

Fisher Controls

Material Specification

No.	FMS 17A4	(B)
By	RGK	2-19-69
Apvd	TKB	9-14-82
Page	1	of 1
Rev	22	9-14-82

FISHERHEAVY DUTY ELASTOMER-BOUND ASBESTOS
GASKET MATERIAL

©Fisher Controls 1982

OBsolete1. SCOPE

This specification lists the approved source(s) for nitrile elastomer bound asbestos gasketing and describes the composition of the approved source(s), their product name; and all approved substitutes for the approved source(s).

2. MATERIAL COMPOSITION

The material, as covered by this specification, shall be a compressed asbestos type sheet consisting of about 80-85% asbestos fibers with about 15-20% nitrile type elastomeric binder.

3. SURFACE RESISTANCE OF MATERIAL

The material surfaces shall be resistant to sticking to metals such as brass, aluminum, and steel. The material shall be resistant to compression relaxation under heavy loads.

4. GENERAL USAGE OF MATERIAL

The material shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical, and general processing type industries.

5. MATERIAL SUBSTITUTION

The approved source(s) may be substituted for the material source(s) shown on FMS17A2 provided:

- (a) The service conditions are acceptable to allow substitution.
- (b) The gasket cutter can furnish cut parts at prices equivalent to those for FMS17A2 material.

There is no approved substitute for FMS17A4 material.

6. APPROVED SOURCE(S)

The following material(s) have been approved:

- (a) Armstrong Accobest AN-8012
(Cooper Manufacturing Co.)
Armstrong Industry Products Div.
Lancaster, PA 17604

ECR/NO.		DATE	
BY WHH	CHKD DRB	APVD HFR	
848, OLD STOCK	1. USE	2. SAFETY	3. STDZ
1. USE	2. MATE	3. COST	4. BKTG/SALES
2. REMOVED	3. IMPROVE	4. ERROR	
3. SCRAP/NEW	4. SCRAP NOW		

Make obsolete - no longer
use asbestos

OBsolete
superseded by
FMS 17A5 or
17F38

MAJOR REVISION

MC4204

Form FC3883/Printed in USA

FEB 22 1988

FC 01964

ROA_03572



FISHER® GOVERNOR CO. MARSHALLTOWN, IOWA USA	MATERIAL SPECIFICATION		NO. FMS 17A48- A
	HEAVY DUTY <u>RUBBER</u> ASBESTOS GASKET MATERIAL <i>Elastomer-Bond</i>		ISSUED ROK 2-19-69
			REV.
			PAGE 1 OF 1

Heavy Duty Rubber-Asbestos

Nitrile - butadiene rubber binder

The following materials have been approved.

1) Armstrong Accobest AN-8012
Cooper Manufacturing Company

SEP 21 1982
 DATE

MAJOR REVISION
 BY CHKD NRP APVD TKB
 849, OLD STOCK 830, REASON
 1 - USE 1 - SAFETY 5 - STDZ
 2 - REMACHINE 2 - MATL 6 - ST
 3 - SCREW 3 - IMPROVE 7 - ST
 4 - 100% WEL 4 - 100% WEL 5 -

*Completely rewritten to agree
 with new format.*

FC_01965

FORMED PACKING TO BE MADE OF METAL PARTICLES, OIL-PROOF
BINDER, LONG FIBRE ASBESTOS AND MUST BE SUITABLE FOR USE
ON OILS AND PETROLEUM DISTILLATES AT TEMPERATURES UP TO
550°F.

THE FOLLOWING MATERIALS HAVE BEEN APPROVED:

1. JOHN CRANE SUPER-SEAL NO. 3.

FC_01966

				TITLE FORM PACKING-LONG FIBRE ASBESTOS, OIL-PROOF BOUND.				TYPE			
				BY	DATE			DESIGN NO.	SIZE		
				DWN.	GR	10-6-43					
DATE	BY	CHKD.	TRCD.	FISHER GOVERNOR CO. MARSHALLTOWN, IOWA				DRAWER NO.	DWG. NO.		
REVISIONS								CHKD.			
SUPERSEDES								APPR.			
DWG. NO. FMS3A1								SCALE			FILE NO.

ROA_03574

PACKING SHALL BE MADE FROM LONG FIBRE ASBESTOS YARN BY THE BRAID OVER BRAID METHOD. PACKING IS TO BE LUBRICATED AND GRAPHITED. FINISHED PRODUCT SHALL BE RESISTANT TO STEAM, WEAK ACIDS, GAS, LYE AND CAUSTICS.

PACKING SHALL BE CUT FROM ROPE AND FORMED INTO RINGS OF THE OD, ID, AND LENGTH SPECIFIED.

THE FOLLOWING MATERIALS HAVE BEEN APPROVED:

1. GARLOCK NO. 235 (RING FORM-CUT TO SIZE BY MFG'R).

FC_01967

			TITLE		RING PACKING FOR STEAM, WEAK ACID, GAS, LYE OR CAUSTIC SODA		TYPE	
			BY	DATE	DESIGN NO.		SIZE	
			DWN.	389	10-6-43	DRAWER NO.		
DATE	BY	CHKD	TRCD			DWG. NO.		
REVISIONS			CHKD			FILE NO.		
SUPERSEDES			APPR			DWG. NO.		
DWS. NO. FMS3AZ			SCALE			DWG. NO.		FMS17DZ
			FISHER GOVERNOR CO. MARSHALLTOWN, IOWA					

ROA_03575

PACKING SHALL BE MADE FROM LONG FIBRE ASBESTOS YARN BY THE BRAID OVER BRAID METHOD. PACKING IS TO BE LUBRICATED AND GRAPHITED. FINISHED PRODUCT SHALL BE RESISTANT TO STEAM, WEAK ACIDS, GAS, LYE AND CAUSTICS.

PACKING SHALL BE FURNISHED IN ROPE FORM.

THE FOLLOWING MATERIALS HAVE BEEN APPROVED:

1. GARLOCK NO. 233 (COIL FORM).

INACTIVE BY *[Signature]*

FC_01968

TITLE BRAIDED ROPE PACKING - FOR STEAM, WEAK ACID, GAS, LYE OR CAUSTIC SODA.				TYPE															
<table border="1"> <tr> <td>DATE</td> <td>BY</td> <td>CHKD.</td> <td>TRCD.</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> </table>				DATE	BY	CHKD.	TRCD.					<table border="1"> <tr> <td>DESIGN NO.</td> <td></td> </tr> <tr> <td>DRAWER NO.</td> <td></td> </tr> <tr> <td>FILE NO.</td> <td></td> </tr> </table>		DESIGN NO.		DRAWER NO.		FILE NO.	
DATE	BY	CHKD.	TRCD.																
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<table border="1"> <tr> <td>DATE</td> <td>BY</td> <td>CHKD.</td> <td>TRCD.</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> </table>				DATE	BY	CHKD.	TRCD.					<table border="1"> <tr> <td>SIZE</td> <td></td> </tr> <tr> <td>DWG. NO.</td> <td>FMS17D3</td> </tr> </table>		SIZE		DWG. NO.	FMS17D3		
DATE	BY	CHKD.	TRCD.																
SIZE																			
DWG. NO.	FMS17D3																		
<table border="1"> <tr> <td>REVISIONS</td> <td></td> </tr> <tr> <td>SUPERSEDES</td> <td></td> </tr> <tr> <td>DWG. NO.</td> <td>FMS3B1</td> </tr> </table>				REVISIONS		SUPERSEDES		DWG. NO.	FMS3B1	<table border="1"> <tr> <td>APPR.</td> <td></td> </tr> <tr> <td>SCALE</td> <td></td> </tr> </table>		APPR.		SCALE					
REVISIONS																			
SUPERSEDES																			
DWG. NO.	FMS3B1																		
APPR.																			
SCALE																			
FISHER GOVERNOR CO. MARSHALLTOWN, IOWA																			

ALL DIMENSIONS ARE IN INCHES

DO NOT SCALE THIS PRINT. WORK TO FIGURES

ROA_03576

INACTIVE

Packing shall be made from high grade Canadian white asbestos. The string shall be formed by twisting together lubricated single strands of asbestos.

Diameter of the packing shall be specified by the Fisher Governor Company.

The packing shall be suitable for use with air, hot water and steam up to 800°F.

The following materials have been approved:

1. Palmetto String Packing - Greene, Tweed & Company

INACTIVE BY *[Signature]*

FC_01969

String Packing For Air, Hot Water & Steam					SIZE	TYPE	
FISHER® GOVERNOR CO. MARSHALLTOWN, IOWA	DWN.	BY	DATE	FILE	SUPERSEDES	DWG. NO.	REV.
	CHKD.	BRJ	10-6-43	SCALE	DESIGN	FMS17D4	B
		10m	6-22-59				

ROA_03577

INACTIVE

Packing shall be made from high grade Canadian white asbestos. The string shall be formed by twisting together lubricated single strands of asbestos.

Diameter of the packing shall be specified by the Fisher Governor Company.

The packing shall be suitable for use with air, hot water and steam up to 800°F.

The following materials have been approved:

1. Palmetto String Packing - Greene, Tweed & Company

3-2-61
MAJOR REVISION
 BY CHKDZITZON APVD [Signature] DATE 3-2-61
 840. OLD STOCK 830. REASON
 1 ☒ USE 1 - SAFETY 5 - SIZE
 2 ☐ REMACHINE 2 - MATL 6 - COST
 3 ☐ SCRAP/NEW 3 ☒ IMPROVE
 4 ☐ SCRAP NOW 4 - ERROR

No longer Available

INACTIVE BY [Signature]

FC_01970

String Packing For Air, Hot Water & Steam				SIZE	TYPE
FISHER® GOVERNOR CO. MARSHAL TOWN, IOWA		BY DWN. BRJ	DATE 10-6-43	FILE SCALE	SUPERSEDES DESIGN
				DWG. NO. FMS17D4	REV. 8-(2)

FISHER CONTROLS COMPANY

MARSHALLTOWN, IOWA 50355

AUTOMATIC CONTROL EQUIPMENT
SINCE 1950

July 11, 1980

University Hygienic Laboratory
Medical Laboratory Building
Iowa City, Iowa 52242

ATTN: Mr. I. A. Schwabbauer

Dear Ivan:

Enclosed are two gaskets for your use as "bulk" samples.

As I stated in our recent telephone conversation, I mailed four asbestos samples to you for analysis. Sample #3 was taken while flat black gaskets were being packed, and #4 while spiral wound (blue) gaskets were being packed. Both gasket types were being handled when samples #1 and #2 were taken.

The asbestos types used on these gaskets are probably chrysotile and crocidolite. More specific information on the asbestos types used is not readily available.

I also neglected to include an unused filter cassette with the samples I sent to you. A blank filter cassette has also been enclosed.

Thank you for your cooperation.

Sincerely,

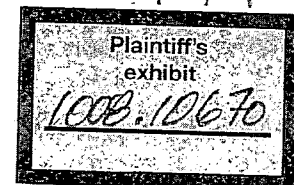
FISHER CONTROLS COMPANY

Paul S. Adams

Paul Adams
Facilities & Equipment Engineering

PA/gf

Enclosures



IF IT FLOWS THROUGH PIPE... CHANCES ARE IT'S CONTROLLED BY...  TELEPHONE (515) 264-2011... TWX 910-520-1425... TELEX 478456

calafish_10670

ROA_03579

FISHER CONTROLS COMPANY

MARSHALLTOWN, IOWA 50558

AUTOMATIC CONTROL EQUIPMENT
SINCE 1949

July 9, 1980

University Hygienic Laboratory
Medical Laboratory Building
Iowa City, IA 52242

Attn: Mr. I.A. Schwabbauer

Dear Ivan:

Enclosed are four samples requiring analysis for asbestos.
Accompanying these samples are copies of the Sampling Analysis
Data Sheets for your reference.

The air volume drawn through each filter was as follows:

<u>Sample No.</u>	<u>Air Volume (liters)</u>
1	350
2	180
3	67
4	46

Please refer to Purchase Order No. L237473.

If you have any questions, please feel free to contact either myself
or Chien Lin.

Sincerely,

FISHER CONTROLS COMPANY

Paul S. Adams

Paul Adams
Equipment & Facilities Eng.

Enc.
PA/mz

cc: Chien Lin

Plaintiff's
exhibit

100B-10665

IF IT FLOWS THROUGH PIPE... CHANCES ARE IT'S CONTROLLED BY... **FISHER** TELEPHONE (515) 754-2011... FAX 515-329-1472... TELEX 425456

calafish_10665

ROA_03580

FISHER CONTROLS COMPANY

Sampling Analysis Data Sheet

1. Sample number: #1
2. Date taken: 6-16-80
3. Date submitted to lab: 7-9-80
4. By whom taken: PAUL ADAMS
5. Where taken: GAS REGULATOR AREA
6. Sampling for: ASBESTOS
7. Possible interference: CIGAR SMOKER
8. Analysis required:
9. Operator: [REDACTED]
10. Sampling pump number: 4515
11. Flow rate: 1500 cc/min.
12. Time in: 9:00 AM.
13. Time out: 1:00 PM.
14. Air volume: 360 LITERS
15. Remarks: A MAJORITY OF THE TIME WAS SPENT IN
THE AREA WHERE THE GRANTS
WERE NOT HAULED.

calafish_10666

FISHER CONTROLS COMPANY

Sampling Analysis Data Sheet

1. Sample number: #2
2. Date taken: 6-18-80
3. Date submitted to lab: 7-9-80
4. By whom taken: PAUL ADAMS
5. Where taken: E-BODY LINE, CENTER STREET PLANT
6. Sampling for: ASBESTOS
7. Possible interference: CIGARETTE SMOKE, ALIPHATIC HYDROCARBON
PRESENT IN THE AREA
8. Analysis required:
9. Operator: [REDACTED]
10. Sampling pump number: 4515
11. Flow rate: 1500 cc/min.
12. Time in: 9:37 am.
13. Time out: 11:37 pm.
14. Air volume: 180 LITERS
15. Remarks: MANY OF THE VALVES THE OPERATOR
ASSEMBLED DID NOT CONTAIN ASBESTOS GASKETS.
THE FOREMAN STATED THAT THE OPERATOR
HANDLED AS MUCH AS ANYONE ON THE LINE.

calafish 10667

FISHER CONTROLS COMPANY

Sampling Analysis Data Sheet

1. Sample number: #3
2. Date taken: 7-7-80
3. Date submitted to lab: 7-9-80
4. By whom taken: PAUL ADAMS
5. Where taken: PACKAGING DEPT., CENTER STREET
6. Sampling for: ASBESTOS
7. Possible interference:
8. Analysis required:
9. Operator: [REDACTED]
10. Sampling pump number: 4514
11. Flow rate: 1500 cc/MIN.
12. Time in: 3:05
13. Time out: 3:50
14. Air volume: 67 LITERS
15. Remarks: ASBESTOS GASKETS WERE BEING WEIGH COUNTED
"DOES GASKETS WERE THE FLAT
ASBESTOS - SHEET TYPE.

calafish_10668

FISHER CONTROLS COMPANY

Sampling Analysis Data Sheet

1. Sample number: #4
2. Date taken: 7-8-80
3. Date submitted to lab: 7-9-80
4. By whom taken: PAUL ADAMS
5. Where taken: PACKAGING DEPT., CENTER STREET.
6. Sampling for: ASBESTOS
7. Possible interference:
8. Analysis required:
9. Operator: [REDACTED]
10. Sampling pump number: 4515
11. Flow rate: 1500 cc/min.
12. Time in: 1:58
13. Time out: 2:29
14. Air volume: 46 LITERS
15. Remarks: RUN TIME OF TEST INCLUDED A 10 MINUTE
DUE TO WHICH THE OPERATOR STAYED AT HIS
WORK STATION. ASBESTOS GASKETS SPRING-WOUND
TIRE, WERE BEING PACKED INTO BLUE BOXES.

calafish_10669

The University of Iowa

Iowa City, Iowa 52242

University Hygiene Laboratory

(319) 352-6200



25 July 1980

Mr. Paul Adams
Facilities & Equipment Engineering
Fisher Controls Company
Marshalltown, IA 50158

Dear Paul:

We have analyzed the cassettes submitted for asbestos fiber counts.
The results of the analysis are as follows:

<u>Sample #</u>	<u>Air Volume</u>	<u>Fibers</u>	<u>Fields</u>	<u>Fibers/cc</u>
1	360 l	49	100	0.48
2	180 l	0	100	0.00
3	67 l	1	100	0.05
4	46 l	0	100	0.00
Blank	0 l	0	100	0.00

If you have any questions on the analysis, please contact me.

I have instructed our business office to submit a bill for analytical services in the amount of \$125.

Sincerely,

A handwritten signature in cursive script, likely reading "I. A. Schwabbauer".

I. A. Schwabbauer
Chief, Occupational Health/Air Quality

nm

cc: J. Mefford

calafish_10671

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CC1155 PCC1330

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

FILE

814.00

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL
COPIES OF THE INVOICE AND ON ALL PACKAGES.

C32108-K2 **EDI**

ORDER DATE

9-03-92

FISHER CONTROLS COMPANY
% ROBERT E. MASON & CO
P O BOX 33424
CHARLOTTE NC 28233S DUKE POWER CO.
H OGDONEE NUCLEAR STATION C32108-K2
I C/O H.A. HEDDEN
P HIGHWAY 183
T
OSENECA, SC 29678
UPS BROWN

HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER:
NC26 SC1002-19
EIN NUMBER: 56-020550MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*
BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR
SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF
THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE
LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			***** * * EDI ORDER * * * THIS ORDER HAS BEEN TRANSMITTED * * ELECTRONICALLY TO THE VENDOR. * * PLEASE SEND ORIGINAL COPY TO THE * * EDI COORDINATOR FOR VERIFICATION. * *****		
1	1	EA	ASSEMBLY, , RELAY, MFR SPECIFIC INFO: HORIZONTAL MFR: FISHER CONTROLS CO. PART #: AJ6203000A2	115502121	126.00 EA
2	2	EA	GASKET, , TYPE: BELLOWS FRAME MFR: FISHER CONTROLS CO. PART #: 1D396803012	115502602	101.00 EA
3	1	EA		115502586	

(CONT. ON PAGE 2)

SHIPPING TERMS 0001

CASH NET 30 DAYS

*NOTICE TO SELLER

ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents,
show ID numbers on boxes and invoices if shown on this order.
SEE COPIES OF INVOICE, WITH FREIGHT BILL
OR OTHER SHIPPING DOCUMENTS ATTACHED,
ARE TO BE MAILED TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
PO BOX 1002
CHARLOTTE NC 28201-1002ADDRESS
REPLY TO:DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

J.L. ROSEMAN

(803) 885-3551

(803) 885-3558

REV. 06/91

FILE COPY

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7 101.00EU76 STK JLR/DBJ/
6 2.00

C1155 PCC1330

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

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C32108-K2 **EDI**

ORDER DATE

PAGE 2

FISHER CONTROLS COMPANY
Z ROBERT E MASON & CO
P.O. BOX 33424
CHARLOTTE NC 28233S
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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER:
NC26 SC1002-19
EIN NUMBER: 58-020550MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*
BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR
SERVICES DESCRIBED BELOW UNDER THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF
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ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
4	1	EA	GASKET, MFR: FISHER CONTROLS CO. PART #: 1N4991-99202	115502605	
5	1	EA	ADAPTER, , CONNECTION: MALE MFR: FISHER CONTROLS CO. PART #: 1H784201012	115502621	
6	5	EA	ADAPTER, MFR: FISHER CONTROLS CO. PART #: 1H784401012	115502555	
7	4	EA	GASKET, , TYPE: SWITCH PLATE MFR: FISHER CONTROLS CO. PART #: 1N8741	115500395	

(CONT. ON PAGE 3)

SHIPPING
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TERMS

*NOTICE TO SELLER

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DUKE POWER COMPANY
PURCHASING DEPARTMENT
PO BOX 1002
CHARLOTTE NC 28201-1002ADDRESS
REPLY TO:DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

FILE COPY

REV. 06/01

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DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

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C32108-K2 **EDI**

ORDER DATE

PAGE 3

FISHER CONTROLS COMPANY
Z ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE NC 28233S
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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER:
NC26 SC1002-19
EIN NUMBER: 86-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*

BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
8	2	EA	GASKET, , TYPE: RELAY APPLICATION: FOR FISHER 3570 POSITIONER FURNISHED TO DP CO SPEC CNS-1205.06-3 MFR: FISHER CONTROLS CO. PART #: 1H855903012	115502617	
9	9	EA	SPRING, MFR: FISHER CONTROLS CO. PART #: 1H8917000A2	115000001	
10	2	EA	PIN, , TYPE: TRAVEL MFR: FISHER CONTROLS CO. PART #: 1U909646332	115502785	
			GASKET, , SIZE: 1/4" THK, MATERIAL: ASBESTOS- APPLICATION: FOR FISHER CONTROL PRESSURE RELIEF VALVE MFR: FISHER CONTROLS CO. (CONT. ON PAGE 4)		

SHIPPING
TERMSCASH
TERMS

*NOTICE TO SELLER

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Show ID numbers on boxes and invoices if shown on this order.
THREE COPIES OF INVOICE, WITH FREIGHT BILL
OR OTHER SHIPPING DOCUMENTS ATTACHED,
ARE TO BE MAILED TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
PO BOX 1002
CHARLOTTE NC 28201-1002ADDRESS
REPLY TO:DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

FILE COPY

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CC2444 PCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

FILE

2541:97

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL
COPIES OF THE INVOICE AND ON ALL PACKAGES.

E14357-K2

EDI

ORDER DATE

3-24-93

FISHER CONTROLS COMPANY
% ROBERT E. MASON & CO
P O BOX 33424
CHARLOTTE NC 28233

S DUKE POWER CO.
H OCONEE NUCLEAR STATION E14357-K2
I C/O H.A. HEDDEN
P HIGHWAY 183
T
O

SENECA, SC 29678

VIA DELIVER

HEREIN DESIGNATED SELLER

TAX CERTIFICATE NUMBER:

NC25 SC1002-19

Ein NUMBER: 56-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER

BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR
SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF
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ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			***** * * EDI ORDER * * * THIS ORDER HAS BEEN TRANSMITTED * * ELECTRONICALLY TO THE VENDOR. * * PLEASE SEND ORIGINAL COPY TO THE * * EDI COORDINATOR FOR VERIFICATION. * ***** PLEASE RUSH - ITEMS 1 AND 2 NEEDED FOR UPCOMING OUTAGE.		
1	1	EA	GASKET, , TYPE: BONNET APPLICATION: FOR FISHER GLOBE VALVE MODEL 475-DBQ 2.0 INCH MFR: FISHER GOVERNOR CO. PART #: 1L120899442	244401187	16.45 EA
2	5	EA	O-RING, MFR: FISHER CONTROLS CO. PART #: 1H849806992 (CONT. ON PAGE 2)	254101840	.60 EA

SHIPPING
TERMS

FOB: DEST

CASH NET 30 DAYS
TERMS

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
3. If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents.
4. Show ID numbers on boxes and invoices if shown on this order.

TWO COPIES OF INVOICE, WITH FREIGHT BILL
OR OTHER SHIPPING DOCUMENTS ATTACHED,
ARE TO BE MAILED TO:

DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

ADDRESS
REPLY TO:

J.L. ROSEMAN

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

5. ALL OCONEE NUCLEAR STATION PURCHASING
DEPARTMENT CORRESPONDENCE IS TO BE
MAILED TO:

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 215
SENECA SC 29678

FILE COPY

(803) 885-3551
(803) 885-3558

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DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL
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E14357-K2

EDI

ORDER DATE

PAGE 2

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER:

NC26 SC1002-19

EIN NUMBER: 56-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER

BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
3	1	EA	ASSEMBLY, , SHAFT AND DISC, TYPE: BUTTERFLY VALVE APPLICATION: BUTTERFLY VALVE 8 INCH TYPE 9110 MFR: FISHER CONTROLS CO. PART #: H11780X0032	254102550	1,493.10 EA
4	2	EA	PACKING, RING, MATERIAL: TEFLON APPLICATION: FOR 24 INCH TYPE 7640 BUTTERFLY VALVE MFR: FISHER CONTROLS CO. PART #: G1860401302	254102508	25.20 EA
5	5	EA	PACKING, , MATERIAL: TEFLON APPLICATION: FOR VEE-BALL VALVE SIZE 6 INCH 657-B-U MFR: FISHER CONTROLS CO. PART #: 1R516001012	254202275	19.53 EA
6	1	EA		254200670	54.81 EA

(CONT. ON PAGE 3)

IPPING
RMS

CASH
TERMS

ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
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If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents.
Show ID numbers on boxes and invoices if shown on this order.

10 COPIES OF INVOICE, WITH FREIGHT BILL
OTHER SHIPPING DOCUMENTS ATTACHED,
ARE TO BE MAILED TO:

ALL OCONEE NUCLEAR STATION PURCHASING
DEPARTMENT CORRESPONDENCE IS TO BE
MAILED TO:

DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 219

ADDRESS
REPLY TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

ROA_03592

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731077432

ENC
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EU76 STK JLR/TLC/

CC2444 PCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL
COPIES OF THE INVOICE AND ON ALL PACKAGES.

ORDER DATE

E14357-K2 **EDI**

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE N C 28233

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PAGE 3

HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER:
NC26 SC1002-19
EIN NUMBER: 56-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*

BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
7	1	EA	SEAL, , TYPE: BALL APPLICATION: FOR 6 INCH TYPE 657-B-U CONTROL VALVE MFR: FISHER CONTROLS CO. PART #: 1R9703-36142 DWG #: CU5686	254200671	308.70 EA
8	2	ST	RING, BACK-UP APPLICATION: FOR FISHER 6 INCH BALL VALVE MFR: FISHER CONTROLS CO. PART #: 1P5698-36042 DWG #: CU5686	254600596	25.83 ST
9	3	EA	PACKING SET, APPLICATION: FOR FISHER VALVE 6 INCH TYPE EHT AND SIZE 16 INCH VALVE MFR: FISHER CONTROLS CO. PART #: 1R290801012	244400529	44.10 EA
GASKET, FLANGED FITTING, TYPE: SPIRAL WOUND, MATERIAL: 316 SS WITH ASBESTOS, (CONT. ON PAGE 4)					

SHIPPING
TERMS

CASH
TERMS

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
3. If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents.
4. Show ID numbers on boxes and invoices if shown on this order.

TWO COPIES OF INVOICE, WITH FREIGHT BILL
AND OTHER SHIPPING DOCUMENTS ATTACHED,
ARE TO BE MAILED TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

ALL OCONEE NUCLEAR STATION PURCHASING
DEPARTMENT CORRESPONDENCE IS TO BE
MAILED TO:

DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

ADDRESS
REPLY TO:

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 219
SENECA SC 29670

FILE COPY

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V#90520801 OT04

EU76 STK JLR/TLC/

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DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES.

E14357-K2

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ORDER DATE

PAGE 4

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE, N.C. 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER:
NC26 SC1002-19
EIN NUMBER: 56-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER
BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
	2	EA	SIZE: 1-13/16" ID X 1-15/16" OD X .175" THK APPLICATION: FOR GLOBE VALVE TYPE DBQ SIZE 1 INCH MFR: FISHER CONTROLS CO. PART #: 1N297999102 LINER, , TYPE: VALVE APPLICATION: FOR TYPE 9110 VALVE MFR: FISHER CONTROLS CO. PART #: F2622806782 DWG #: F11733 IT. 197 DELIVERY COMMITMENT: ITEMS 1 & 2 - STOCK PER S. MIRANDA ITEMS 3 & 4 - 2-3 WEEKS (04/13/93) BALANCE - 4-6 WEEKS (05/06/93) NEED DATE: ITEMS 1 & 2 - 03/31/93 BALANCE - ON OR BEFORE 05/30/93 PRICE AND DELIVERY PER PRICE LIST DATED 03/03/93. PRICED BY B. PARKER (CONT. ON PAGE 5)	254101906	166.95 EA

SHIPPING TERMS

CASH
TERMS

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WO COPIES OF INVOICE, WITH FREIGHT BILL
OR OTHER SHIPPING DOCUMENTS ATTACHED,
ARE TO BE MAILED TO:

5. ALL OCONEE NUCLEAR STATION PURCHASING
DEPARTMENT, CORRESPONDENCE IS TO BE
MAILED TO:

DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 215

ADDRESS
REPLY TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

FILE COPY

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CC2444 PCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES.

E14357-K2

***EDI**

ORDER DATE

PAGE 5

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER:

NC26 SC1002-1B

EIN NUMBER: 56-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER

BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			03/22/93. ***** * CONFIRMATION-DO NOT DUPLICATE (04) * ***** PURCHASE ORDER NUMBER, ID NUMBER, AND PART(S) NUMBER (AS APPLICABLE) MUST BE SHOWN ON ALL PACKING LISTS, BOXES, CARTONS, REELS, PART(S) TAGS, AND INVOICES. (05) "SHIPMENTS WILL BE ACCEPTED MONDAY THRU THURSDAY, 8:00 AM TILL 11:30 AM AND 12:30 PM TILL 4:30 PM, EXCEPT HOLIDAYS (INCLUDING EASTER MONDAY, DAY AFTER THANKSGIVING AND CHRISTMAS EVE). IN INSTANCES WHERE SHIPMENTS ARE NOT SO ENDORSED, ALL EXCESS CHARGES FOR DETENTION OR REDELIVERY WILL BE REBILLED TO THE SUPPLIER." (82) ***** * PLEASE CONFIRM SHIP DATE UPON RECEIPT OF THIS ORDER * (CONT. ON PAGE 6)		

SHIPPING TERMS

CASH TERMS

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
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4. Show ID numbers on boxes and invoices if shown on this order.

TWO COPIES OF INVOICE, WITH FREIGHT BILL OR OTHER SHIPPING DOCUMENTS ATTACHED, ARE TO BE MAILED TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

6. ALL OCONEE NUCLEAR STATION PURCHASING DEPARTMENT CORRESPONDENCE IS TO BE MAILED TO:

DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

ADDRESS
REPLY TO:

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 219

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DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL
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E14357-K2

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ORDER DATE

PAGE 6

FISHER CONTROLS COMPANY
% ROBERT E. MASON & CO
P O BOX 33424
CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER:
NC26 SC1002-19
EIN NUMBER: 58-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*

BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			* ***** (4G) ***** *****		
SHIPPING TERMS			CASH TERMS		

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
3. If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents.
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TWO COPIES OF INVOICE, WITH FREIGHT BILL OR OTHER SHIPPING DOCUMENTS ATTACHED, ARE TO BE MAILED TO:

6. ALL OCONEE NUCLEAR STATION PURCHASING DEPARTMENT CORRESPONDENCE IS TO BE MAILED TO:

DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

ADDRESS
REPLY TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 219

FILE COPY

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CC2444 PCC9370
DUKE POWER COMPANY
PURCHASING DEPARTMENT

PURCHASE ORDER

FILE

186.1-7.30:

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES.

ORDER DATE

5-19-93

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FISHER CONTROLS COMPANY
 2 ROBERT E MASON & CO
 P.O. BOX 33424
 CHARLOTTE N C 28233

DUKE POWER CO.
OCONEE NUCLEAR STATION E21111-K2
C/O H.A. HEDDEN
HIGHWAY 183

SENECA, SC 29678
DELIVER

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DELIVER

TAX CERTIFICATE NUMBER:

NC26 SC1002-19

EIN NUMBER: 56-020550

~~HEREIN DESIGNATED SELLER~~

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER

VIA DELIVER

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*

*BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

DESCRIPTION	ID NUMBER

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			***** * EDI ORDER * * THIS ORDER HAS BEEN TRANSMITTED * * ELECTRONICALLY TO THE VENDOR. * * PLEASE SEND ORIGINAL COPY TO THE * * EDI COORDINATOR FOR VERIFICATION. * ***** ORDER PLACED BY PHONE, BILL PARKER TO S. MERANDA 05/18/93.		
1	1 EA		CAGE, VALVE, VALVE STYLE: GLOBE, VALVE SIZE: 16" APPLICATION: TYPE 476L-16-5-ENA "PISTON"	2444372756	12,070.80 EA
2	10 EA		MFR: FISHER CONTROLS CO. PART #: 4U7660X00A2	254102505	25.20 EA
			PACKING, RING, MATERIAL: TEFLON APPLICATION: FOR 24 INCH BUTTERFLY VALVE (CONT. ON PAGE 2)		

SHIPPING TERMS: FOB: DESTINATION
 ACKNOWLEDGE ORDER BY PROFORMA
 PLANTER'S EXHIBIT

SHIPPING
ARMS

FOB: DESTINATION

CASH NET 30 DAYS
TERMS

ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents.
Show ID numbers on boxes and invoices if shown on this order.

COPIES OF INVOICE, WITH FREIGHT BILL,
OTHER SHIPPING DOCUMENTS ATTACHED,
ARE TO BE MAILED TO:

ALL OCONEE NUCLEAR
DEPARTMENT CORRESPONDENCE IS TO BE
MAILED TO:

DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

ADDRESS
REPLY TO: J. L. ROSEMAN

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

DUKE POWER COMPANY
ODONEE NUCLEAR STATION
PURCHASING DEPARTMENT

(803) 885-3551
(807)

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22444 PCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES.

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ORDER DATE

PAGE 2

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE N C 28233

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VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 58-020550			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
3	1	EA	TYPE 7640 MFR: FISHER CONTROLS CO. PART #: G1860301302 CAGE, VALVE, VALVE STYLE: DIAPHRAGM CONTROL, VALVE SIZE: 8" X 10" APPLICATION: FOR 8X10 INCH FISHER DIAPHRAGM CONTROL VALVE MFR: FISHER CONTROLS CO. PART #: 2U228233272	299.25 EA
4	14	EA	SEAL, , TYPE: SHIM APPLICATION: FOR 16 INCH FISHER V-BALL VALVE, TYPE U MFR: FISHER CONTROLS CO. PART #: 1R23764112	28.35 EA
5	2	EA	ASSEMBLY, , PLUG STEM, TYPE: GLOBE VALVE APPLICATION: FOR 3 INCH GLOBE VALVE PART NUMBER 11A5229X042 FISHER CONTROL (CONT. ON PAGE 3)	926.10 EA

SHIPPING
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TERMS

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TWO COPIES OF INVOICE, WITH FREIGHT BILL
OR OTHER SHIPPING DOCUMENTS ATTACHED,
ARE TO BE MAILED TO:

6. ALL OCONEE NUCLEAR STATION PURCHASING
DEPARTMENT CORRESPONDENCE IS TO BE
MAILED TO:

DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 219
SENECA SC 29579

ADDRESS
REPLY TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

FILE COPY

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DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

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E21111-K2 **EDI**

ORDER DATE

PAGE 3

FISHER CONTROLS COMPANY
 % ROBERT E MASON & CO
 P O BOX 33424
 CHARLOTTE NC 28233

SHIP TO

HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 56-020550			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
6	1	EA	MFR: FISHER CONTROLS CO. PART #: 11A5229X042 254200210 SEAL, TYPE: BALL APPLICATION: FOR FISHER CONTROLS BALL VALVE 16 INCH MFR: FISHER CONTROLS CO. PART #: 1V629805302 254201609	469.35 EA
7	6	ST	PACKING SET, APPLICATION: FOR BALL VALVE 16 INCH MFR: FISHER CONTROLS CO. PART #: 1R516201012 254202253	51.66 ST
8	6	EA	GASKET, FLANGED FITTING, TYPE: SPIRAL WOUND, MATERIAL: 316 SS WITH ASBESTOS, SIZE: 3-9/16" ID X 4-5/16" OD X .125" THK APPLICATION: FOR FISHER VEE-BALL VALVE U TYPE 10 INCH (CONT. ON PAGE 4)	9.14 EA

SHIPPING TERMS

CASH TERMS

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6. ALL OCONEE NUCLEAR STATION PURCHASING DEPARTMENT CORRESPONDENCE IS TO BE MAILED TO:

DUKE POWER COMPANY
 INVOICE OPERATIONS - PB02G
 PO BOX 1015
 CHARLOTTE NC 28201-1015

DUKE POWER COMPANY
 OCONEE NUCLEAR STATION
 PURCHASING DEPARTMENT
 PO BOX 200
 SENECA, SC 29679

ADDRESS REPLY TO:

FILE COPY

DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 R.E. SMITH
 General Manager, Purchases

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DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

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ORDER DATE

PAGE 4

FISHER CONTROLS COMPANY
 % ROBERT E MASON & CO
 P O BOX 33424
 CHARLOTTE NC 28233

SHIP TO

HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 56-020560			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
9	2	EA	MFR: FISHER CONTROLS CO. PART #: 1P927299102 ADAPTER, , TYPE: SEAT RING APPLICATION: FOR A 2 1/2" X 4" X 10" FISHER MODEL ES CONTROL VALVE SERIAL NUMBERS 4B31796 & 4031797 MFR: FISHER CONTROLS CO. PART #: 1U2396X0022 DELIVERY COMMITMENT: ITEM 9 - BY 05/20/93 BALANCE - BY 07/01/93 (PER S. MIRANDA) PRICE AND DELIVERY PER PRICE LIST DATED 03/03/93. DELIVERY REQUIRED: 7-01-93 PURCHASE ORDER NUMBER, ID NUMBER, AND PART(S) NUMBER (AS APPLICABLE) MUST BE SHOWN ON ALL PACKING LISTS, BOXES, CARTONS, REELS, PART(S) TAGS, AND INVOICES. (CONT. ON PAGE 5)	2546320575 1,456.00 EA

SHIPPING TERMS

CASH TERMS

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DUKE POWER COMPANY
 INVOICE OPERATIONS - PB02G
 PO BOX 1015
 CHARLOTTE NC 28201-1015

DUKE POWER COMPANY
 OCONEE NUCLEAR STATION
 PURCHASING DEPARTMENT
 PO BOX 219

ADDRESS REPLY TO

DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 R.F. SMITH
 General Manager, Purchases

ROA_03600

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V#90520B01 OT02

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DUKE POWER COMPANY

PURCHASING DEPARTMENT

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PAGE 5

FISHER CONTROLS COMPANY

% ROBERT E MASON & CO

P O BOX 33424

CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 56-020550 MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER* BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.					
			"ALL INSIDE PACKAGING AND/OR PACKING MATERIAL MUST BE BIODEGRADABLE, I.E., NO PLASTICS OR STYROFOAM." (2F) "SHIPMENTS WILL BE ACCEPTED MONDAY THRU THURSDAY, 8:00 AM TILL 11:30 AM AND 12:30 PM TILL 4:30 PM, EXCEPT HOLIDAYS (INCLUDING EASTER MONDAY, DAY AFTER THANKSGIVING AND CHRISTMAS EVE). IN INSTANCES WHERE SHIPMENTS ARE NOT SO ENDORSED, ALL EXCESS CHARGES FOR DETENTION OR REDELIVERY WILL BE REBILLED TO THE SUPPLIER." (82) ***** * * CONFIRMATION-DO NOT DUPLICATE (01) * * ***** ***** * * PLEASE CONFIRM SHIP DATE UPON * * RECEIPT OF THIS ORDER * * (4G) * *****		
SHIPPING TERMS			CASH TERMS		

- NOT TO SELLER
1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
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DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

5. TWO COPIES OF INVOICE, WITH FREIGHT BILL OR OTHER SHIPPING DOCUMENTS ATTACHED, ARE TO BE MAILED TO:

DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

ADDRESS
REPLY TO:

6. ALL OCONEE NUCLEAR STATION PURCHASING DEPARTMENT CORRESPONDENCE IS TO BE MAILED TO:

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 210
SENFCA, SC 29875

FILE COPY

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REV. 9/92

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PS JS DHC

V#90520801 0Y00 CC

EU STK EAL/CDH

PURCHASE ORDER

IMPORTANT

Mill-Power Supply Co.

No. H23395-73

5-24-82

FISHER CONTROLS COMPANY
 K. ROBERTSON MASON & CO
 P.O. BOX 32307
 CHARLOTTE N.C. 28233

S. DUKE POWER CO.
 C/O J. ED SMITH, MGR.
 OCONEE NUCLEAR STATION
 HIGHWAY 130
 P.O. BOX 1439
 SENECA, SC 29678

CNS #001
 033-73307

H23395-73

CNS #002

HEREIN DESIGNATED SHIPPER

VIA UPS INSURED

MAKE ☒ K DUKE POWER CO.
 INVOICE TO: MILL-POWER SUPPLY CO.
 MAIN INVOICE AS DIRECTED BELOW UNDER NOTICE TO SELLER
 BUYER WHOSE ADDRESS AND SIGNATURE APPEAR BELOW AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER, OR TO PERSON HEREIN DESIGNATED AT THE LOCATION, AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED, THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
1	2	EA	DIAPHRAGM FOR FISHER CONTROLS DIAPHRAGM ACTUATOR MODEL 657 SIZE 45&50 CLASS B FURNISHED TO D.P.CO. SPEC. CNS-1205.06-3 P.O. A-98519	25510087N	54.40 EA
2	2	EA	GASKET GAGE 3 1/2 X 4 3/32 X 1/32 ASBESTOS SPEC FMS-17A2 P/N-1R984604022 FOR A FISHER 4 IN. GLOBE VALVE	244401862N	1.02 EA
3	2	EA	GASKET, BONNET 5 X 6 3/32 X 1/32 ASBESTOS SPEC FMS-17A2 PART NO. 1R972404022 FOR A FISHER 4 IN GLOBE VALVE	244401863N	1.53 EA
4	2	EA	PIN, GROOVE TYPE C FOR FISHER CONTROLS DIAPHRAGM ACTUATED CONTROL VALVE TYPE ED, CS&YD SIZE .75, 1.2&3 INCH BODY SCREWED, SOCKET WELD&FLANGED RATING, ANSI 600 CLASS B FURNISHED TO D.P.CO. SPEC. CNS-1205.06-3	243900042N	.31 EA
5	2	EA	STEM, PLUG FOR FISHER CONTROLS DIAPHRAGM ACTUATED CONTROL VALVE TYPE ED, ES, ET, EAT&EWY SIZE 2.5, 3, 4, 6, 8, 10, 8X10, (CONT. ON PAGE 2)	244400468N	44.20 EA

SHIPPING TERMS

FOB MARSHALLTOWN, IOWA

CASH TERMS

NET 30 DAYS

NOTICE TO SELLER

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
3. If freight is prepaid and added to invoice attach expense bill.
4. Show ID numbers on boxes and invoices (if shown on this order).
5. THREE COPIES OF INVOICE, WITH SHIPPING PAPERS ATTACHED, ARE TO BE MAILED TO:

MILL-POWER SUPPLY CO.
 CHARLOTTE N.C. 28232-2307
 P.O. BOX 32307 TELEX 572340

ADDRESS
 REPLY TO:

E.A. LAIL

(704) 779

FILE COPY



ROA_03602

VW90520801 DT00 CC

EU

EAL/CDH

PURCHASE ORDER

Mill-Power Supply Co.

IMPORTANT

No. H23975-70

THIS ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES

PAGE 2

FISHER CONTROLS COMPANY
 % ROBERT E. MASON & CO
 P.O. BOX 39424
 CHARLOTTE, N.C. 28233

SHIP TO

HEREIN DESIGNATED SHIPPER

VIA

MAKE: DUKE POWER CO.
 INVOICE TO: MILL-POWER SUPPLY CO.
 MAIL INVOICE AS DIRECTED BELOW UNDER NOTICE TO SELLER

BUYER WHOSE ADDRESS AND SIGNATURE APPEAR BELOW AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED, AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES:

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
6	2	EA	10X16X14X16 INCH BODY BUTT WELD SCHEDULE 40&80&FLANGED RATING ANSI 600 CLASS F FURNISHED TO D.P.CO. SPEC. CNS-1205.06-3		
7	2	EA	PLUG VALVE FOR FISHER CONTROLS DIAPHRAGM ACTUATED CONTROL VALVE TYPE ES SIZE 4&6 INCH BODY BUTT WELD SCHEDULE 40&FLANGED CLASS F FURNISHED TO D.P.CO. SPEC. CNS-1205.06-3	244400463N	268.60 EA
8	2	EA	GASKET, SPIRAL WOUND 3 9/16 X 4 1/16 X 0.175 INCONEL GRAPHITE PART NO. 1R384599442 FOR A FISHER 4 IN GLOBE VALVE	244401864N	18.36 EA
9	2	EA	GASKET, ADAPTOR 5 X 5 15/32 X 1/32 ASBESTOS SPEC. FMS-17A2 PART NO. 1J504704022 FOR A FISHER 4 IN GLOBE VALVE	244401865N	1.53 EA
	2	EA	RING SEAT FOR FISHER CONTROLS DIAPHRAGM ACTUATED CONTROL VALVE TYPE ED, ES&ET SIZE 2.5, 4&6 INCH BODY BUTT WELD (CONT. ON PAGE 3)	244400489N	67.32 EA

SHIPPING TERMS

CASH TERMS

NOTICE TO SELLER

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
3. If freight is prepaid and added to invoice, attach expense bill.
4. Show ID numbers on boxes and invoices if shown on this order.
5. THREE COPIES OF INVOICE, WITH SHIPPING PAPERS ATTACHED, ARE TO BE MAILED TO:

MILL-POWER SUPPLY COMPANY ("BUYER")

W. T. ROBERTSON, JR., PRES.

MILL-POWER SUPPLY CO.
 CHARLOTTE, N.C. 28232-2307
 P.O. BOX 32307, TELEX 57-2346

ADDRESS REPLY TO:

(704)

FILE COPY

ROA_03603

V#90520801 DT00 CC

EU

EAL/CDH

PURCHASE ORDER

Mill-Power Supply Co.

IMPORTANT

No. H23395-73

THIS ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES

PAGE 3

FISHER CONTROLS COMPANY
 % ROBERT E MASON & CO
 P O BOX 33424
 CHARLOTTE N C 28233

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HEREIN DESIGNATED SHIPPER

VIA

MAKE ☐ DUKE POWER CO.
 INVOICE TO: ☐ MILL-POWER SUPPLY CO.
 MAIL INVOICE AS DIRECTED BELOW UNDER NOTICE TO SELLER

BUYER WHOSE ADDRESS AND SIGNATURE APPEAR BELOW AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
10	2	EA	SCHEDULE 40 FLANGED DESIGN PRESSURE 300 PSIG DESIGN TEMPERATURE 300 DEGREES F. CLASS C FURNISHED TO D.P.CO. SPEC. CNS-1205.06-3		
11	2	EA	GASKET SEAT RING 3 1/2 X 3 29/32 X 1/32 ASBESTOS SPEC. FMS-17A2 P/N-1R884404022 FOR A FISHER 4 IN GLOBE VALVE	244401866N	.85 EA
12	2	EA	O-RING 7/8 X 1/8 X 1/8 NITRILE PART NUMBER 1B885506992 FOR A FISHER 4 IN GLOBE VALVE	244401867N	.31 EA
13	2	EA	PIN GROOVE TYPE C FOR FISHER CONTROLS DIAPHRAGM ACTUATED CONTROL VALVE TYPE ES, ET, END&U SIZE 2, 4, 6 & 8 INCH BODY FLANGED RATING ANSI 300 FURNISHED TO D.P.CO. SPEC. CNS-1205.06-3	243900044N	.31 EA
			O-RING 6 3/4 X 7 X 1/8 NITRILE PART NUMBER 1D547106992 FOR A FISHER 4 IN GLOBE VALVE	244401868N	3.40 EA

(CONT. ON PAGE 4)

SHIPPING TERMS

CASH TERMS

NOTICE TO SELLER

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
3. If freight is prepaid and added to invoice attach expense bill.
4. Show ID numbers on boxes and invoices if shown on this order.
5. THREE COPIES OF INVOICE WITH SHIPPING PAPERS ATTACHED ARE TO BE MAILED TO:

MILL-POWER SUPPLY COMPANY ("BUYER")

W. T. ROBERTSON, JR., PRES.

MILL-POWER SUPPLY CO.
 CHARLOTTE N.C. 28232-2307
 P.O. BOX 32307 • TELEX 57-2346

ADDRESS REPLY TO:

(704)

FILE COPY

ROA_03604

V#90520801 DT00 CC

EU

EAL/CDH

PURCHASE ORDER

Mill-Power Supply Co.

IMPORTANT

No. H23395-73

THIS ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES

PAGE 4

FISHER CONTROLS COMPANY
 X ROBERT E MASON & CO
 P O BOX 33424
 CHARLOTTE N C 28238

S
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VIA

HEREIN DESIGNATED SHIPPER

MAKE ☐ DUKE POWER CO.
 INVOICE TO: ☐ MILL-POWER SUPPLY CO.
 MAIL INVOICE AS DIRECTED BELOW UNDER NOTICE TO SELLER*

BUYER WHOSE ADDRESS AND SIGNATURE APPEAR BELOW AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES

ITEM NO	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			THIS MATERIAL AND/OR SERVICE SHALL BE FURNISHED UNDER THE QUALITY ASSURANCE PROGRAM OF THE FISHER CONTROLS FACILITY AT GOVERNOR RD. & OLIVE STREET, MARSHALLTOWN, IOWA. PRICE AND DELIVERY PER YOUR QUOTATION DATED 5-17-82. COMMITTED DELIVERY 8-27-82. FORMS ATTACHED: QA-505B 7310820370. DELIVERY REQUIRED: 9-01-82 ID NUMBER AND PURCHASE ORDER NUMBER MUST BE SHOWN ON ALL PACKING LISTS, BOXES, CARTONS, REELS, PARTS TAGS, AND INVOICES. (05) THE PROVISIONS OF TITLE 10, CODE OF FEDERAL REGULATIONS, PART 21 APPLY TO THIS PURCHASE. THE SIGNER OF THIS PURCHASE ORDER SHALL BE NOTIFIED IF THIS REGULATION IS INVOKED.		SPECIAL CLEANING, PACKAGING, AND DUKE FORM 930.1A - 79.40 EACH. DUKE FINAL INSPECTION IF REQUIRED - 25.00 EACH.

(CONT. ON PAGE 5)

SHIPPING TERMS

CASH TERMS

* NOTICE TO SELLER

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
3. If freight is prepaid and added to invoice attach expense bill.
4. Show ID numbers on boxes and invoices if shown on this order.
5. THREE COPIES OF INVOICE, WITH SHIPPING PAPERS ATTACHED, ARE TO BE MAILED TO:

MILL-POWER SUPPLY CO.
 CHARLOTTE, N.C. 28232-2807
 P.O. BOX 32307 TELEX 572946

MILL-POWER SUPPLY COMPANY ("BUYER")

W. T. ROBERTSON, JR., PRES.

ADDRESS
REPLY TO:

(764)

FILE COPY

ROA_03605

26050 (R12-81)

PREPARED BY S. MillerDATE 7-23-85DUKE POWER COMPANY
QUALITY ASSURANCE DEPARTMENT
FORM QA-505BNUMBER 7310820570PAGE 1 OF 1

QUALITY ASSURANCE REQUIREMENTS TO BE MET BY VENDORS OF ITEMS AND SERVICES

Items of services on this order must be manufactured or performed under a Duke-approved quality program. In accepting this order the designated vendor commits to the above as well as the performance and documentation of the tests or certifications checked below.

This documentation to be forwarded no later than date of shipment to: Quality Assurance Manager, Technical Services
Duke Power Company Post Office Box 33189 Charlotte, North Carolina 28242

IMPORTANT NOTICE TO VENDORS:

The documentation specified on this form constitutes an integral part of the purchase order requirements. Failure to supply it as specified will result in the items being quarantined upon receipt.

REMARKS:

*SUPPLY DOCUMENTATION IN ACCORD WITH DUKE SPEC. CNS
1205.06-3 LATEST REVISION.

The following documentation shall be forwarded as indicated above:

<u>X</u>	1. Results of all tests, inspections or certifications checked above.
<u>X</u>	2. Results of all tests, inspections or certifications required by referenced specifications.
<u>X</u>	3. Results of all tests, inspections or certifications required by referenced codes or standards.
<u>X</u>	4. Duke 930.1a Form
<u> </u>	5. Duke 930.1c Form
<u> </u>	6. <u> </u>

NOTIFICATION POINTS:

Vendor shall notify Duke QA Department at telephone number (704)373-4288 5 days prior to the following tests or inspections to allow in plant surveillance by Duke Personnel as deemed necessary.

<u> </u> 1. None	<u> </u> 2. Hydro Test	<u>X</u> 3. Final Inspection
<u> </u> 4. NDE:	<u> </u>	
<u> </u> 5. Other:	<u> </u>	

PACKAGING AND SHIPPING REQUIREMENTS:

All items to be packaged and shipped per ANSI N45.2.2-1972

Protection B

Rev. 8

Detailed codes, standards and other requirements
for tests, inspections or certifications *

Line Item Number	From Purchase Order	1. Cert. of Compliance	2. Functional Test	3. Phys. & Chem. Analysis	4. PT	5. MT	6. UT	7. RT	8. Hydro	9.	10.	11.	12. ANSI N45.2.1	REMARKS
1	X													
2	X													
3	X													
4	X													
5	X													
6	X													
7	X													
8	X													
9	X													
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FISHER SERVICE COMPANY - COLUMBIA, SOUTH CAROLINA		FISHER	
Customer Order Number A06650-77	Fisher Agent Order Number 033 - 604C98985	Invoice Date 03/06/91	Invoice Number K022828

DUKE POWER COMPANY
P.O. BOX 1002
CHARLOTTE N.C.

28201

REMIT TO:
FISHER CONTROLS INTL INC
P.O. BOX 459F
ST. LOUIS, MO. 63150

PAGE 2

(Same as "Sold To" Unless Otherwise Indicated)
Ship To: DUKE POWER CO/H B BARRON
OCONEE NUCLEAR STATION
7812 ROCHESTER HWY.
SENECA, SC.

19679

TERMS:
NET 030 DAYS IN U.S. FUNDS
F.O.B. COLUMBIA, SOUTH CAROLINA

Date Shipped		
Mo.	Day	Year
3	5	91

Via UPS NEXT DAY AIR

Item No.	Description	Quantity	Unit Price	Net Amount
00010	1P927299102 - GASKET, SPIRAL WOUND TAG: 254202253	3	9.45	28.35
00011	1B885506992 - O-RING TAG: 254202407	13	0.39	5.07
00012	1U222739102 - SEAT RING TAG: 254601358	3	385.00	1155.00
00013	24A1135X012 - SEAT RING TAG: 2546263121	2	770.00	1540.00
00014	3BA1025X012 - CASE, CAVITY, 1 STAGE TAG: 2546263124	1	1582.00	1582.00
00015	OVERTIME CHARGE - WEEKEND WORK	1	750.00	750.00
00800	FREIGHT OUT - VIA	1	122.75	122.75
	SUBTOTAL			10491.74
	INVOICE TOTAL			10491.74



We warrant the material returned without our permission. This material was carefully packed and delivered to the transportation company in good condition. All claims for loss or damage must be made to the transportation company. Goods shipped under this invoice are covered by the Federal Labor Standards Act of 1938, as amended. If items covered by this invoice are for ultimate export or export, they must be properly marked and labeled.

COPY OF INVOICE

Form FG-7165

ROA_03608

W.A.

JES

V#90520801 DT50

EU76 STK JLR/GGC/P

CC2444. FCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES.

ORDER DATE

A06650-77

****E.D.I.****

PAGE 7

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE N C 28233

SHIRO

HEREIN DESIGNATED SELLER

YIA

TAX CERTIFICATE NUMBER:

NC26 SC1002-19

EIN NUMBER: 66-020650

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*
NO SIGNATURE APPEAR BELOW

[illegible]

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			* ***** ***** * PLEASE CONFIRM SHIP DATE UPON * * RECEIPT OF THIS ORDER * * (4G) *		
			SHIPPING TERMS		
			CASH TERMS		

SHIPPING
TERMS

CASH
TERMS

***NOTICE TO SELLER**

NOTICE TO SELLER
 ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
 Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
 If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents.
 Show lot numbers on boxes and invoices if shown on this order.
 SEE COPIES OF INVOICE

FREE COPIES OF INVOICE, WITH FREIGHT BILL
OTHER SHIPPING DOCUMENTS ATTACHED,
ARE TO BE MAILED TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
PO BOX 1002
CHARLOTTE NC 28201-1002

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

ADDRESS
REPLY TO

09/09/90

TELECOPIER: CUSTOMER GROUP (704) 378-3336
POWER GROUP (704) 382-2208

FILE COPY

ROA 03609

FISHER SERVICE COMPANY, COLUMBIA, SOUTH CAROLINA				FISHER
Customer Order Number A06650-77	Fisher / Agent Order Number 033 - 004C93985	Invoice Date 03/06/91	Invoice Number K022828	

DUKE POWER COMPANY
P O BOX 1002
CHARLOTTE N.C.

REMIT TO:
FISHER CONTROLS INTL INC
P.O. BOX 459F
ST. LOUIS, MO, 63150

PAGE 1

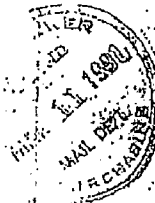
Ship To (Same as Sold To Unless Otherwise Indicated)
DUKE POWER CO/H B BARRON
SCONEE NUCLEAR STATION
2812 ROCHESTER HWY
SENECA, SC

TERMS:
NET 030 DAYS IN U.S. FUNDS
P.O.B. COLUMBIA, SOUTH CAROLINA

Date Shipped		
Mo.	Day	Year
3	5	91

Via		UPB NEXT DAY AIR		
Item No.	Description	Quantity	Unit Price	Net Amount
	JOB NO: T15811			
0001	10A4223X012 - SEAL RING/SPR,RADIAL TAG: 244400452	2	80.50	161.00
0002	10A4225X012 - RING,RETAINING,EXT TAG: 244402414	1	25.20	25.20
0003	RPACKX00032 - KIT,REPAIR TAG: 244406359	3	29.40	88.20
0004	11A5229X042 - PLUG/STEM,HI-TEMP TAG: 244406939	2	980.00	1960.00
0005	28A1010X022 - PLUG/STEM,CAV III TAG: 2444261242	4	661.50	2646.00
0006	1H849804992 - O-RING TAG: 254101840	3	0.39	1.17
0007	01860301302 - PACKING,V-RING TAG: 254102505	12	26.60	319.20
0008	01860401902 - PACKING ADAPTOR,MALE TAG: 254102508	2	26.60	53.20
0009	1R516201012 - PACKING,SET TAG: 254201609	1	54.60	54.60

INVOICE CONTINUED



Will be allowed for material returned without our permission. This material was carefully packed and delivered to the transportation company in good condition. All claims for loss or damage in transit should be made to the transportation company at once. Seller represents that the articles or services covered by this invoice were produced in compliance with the Fair Labor Standards Act of 1938, as amended, if items covered by this invoice are for ultimate export or re-export.

COPY OF INVOICE

Form PG 7165

ROA_03610

7310904483

WA

JES

V490520801 10150

EU76 STK JLR/GGC/P

CC2444 FCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

12424.99

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL
COPIES OF THE INVOICE AND ON ALL PACKAGES.

A06650-77

EDI

ORDER DATE

2-28-91

FISHER CONTROLS COMPANY
 % ROBERT E MASON & CO
 P O BOX 33424
 CHARLOTTE N C 28233

S. DUKE POWER CO.
 H. C/O H.B. BARRON
 P. OCONEE NUCLEAR STATION
 T. 7812 ROCHESTER HIGHWAY
 O. SENECA, S.C. 29678
 P.O. BOX 1439, SENECA S.C. 29679
 VIA YOUR TRUCK

HEREIN DESIGNATED SELLER

TAX CERTIFICATE NUMBER:

NC26 SC1002-19

EIN NUMBER: 56-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*
 BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR
 SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF
 THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE
 LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			***** * * EDI PARALLEL TEST ORDER * * * THIS ORDER PRINTED FOR VERIFICATION * * PURPOSES ONLY. * * * PLEASE SEND ORIGINAL TO EDI * * COORDINATOR. * * *****		
	2 EA		ORDER PLACED BY PHONE 2-27-91 R. PARKER TO A. STEHLEY 10A4223X012 RING, TYPE: SPRING LOADED SEAL, 244400452 APPLICATION: FOR GLOBE VALVE SIZE 4 INCH TYPE ET, 6 INCH TYPE EWT, 6 INCH X 10 INCH TYPE ET, 8 INCH TYPE EWT, 10 INCH X 16 INCH TYPE EWT, 14 INCH X 16 INCH TYPE EWT		80.50 EA
			MANUFACTURER: FISHER PRODUCTS INC., PART NUMBER: 10A4223X012 (CONT. ON PAGE 2)		
SHIPPING TERMS			FOR JOBSITE		
			CASH NET 30 DAYS		

*NOTICE TO SELLER

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
 Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
 If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents.
 2. Show ID numbers on boxes and invoices if shown on this order.
 3. REF COPIES OF INVOICE, WITH FREIGHT BILL
 OR OTHER SHIPPING DOCUMENTS, ATTACHED,
 ARE TO BE MAILED TO:

DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 P O BOX 1002
 CHARLOTTE NC 28201-1002

ADDRESS
REPLY TO:

DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 R.F. SMITH
 General Manager, Purchases

J.L. ROSEMAN

EV. 09/90

ELEX 57-2346 TELECOPIER: CUSTOMER GROUP (704) 373-3338
 POWER GROUP (704) 382-2285

FILE COPY

(704) 373-6059

ROA_03611

RIL 3/6 (1)
3/2

DATE INVOICE AMOUNT

7310904483

WA

JES

V#90520801 DT50

EU76 STK JLR/GGC/P

CC2444 PC09370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES.

A06650-77

EDI

ORDER DATE

PAGE 2

FISHER CONTROLS COMPANY
 % ROBERT E MASON & CO
 P O BOX 33424
 CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 66-020560			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
2	1	EA	10A4225X012 RING, RETAINING, APPLICATION: FOR GLOBE VALVE SIZE 4 INCH TYPE ET, 6 INCH TYPE EWT, 6 INCH X 10 INCH TYPE ET AND EWT, 10 INCH X 16 INCH TYPE EWT, 14 INCH X 16 INCH TYPE EWT MANUFACTURER: FISHER PRODUCTS INC., PART NUMBER: 10A4225X012	25.20 EA
3	3	EA	RPACKX00032 KIT, MODIFIER: REPAIR, TYPE: GLOBE VALVE, APPLICATION: FOR FISHER GLOBE VALVE TYPE 657-AR SIZE 3 INCH DESIGN PRESSURE 300 PSI DESIGN TEMPERATURE 300 DEGREES FAHRENHEIT SOCKET WELD AIR OPERATED CAST STEEL MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: RPACKX00032	29.40 EA
4	2	EA	11A5229X042 ASSEMBLY, MODIFIER: PLUG STEM, TYPE: GLOBE VALVE, APPLICATION: FOR 3 INCH (CONT. ON PAGE 3)	980.00 EA

SHIPPING
TERMSCASH
TERMS***NOTICE TO SELLER**

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
 2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
 3. If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents.
- HOW ID NUMBERS ON BOXES AND INVOICES IS SHOWN ON THIS ORDER.
 THREE COPIES OF INVOICE, WITH FREIGHT BILL
 OR OTHER SHIPPING DOCUMENTS ATTACHED,
 ARE TO BE MAILED TO:

DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 P O BOX 1002
 CHARLOTTE NC 28201-1002

DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 R.F. SMITH
 General Manager, Purchases

ADDRESS
REPLY TO:

REV. 06/90

TELEX 57-2346 TELECOPIER: CUSTOMER GROUP (704) 373-3336
 POWER GROUP (704) 362-2298

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EU76 STK JLR/GGC/P

CC2444 PCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL
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A06650-77 **EDI**

ORDER DATE

PAGE 3

FISHER CONTROLS COMPANY
 Z ROBERT E. MASON & CO
 P O BOX 33424
 CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 55-020650			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER* BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
5	4	EA	GLOBE VALVE PART NUMBER: 11A5229X042 FISHER CONTROL MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: 11A5229X042 28A1010X022 2444261242 STEM, TYPE: FLOW CONTROL, SIZE: 4" APPLICATION: FOR FISHER VALVE 600 POUND WELD NECK SERIAL NUMBER 89B0427	661.00 EA
6	3	EA	MANUFACTURER: ROBERT E. MASON CO., PART NUMBER: 28A1010X022 1H849806992 254101840 O-RING	39 EA
7	12	EA	MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: 1H849806992 G1860301302 254102505 PACKING, RING, MATERIAL: TEFLON, APPLICATION: FOR 24 INCH BUTTERFLY VALVE TYPE 7640	260.60 EA

(CONT. ON PAGE 4)

SHIPPING TERMS	CASH TERMS

*NOTICE TO SELLER

ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
 Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
 If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents.
 Show ID numbers on boxes and invoices if shown on this order.
 FREE COPIES OF INVOICE, WITH FREIGHT BILL
 OTHER SHIPPING DOCUMENTS ATTACHED,
 ARE TO BE MAILED TO:

DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 PO BOX 1002
 CHARLOTTE NC 28201-1002

ADDRESS
REPLY TO:

DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 R.F. SMITH
 General Manager, Purchases

V.09/80

LEX 57-2346 TELECOM: CUSTOMER GROUP (704) 373-3336
 POWER GROUP (704) 382-2298

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V490520801 DT50

EU76 STK JLR/GGC/P

CC2444 PCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES.

A06650-77

EDI

ORDER DATE

PAGE 4

FISHER CONTROLS COMPANY
 Z ROBERT E MASON & CO
 P O BOX 33424
 CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 56-020550			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
8	2	EA	MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: G1860301302 G1860401302 254102508 PACKING, RING, MATERIAL: TEFLON, APPLICATION: FOR 24 INCH TYPE 7640 BUTTERFLY VALVE	26.60 EA
9	1	ST	MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: G1860401302 1R516201012 254201609 PACKING SET, APPLICATION: FOR BALL VALVE 18 INCH	54.60 ST
10	3	EA	MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: 1R516201012 1P927299102 254202253 GASKET, FLANGED FITTING, TYPE: SPIRAL WOUND, MATERIAL: 316 SS WITH ASBESTOS, SIZE: 3-9/16" ID X 4-5/16" OD X .125" THK, APPLICATION: FOR FISHER VEE-BALL VALVE U TYPE 10 INCH	9.45 EA
MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: 1P92729910 (CONT. ON PAGE 5)				

SHIPPING
TERMS.CASH
TERMS

*NOTICE TO SELLER

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
 2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
 3. If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents.
- How ID numbers on boxes and invoices if shown on this order.
 THREE COPIES OF INVOICE, WITH FREIGHT BILL
 OR OTHER SHIPPING DOCUMENTS ATTACHED,
 ARE TO BE MAILED TO:

DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 PO BOX 1002
 CHARLOTTE NC 28201-1002

ADDRESS
 REPLY TO:

DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 R.F. SMITH
 General Manager, Purchases

REV. 03/90

TELEX 67-2346 TELECOPIER: CUSTOMER GROUP (704) 373-3336
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ROA_03615

Rev: T U
By: JAG 12-11-72
Apvd: TRB 10-16-81
Page 1 of 1

CONFIDENTIAL

Revised By: NADH 6-23-91

12-6-91

This specification establishes a procedure for purchasing, handling and assembling packing materials, which must not contain more than 200 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel materials.

NRN's are listed in parenthesis under Section 6.

Items purchased to this specification must be tested for leachable chloride per ASTM D512. Each order must be certified that the requirements have been met.

Items must be packed in sealed plastic bags or envelopes which will prevent contamination and which are marked on the outside of the package to indicate that they have been specially processed. The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

Specially processed parts made to conform to this specification shall be handled in a manner that will maintain chloride content within specified limit when certification is required by customer specification.

The following packing materials can be certified to contain 200 ppm or less
leachable chlorides:

(a) Graphite Ribbon Die-formed (Grafoil GTA - INCAR Carbon Co.) (0199)

- (b) Graphite Ribbon Die-formed with internal passivating inhibitor
(Grofoil GTI - UCAR Carbon Co.) (Q11W)
- (c) Plastic, Molded PTFE FMS 17D7 (D18K)
- (e) Graphite Ribbon Die-formed with internal passivating inhibitor
(Grofoil GTI - UCAR Carbon Co.) certified for oxygen
service per FGS B-11 (Q11X)

FOR/N NO. _____ DATE _____
 BY WITH _____
 IN USE _____

✓	TELETYPE	✓	MAIL
✓	WIRE	✓	COD
✓	REGISTERED MAIL	✓	POSTAL ORDER

CHIEF OF BUREAU
 APPROVED _____
 SPECIAL AGENT IN CHARGE

DEC 10 1981
 Add new compound.

SPECIFICATION FOR LOW-CHLORIDE PACKING MATERIALS

Rev: (R) S
By: DJG 12-11-72
Apvd: TGB 10-16-01
Page 1 of 1

FISHER

CONFIDENTIAL

Officer Controls 1901, 1989 1991

Revised By: W H H 6-1-89

444 1-8-41

1. SCOPE

This specification establishes a procedure for purchasing, handling and assembling packing materials, which must not contain more than 200 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel materials.

2. MATERIAL REFERENCE NUMBERS

ADN's are listed in parenthesis under Section 5.

3. CERTIFICATION BY VENDOR

Items purchased to this specification must be tested for leachable chloride per ASTM D512. Each order must be certified that the requirements have been met.

4. PACKAGING BY VENDOR

Items must be packed in sealed plastic bags or envelopes which will prevent contamination and which are marked on the outside of the package to indicate that they have been specially processed. The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. HANDLING AND ASSEMBLY

Specially processed parts made to conform to this specification shall be handled in a manner that will maintain chloride content within specified limit when certification is required by customer specification.

6. APPROVED MATERIALS

The following packing materials can be certified to contain 200 PPM or less leachable chlorides:

Materials ~~delete~~ Die-formed

(a) Graphite (Molded) Ribbon (Grafoil GFA - Union Carbide) (0199)

(b) Plastic, Molded PTFE EHS 17D7 (010M)

JAN 15 1991

(b) Graphite Ribbon Die-formed with internal passivating inhibitor (Gratall GTI - Union Carbide) (all W)

MAJOR REVISION

ECR/H NO. _____ DATE _____
BY WHA CHUD DRB APVD NCR
C/O, OLD STOCK
1 - USE 1 - FIFTH 5 - SEVEN
2 - BHSOXX 2 - NINE 6 - ONE
3 - 5033-074 3 - 10-10-0000

Fisher Controls

Material Specification

FISHER

SPECIFICATION FOR
LOW-CHLORIDE PACKING MATERIALS

CONFIDENTIAL

©Fisher Controls 1981, 1987

No.	FMS 17D16
By	LLW 9-27-81
Apvd	ENTER 9-28-81
Page	2 of 2
Rev	2.7 2-12-81

(a) (c) Graphite Molded Ribbon (Grafoll - Union Carbide) (0199)

(d) Graphite Laminate FMS 17D19, Low Chloride FMS 17D16 (0188)

(e) Graphite Laminate/Zinc - High Density FMS 17D20 (019P)

(f) Graphite Laminate/Zinc - Medium Density FMS 17D23 (0191)

delete

(b) (g) Plastic, molded TFE FMS 17D7 (018A)

JAN 05 1988

MAJOR REVISION

ECN/NO.	A9440	DATE	
BY	PL7	CHG	WHH
APVD	NER		
1. DESIGN	2. MATERIAL	3. MANUFACTURE	4. TESTING
5. COST	6. SALES		

Deleted Graphite Laminate packings
Deleted page 2

Fisher Controls

Material Specification

FISHER

SPECIFICATION FOR
LOW-CHLORIDE PACKING MATERIALS

CONFIDENTIAL

No.	FMS 17016	
By	LLW	9-23-80
Appr.	Letter	9-25-80
Page	2 of	2
Rev	NRP	1-13-86

Fisher Controls 1981, 1986

- (b)(6) Graphite Laminate - High Density FMS-17018 (019H)
- (c)(d) Graphite Molded Ribbon (Grafoil - Union Carbide) (0199)
- (4)(e) Graphite Laminate FMS 17015, Low Chloride FMS 17016 (0188)
- (e)(f) Graphite Laminate/Zinc - High Density FMS 17020 (019P)
- (4)(g) Graphite Laminate/Zinc - Medium Density FMS 17023 (0191)
- (h) Graphite Filament, Crane 1625-GF, low chloride (018H) *delete*
- (a)(i) Plastic, molded TPE FMS 1707 (018H)

MAJOR REVISION FEB 27 1987

ECR/N NO.	DATE
BY <i>RL</i>	<i>NR</i>
1. <i>REVISION</i>	1. <i>11/77</i>
2. <i>REVISION</i>	2. <i>11/77</i>
3. <i>REVISION</i>	3. <i>11/77</i>
4. <i>REVISION</i>	4. <i>11/77</i>

Delete Graphite Fil. Wm, FMS 17019 (0190)
& Graphite Fil. Crane 1625-GF (018H)
Mat'l's. now covered by FMS 17019

Fisher Controls	Material Specification	No.	FMS-17016	7
FISHER	SPECIFICATION FOR LOW-CHLORIDE PACKING MATERIALS	By	LLW	9-23-80
		Appd	ETER	9-25-80
		Page	2	2
©Fisher Controls 1981, 1984		Rev	NRP	9-11-84

- (17) Graphite Laminate - High Density FMS-17018 (019H)
- (8) Graphite Molded Ribbon (Grafoil - Union Carbide) (0199)
- (9) Graphite Laminate FMS 17015, Low Chloride FMS 17016 (0188)
- (10) Graphite Laminate/Zinc - High Density FMS 17020 (019P)
- (11) Graphite Laminate/Zinc - Medium Density FMS 17023 (0191)
- (12) Graphite Filament, Crane 1625-GF, low chloride (018H)
- (1) Plastic, molded TFE FMS 1707 (018M)

CONFIDENTIAL

JAN 21 1986

MAJOR REVISION

ECR/IN NO. _____ DATE _____

BY NRP CHKD WHH APVD 4/82

NO. OLD STOCK	ADD. REASON	5. SLOTT
1. USE	1. SAFETY	6. COST
2. REMOVE	2. SIZE	7. MATE/
3. SUBMIT/NEW	3. IMPROVE	8. SLES
4. SCRAP ROW	4. ERROR	

ELIMINATE MATERIALS CONTAINING

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03620

 FISHER Controls MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. FMS 17D15 18
	SPECIFICATION FOR LOW-CHLORIDE PACKING MATERIALS		BY YKB 9-23-81
			APPROV. YKB
			PAGE 2 OF 2
			REV YKB 12-1-81

- (7) Graphite Laminate - High Density FMS-17D18 (019H)
- (8) Graphite Molded Ribbon (Grafoil - Union Carbide) (0199)
- (9) Graphite Laminate FMS 17D15, Low Chloride FMS 17D16 (018B)
- (10) Graphite Laminate/Zinc - High Density FMS 17D20 (019T)
- (11) Graphite Laminate/Zinc - Medium Density FMS 17D23 (019U)

CONFIDENTIAL

NOV 17 1982

MAJOR REVISION

BY **YKB** CHKD **YKB** APVD **YKB**

1 - USE	2 - SAFETY	3 - STOCK
4 - MACHINE	5 - MNT.	6 - COST
7 - SCRAP/HOG	8 - IMPROVE	9 - MKTG/SALES
10 - SCRAP/HOG	11 - ERROR	

Corrected error in mtl. not.
no. for FMS 17D23

© FISHER CONTROLS, 1981, 1982

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03622



MARSHALLTOWN, IOWA

MATERIAL SPECIFICATION

SPECIFICATION
FOR LOW-CHLORIDE PACKING MATERIALS

NO. FMS 17D16

BY *JKW* 9-27

APVD *JKW* 9-27

PAGE 2 OF 2

REV *JKW* 9-27

CONFIDENTIAL

Materials Continued:

- (10) Graphite Laminates/Zinc - High Density FMS 17D20 (019F)
- (11) Graphite Laminates/Zinc - Medium Density FMS 17D23 (019U)

MAJOR REVISION
BY *JKW* CHKD *JKW* APVD *TKB*
DATE: OCT 21 1981
BY *JKW* CHKD *JKW* APVD *TKB*
1 - BSI
2 - REMACHING
3 - SCRAPING
4 - SCRAP NOW
5 - BSA
6 - SAFETY
7 - MAIL
8 - IMPROVE
9 - L220R
10 - STICK
11 - COST
(change on page 1)

Continued on back (100)



MARSHALLTOWN, IOWA

MATERIAL SPECIFICATION

SPECIFICATION
FOR LOW-CHLORIDE PACKING MATERIALS

NO. FMS 17D16 J-10

ISSUED 12/13/72 bmc

REV. X/S 1-80-Y8

PAGE 1. OF 1

CONFIDENTIAL

1. Scope

This specification establishes a procedure for purchasing, handling and assembling packing materials, which must not contain more than 200 parts per million leachable chlorides.

2. Purpose of Requirement

Presumably the chloride content must be as low as practicable in components because of the danger of stress corrosion in stainless steel in the system.

3. Certification By Vendor

Items purchased to this specification must be tested for leachable chloride per ASTM D512-67. The items must also be manufactured, processed and packaged in a manner which will justify certification. Each order must be certified that the requirements have been met.

4. Packaging By Vendor

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

MAJOR REVISION

BY: [Signature] CHKD: [Signature] APVD: [Signature]

REV. REASON

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94. [Signature] 95. [Signature] 96. [Signature]

97. [Signature] 98. [Signature] 99. [Signature]

100. [Signature]

5. Handling and Assembly By Fisher

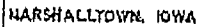
Specially processed parts made to conform to this specification shall be handled in a manner that will maintain chloride content within specified limit when certification is required by customer specification.

6. Materials

The following packing materials can be certified to contain 200 PPM or less leachable chlorides:

Materials

- (1) ASB-Inconel-Graphite, Crane 187-I, Low Chloride (0186)
- (2) ASB-Graphite, Crane 187-J, Low Chloride (0187)
- (3) ASB-TFE, Crane C-994, Low Chloride (0188)
- (4) ASB-Inconel-Graphite, Crane 177A1, Low Chloride (0189)
- (5) Graphite Filament Yarn, FMS 17D19 Low Chloride (0190)
- (6) Graphite Laminates/Zinc, FMS 17D17 (019A)
- (7) Graphite Laminates - High Density FMS-17D18 (019H)
- (8) Graphite Molded Ribbon (Grafell - Union Carbide) (0199)
- (9) Graphite Laminates FMS 17D15, Low Chloride FMS 17D16



SPECIFICATION
FOR LOW-CHLORIDE PACKING MATERIALS

ISSUED 12/11/72 DJG
REV. ~~WOT~~ 3-24-77
PAGE 1 OF 1

~~CONFIDENTIAL~~

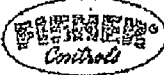
2

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4.5

⌞ ⌟ ⌠ ⌡ ⌢ ⌣

ROA 03625

 MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. FMS 17D16
	SPECIAL HANDLING SPECIFICATION FOR LOW-CHLORIDE PACKING MATERIALS		ISSUED 12/11/73
			REV. 12-15-71
			PAGE 1 OF 1

CONFIDENTIAL

1. Scope
This specification establishes a procedure for purchasing, handling and assembling packing materials, which must not contain more than 200 parts per million leachables chlorides.
2. Purpose of Requirement
Presumably the chloride content must be as low as practicable in components because of the danger of stress corrosion in stainless steel in the system.
3. Certification
Items purchased to this specification must be manufactured, processed and packaged in a manner which will justify certification by the supplier.
Each order must be certified that the requirements have been met.
4. Packaging
Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.
The sealed containers shall not be opened until ready for assembly in the appropriate assembly areas.
5. Assembly
Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.
6. Materials
The following packing materials can be certified to contain 200 PPM or less leachable chlorides:

ENGINEERING DEPT. 32811
 BY MAJOR R. J. CHODURA
 DISPOSITION OF OLD STOCK USE
 FMS 17D17 (0194)
 ADVISORY: SURFACES, RESIN, EPOXY
 PACK WITHOUT ZINC BRAG

- Materials
- (1) ASB-Inconel-Graphite, Crane 187-I, Low Chloride (0186)
 - (2) ASB-Graphite, Crane 187-J, Low Chloride (0187)
 - (3) ASB-TAN, Crane C-994, Low Chloride (0188)
 - (4) ASB-Inconel-Graphite, Crane 177A1, Low Chloride (0189)
FMS 17D19 - (ADD)
 - (5) Graphite Filament Yarn, Crane 1625-CP, Low Chloride or
CHEMPTO 2000 Low Chloride (0190)
- HIGH DENSITY - ADD
 - (6) Graphite Laminata/Zinc, FMS 17D17 (0194)
(7) GRAPHITE LAMINATE FMS 17D18 (0194) - ADD
 - (8) (9) Graphite Molded Ribbon (Grafoil - Union Carbide) (0199)

Fisher Controls

GRAPHITE LAMINATE (PACKING)

FISHER

CONFIDENTIAL

©Fisher Controls 1982, 1985

By RKB	4-3-69
App'd TKB	4-5-82
Page 1	of 1
Rev NRP	10-25-85

OBSOLETE

1. SCOPE

This specification covers laminated graphite materials used for high temperature valve stem packing applications.

2. MATERIAL REFERENCE NO. 0165 (standard)

0165 for less than 200 ppm leachable chloride - per FMS 17D16

3. COMPOSITION

- (a) All graphite composition
- (b) Density 70 lbs./cu. ft.
- (c) Laminations perpendicular to shaft

4. APPROVED SOURCE(S)

- (a) Union Carbide Corporation
Carbon Products Div.
Trade Name - Grafoil

OBSOLETE
SUPERSEDED BY

FMS 17D17

MRN 0165

MAJOR REVISION JAN 05 1988

ECR/IN NO. 49440	DATE
BY R17	CHKD WHM
APVD NRP	
1. ☒ RISE	2. ☒ SAFETY
3. ☒ RETURN	4. ☒ COST
5. ☒ SCRAP/NEW	6. ☒ IMPROVE
7. ☒ SCRAP NOW	8. ☒ SALES

obsolete

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03627

ISSUED AFB 1-8-6
REV.
PAGE 1 OF 1

GRAPHITE LAMINATE (PACKING)

CONFIDENTIAL

All Graphite Pecking

Density 70 lb/cu ft

Laminations Perpendicular to Shaft

Approved Source

Union Carbide Corporation
Carbon Products Division
Trade Name - Gruboil
Catalog No. 65300

1. 350PE

This specification covers laminated graphite materials used for high temperature valve stem packing applications.

2. MATERIAL REFERENCE NO. 0145

3. COMPOSITION

- (a) All graphitic composition
- (b) Density 70 lb./cu. ft.
- (c) Laminations perpendicular to shaft

4. APPROVED SOURCE(S)

- (9) Union Carbide Corporation
Carbon Products Div.
Trade Name - Grafoil

APR : 4 1982

MAJOR REVISION

BY ~~XXXXXXXXXX~~ ~~XXXXXXXXXX~~ ~~XXXXXXXXXX~~
BRO. OLD STOCK ~~XXXXXXXXXX~~ BRO. REASON
1 - ~~XXXXXXXXXX~~ 1 - SAFETY 5 - STICK
2 - ~~XXXXXXXXXX~~ 1 - MAIL 6 - COST
3 - ~~XXXXXXXXXX~~ 1 - INTERVIEW 1 - ~~XXXXXXXXXX~~
4 - ~~XXXXXXXXXX~~ 1 - ~~XXXXXXXXXX~~ 1 - ~~XXXXXXXXXX~~
Update to new for

© Fisher Controls 1984.

TAYLOR V. 3.M. COMPANY ET AL.

ROA 03628

Fisher Controls

Material Specification

FMS 17D14

GLASS FILLED PTFE PACKING

Rev: P. G.

By: LIA 3-11-66

App'd: TXS 1-25-62

Page 1 of 1

FISHER**CONFIDENTIAL***Fisher Controls 1902, 1990 1991Revised By: WHH 11-28-90

12-15-91

1. SCOPE

This specification covers glass filled PTFE compounds used as V-ring type valve stem packing, and piston rings, valve discs, ball seats and gaskets.

2. MATERIAL REFERENCE NOS.

- 0120 - Standard
- 015W - Special - yellow color
- 0117 - Special - green color

3. COMPOSITION

virgin

V-Ring packing compound of PTFE (polytetrafluoroethylene) filled with 15 to 25 weight percent glass fibers and inorganic coloring.

4. TEMPERATURE RANGE

0°F TO +450°F

5. APPROVED SOURCE(S)

- (a) John Crane International
Morton Grove, IL
Style No. 74-86 (251)
- (b) United Polymer, Inc.
Houston, TX
Style No. Fluorogreen E110

JAN 20 1992

MAJOR REVISION

ECR/N NO.	DATE
BY WHH CHKD PGB APVD <u>APVD</u>	
240, OLD STOCK	
1 - MUSE	1 - SAFETY
2 - RING	2 - MATH
3 - SCRAP/REIN	3 - IMPROVE
4 - SCRAP ROW	4 - EXHIB
	5 - STOCK
	6 - COST
	7 - MKTG/SALES

Add other applications since these MEN's are used for parts other than packing.

Fisher Controls	Material Specification	No. FMS 17014	①
FISHER	GLASS FILLED PTFE PACKING CONFIDENTIAL	By LLS	3-11-66
		Appr. TKB	1-25-67
		Page 1	of 1
Fisher Controls 1982, 1987		Rev WHH	4-15-87

1989

1. SCOPE

This specification covers glass filled PTFE compounds used as V-ring type valve stem packing and piston rings.

2. MATERIAL REFERENCE NOS. 0120 (Standard)

0120 - standard
019W special - yellow color
0117 special - green color

3. COMPOSITION

V-ring packing compound of PTFE (polytetrafluoroethylene) filled with 15 to 25 weight percent glass fibers and inorganic coloring.

4. TEMPERATURE RANGE

0° F to + 450° F

5. APPROVED SOURCE(S)

(a) Crane Packing Co.,
Morton Grove, IL.
Style No. 74-06 (25%)

(b) United Polymer, Inc.,
Houston, TX
Style No. Fluorogreen E110

MAJOR REVISION

ECN/IN NO.	DATE JUN 15 1989
BY WHH	CHRO DRS APVD NFR
CHD, GID, TROCK	330. DESIGN
1 X USE	1 SAFETY
2 REMARK	2 PLATC
3 SCRAP/REIN	3 IMPROVE
4 SCRAP KTH	4 ERROR
	5 ERROR
	6 COST
	7 HEMI/
	8 SALS

Add source and special MRN
for green colored parts.



MATERIAL SPECIFICATION

GLASS FILLED TFE PACKING

NO. FMS 17014

BY *WCB* 5-11-66

APPROVED *WCB* 1-2-67

PAGE 1 OF 1

REV *2/1/67* 1-20-66

CONFIDENTIAL

1. SCOPE

This specification covers glass filled TFE compounds used as V-ring type valve stem packing and piston rings.

2. MATERIAL REFERENCE NO. 0120 (standard)

019W special - yellow color

3. COMPOSITION

V-ring packing compound of TFE resin (polytetrafluoroethylene) filled with 15 to 25 weight percent glass fibers.

4. APPROVED SOURCE

Crano Packing Co.
Morton Grove, IL.
Style No. 74-06 (25%)

OCT 30 1985

MAJOR REVISION

ECR/NO. <i>N/A</i>	DATE <i>N/A</i>	
BY <i>NRP</i>	CHKD <i>WCB</i> APVD <i>N/A</i>	
840. OLD SPEC	830. REASON	
1 - COST	1 - SAFETY	5 - STRENGTH
2 - DESIGN	2 - MATERIAL	6 - COST
3 - SCRAP/RECY	3 - IMPROV	7 - MATERIAL
4 - SCRAP HOW	4 - OTHER	8 - OTHER

© FISHER CONTROLS, 1982

ADD MAT'L REF. NO. *1* PUT IN
NEW FORM

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03631

Fisher Controls

Material Specification

FMS 17D13

LOW PROFILE PTFE PACKING

Rev: **16**
By: ELB 1-11-66
Apvd: TKB 1-25-82
Page 1 of 1

FISHER

CONFIDENTIAL

*Fisher Controls 1982, 1991

Revised By: WBI 12-13-91

1. SCOPE

This specification covers virgin PTFE, low profile, V-ring products used as valve stem packing.

2. MATERIAL REFERENCE NOS.

- (a) 0119
- (b) 0176 for oxygen service clean and handle per ICS 8A11

3. COMPOSITION

Molded, coined, or machined virgin PTFE ((polytetrafluoroethylene) in a low profile V-ring configuration.

4. TEMPERATURE RANGE

-40°F to +450°F

5. APPROVED SOURCE(S)

- (a) John Crane International
Morton Grove, IL
Style No. 774 (machined)
or Style No. 775 (memorized or coined)
- (b) Garlock, Plastics Div.
Condon, NJ
"Molded PTFE V Packing"
- (c) Norton Performance Plastics
Elk Grove, IL
Style No. 600

MAJOR REVISION 5-27-77

ECRN No. 961398 Date: 7/1/98

By HLH chkd PMO Apvd TKB

640, Old Stock	SW, Reason
1. VDR	1. SAFETY 5. ST02N
2. REMARK	2. MATL 6. COST
3. SCRAP NEW	3. IMPROVE 7. MKTG
4. SCRAP NOW	4. FINISH 8. SALES

Updated to the new electronic format.
Any changes to appearance, paragraph numbering, etc., were to accommodate the new document format style. The appearance of the document will not be the same as before. NO CHANGES TO CONTENT.

AUG 5 - 1997

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03632

Fisher Controls

Material Specification

FMS 17D13

FISHER

LOW PROFILE PTFE V-RING PACKING

CONFIDENTIAL

1990

©Fisher Controls 1982

1987

By C.L.B. 3-11-66

Apvd rkb 1-25-82

Page 1 of 1

Rev WHH (1-15-87)

11-28-90

1. SCOPE

This specification covers virgin PTFE, low profile, V-ring products used as valve stem packing.

2. MATERIAL REFERENCE NOS.

(a) 0119

(b) 0126 for oxygen service clean and handle per FGS BAIL.

3. COMPOSITION

Molded, coined, or machined virgin PTFE (polytetrafluoroethylene) in a low profile V-ring configuration.

4. TEMPERATURE RANGE

-40° F to +450° F

5. APPROVED SOURCES

(a) Crane Packing Co. John Crane International
Morton Grove, IL
Style No. 774 (machined)
or Style No. 775 (Memorized or coined)

(b) Garlock Plastics Div.
Camden, N.J.
"Molded PTFE V Packing"

(c) Halogen Insulator & Seal Co. Norton Performance Plastics
Elk Grove, IL
Style No. 600

DEC 14 1990

MAJOR REVISION

ECR/A NO.	DATE
BY WHH	CHKD RJF
APVD NFR	
FOR DEL STOCK	FOR REVISION
1. DESIGN	1. SAFETY
2. MATERIAL	2. MAIL
3. ADAP/REV	3. IMPROVE
4. CHANGE	4. CHECK
	1. BUDG
	2. COST
	3. MATE
	4. SALES

Update names of vendors.

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03633

 MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. FMS 17013
	LOW PROFILE TFE V-RING PACKING		BY <u>WFD</u> DATE <u>2-11-66</u>
			APPROVED BY <u>TKB</u> DATE <u>1-25-62</u>
			PAGE 1 OF 1
			REV <u>3-10-67</u> DATE <u>1-20-62</u>
CONFIDENTIAL			NRP 4-17-85

1. SCOPE

This specification covers virgin TFE, low profile, V-ring products used as valve stem packing.

2. MATERIAL REFERENCE NOS 0119 ~~delete~~

(a) 0119

(b) 0176 for oxygen service. (clean and handle per FGS BA11).

3. COMPOSITION

Molded, coined, or machined virgin TFE (polytetrafluoroethylene) in a low profile V-ring configuration.

4. APPROVED SOURCES

(a) Crane Packing Co.
Morton Grove, IL
Style No. 774 (machined)
or Style No. 773 (memorized or coined)

(b) Garlock Plastics Div.
Camden, N.J.
"Molded TFE V Packing"

(c) Halogen Insulator & Seal Co.
Elk Grove, IL
Style No. 608

APR 29 1966

MAJOR REVISION

BY NRE CHKD WFD APVD NRP

1 - OLD STOCK	2 - REWORK	3 - SCRAP/NEW	4 - SCRAP NOW	5 - SAFETY	6 - COST	7 - MATEL	8 - IMPROVE	9 - ERROR	10 - SERVICE

ADD 2ND MAT'L REF NO. FOR Q. SERVICE.
REFERENCE FGS BA11

© FISHER CONTROLS, 1962, 1985

FISHER

GLASS FILLED PTFE PACKING

CONFIDENTIAL

©Fisher Controls 1982, (1987) 1987

BY JMT	6-14-83
App'd TMB	2-18-82
Page 1	of 1
Rev W/H	4-15-87

1. SCOPE

This specification covers glass fiber reinforced PTFE V-ring products used as valve stem packing.

2. MATERIAL REFERENCE NO. 0117

3. COMPOSITION

V-ring packing made of PTFE (polytetrafluoroethylene), 15-20% glass fibers, compound and inorganic coloring.

4. TEMPERATURE RANGE

0° F to + 450° F

5. APPROVED SOURCE

EPSCO, Inc.
(Div. of Peabody Dore)
Houston, TX
Style: Fluorogreen E110

MAJOR REVISION

ECR/N NO.	DATE
BY <i>W/H</i>	<i>7-14-87</i>
CHG. BY <i>W/H</i>	<i>7-14-87</i>
1 - <i>W/H</i>	<i>7-14-87</i>
2 - <i>W/H</i>	<i>7-14-87</i>
3 - <i>W/H</i>	<i>7-14-87</i>
4 - <i>W/H</i>	<i>7-14-87</i>
5 - <i>W/H</i>	<i>7-14-87</i>
6 - <i>W/H</i>	<i>7-14-87</i>
7 - <i>W/H</i>	<i>7-14-87</i>
8 - <i>W/H</i>	<i>7-14-87</i>
9 - <i>W/H</i>	<i>7-14-87</i>
10 - <i>W/H</i>	<i>7-14-87</i>

MAY 31 1989

Obsolete - superseded by
FMS 17014

FISHER®
OVERNOR CO.
ISHALLTOWN, IOWA
USA

GLASS FILLED TFE PACKING
JOHN L. DORE' E110 ONLY

ISSUED JMT 6-14-63
REV. CRB 5-15-65
PAGE 1 OF 1

CONFIDENTIAL

1. SCOPE

This specification covers glass fiber reinforced TFE V-ring products used as valve stem packing.

2. MATERIAL REFERENCE NO. D117

3. COMPOSITION

V-ring packing made of TFE resin (polytetrafluoroethylene), 15-20% glass fibers, compound and inorganic coloring

V-Ring Packing Made Of TFE Resin,
Glass Fibers, Compound, and
Inorganic Coloring

4. APPROVED SOURCE

EPSCO, Inc.
(Div. of Peabody Dore')
Houston, TX.
Style: Fluorogreen No. E110

Approved Materials

John L. Dore' Fluorogreen No. E110

FEB 23 1982

MAJOR REVISION
BY CHKO WMT APVD TKD
140. OLD STOCK 140. REASON 1 - STOCK
12. USE 1 - SATIS 1 - COST
2 - REWORK 2 - WAT 1 - WAT
3 - SCRAP/NEW 3 - IMPROV 1 - WAT
1 - WAT 1 - IMPROV 1 - WAT

Update to current specs.
and format.

TAYLOR V. 3.M. COMPANY ET AL.
E10120 000520

ROA_03636

OBSOLETE

TFE impregnated asbestos rings for oxygen service

Specify: TFE Asbestos - FMS 17D11

The packing material covered by this specification is intended for use with liquid or gaseous oxygen and must meet the following specifications:

1. Must not contain organic matter, dirt or oil.
2. Supplier must furnish with tag certifying cleanliness, viz: "This packing is clean, free from oil, and is suitable for oxygen service."
Signed _____ Inspector.

Approved Material

Martin Markel, Inc.
Cleveland, Ohio 44139
Style: Union #5712

MAJOR REVISION APR 22 1967

ECR/N NO. _____ DATE _____
BY WJH CHKD DRB APVD WJH
B60, OLD STOCK B30, REASON
1. USE 1. SAFETY 8. STOLN
2. REWORK 2. SMALL 6. COST
3. SCRAP/VIEW 3. IMPROVE 7. MKTG/
4. SCRAP NOW 4. ERROR 8. SALES

until 7-6-67
then scrap

Obsolete, see none
Asbestos elimination program

© FISHER CONTROLS, 1991, 1995

Asbestos - TFE in Packing For Oxygen Service

SIZE TYPE

FISHER GOVERNOR CO. MARSHALLTOWN, IOWA		BY	DATE	FILE	SUPERSEDES	DESIGN	REV
		DWN	J.R.	4-28-61	SCALE		
		CHD	WJH	4-28-61			

INACTIVE

Packing To Be Square Braided Blue African
Asbestos Impregnated With TFE And Furnished
In Ring Form With Bavel Joint. Packing must
be free of excessive graphite and dirt.

The Following Materials Have Been Approved:

Johns-Manville Style No. 2014

Garlock, Inc. No. 5561

INACTIVE

SEP 21 1982

MAJOR REVISION
BY RED CHKD GR APVD GP DATE
NO. OLD STOCK 247-56 REASON
1 ☒ USE 1 ☐ SAFETY 3 ☐ STDS
2 ☐ REWORK 2 ☐ MATL 6 ☐ COST
3 ☐ SCRAP/NEW 3 ☒ IMPROVE
4 ☐ SCRAP NOW 4 ☐ ERROR

*Make inactive - no longer
needed.*

© Fisher Controls 1982

TITLE Blue African Asbestos- TFE Packing				TYPE																			
<table border="1"> <tr> <td>DATE</td> <td>BY</td> <td>CHKD</td> <td>DATE</td> </tr> <tr> <td>2-15-85</td> <td>ERB</td> <td>WPS</td> <td></td> </tr> <tr> <td>6-23-81</td> <td>IRB</td> <td>WPS</td> <td></td> </tr> </table>				DATE	BY	CHKD	DATE	2-15-85	ERB	WPS		6-23-81	IRB	WPS		<table border="1"> <tr> <td>DESIGN NO.</td> <td></td> </tr> <tr> <td>DRAWER NO.</td> <td></td> </tr> <tr> <td>SUPERSEDED NO.</td> <td></td> </tr> </table>		DESIGN NO.		DRAWER NO.		SUPERSEDED NO.	
DATE	BY	CHKD	DATE																				
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SUPERSEDED NO.																							
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TRGD.																							
CHKD.	HGR	247-56																					
APPR.																							
SIZE	INACTIVE D																						
REV.	DIO																						
<table border="1"> <tr> <td>REVISIONS</td> <td>SCALE</td> </tr> <tr> <td></td> <td></td> </tr> </table>				REVISIONS	SCALE			<table border="1"> <tr> <td>FISHER</td> </tr> <tr> <td>GOVERNOR CO.</td> </tr> <tr> <td>MARSHALLTOWN, IOWA</td> </tr> </table>		FISHER	GOVERNOR CO.	MARSHALLTOWN, IOWA											
REVISIONS	SCALE																						
FISHER																							
GOVERNOR CO.																							
MARSHALLTOWN, IOWA																							

TAYLOR V. 3.M. COMPANY ET AL.
FIGURED 000500

ROA_03638

CONFIDENTIAL

Packing shall consist of two types of rings.

Plastic Rings: Use to fill space between metallic rings to give proper packing depth. Plastic rings shall consist of pure, long asbestos fibres and aluminum shreds lubricated.

Metallic Rings

Plastic Rings

Durametallic Style D-222 or D-2 (Bulk alternate)

PAGE TWO
FROM HQ DATE 4-15-68
BY NRP
X X X
REPRODUCTION & ELIMINATE
ASPECT

		TITLE		High Temperature Packing		REVISED		TYPE	
		BY	DATE	FISHER ® GOVERNOR CO. MARSHALLTOWN, IOWA		DESIGN NO.		SIZE	
		DWG. NO.	4-11-55			DRAWER NO.		B 1709	
		TRD.							
		DWG. NO.	WMP 4-11-55						
DATE	BY	CHKD.	APP.	SUPERSEDES DWG. NO.		DWG. NO.		FMS 1709	
REVISIONS		SCALE							

Fisher Controls

Material Specification

No. FMS 17D8

H
G

TFE ASBESTOS - PACKING

FISHER

By MMP B-12-54

APVD TKB 2-18-82

Page 1 of 1

©Fisher Controls 1982, 1985

Rev
NRP 10-30-85**OBsolete**1. SCOPE

This specification covers square braided asbestos valve stem packing impregnated with TFE (polytetrafluoroethylene).

2. MATERIAL REFERENCE NO. 01043. COMPOSITION

Square braided asbestos impregnated with TFE and furnished in ring form with bevel joint.

3.1 Packing should be reasonably clean and free from graphite. Not for oxygen service.

3.2 Note: For oxygen service specify FMS 17D11

4. APPROVED SOURCE

(a) Argo Packing Co.
P.O. Box 66
Oakmont, PA. 15139
Style No. 715

(b) Martin Merkel Packings and Seals, Inc.
5375 Naiman Parkway, Suite B
Cleveland, OH. 44139
Style No. 5741

MAJOR REVISION APR 22 1987

EGR/N NO. _____ DATE _____
BY WHA CHKD **DRB** APVD **NPK**
840. OLD STOCK 1. USE 2. REWORK 3. SCRAP/NEW 4. SCRAP NOW
1. SAFETY 2. 2X MATL 3. IMPROVE 4. FRRDR
5. STDN 6. COST 7. MKTG/SALES
until 4-30-87 then scrap
Obsolete, see FMS 17D26
Asbestos elimination program

FMS3-27/1

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03640

Fisher Controls

Material Specification

FMS 1707

PTFE RING PACKING

FISHER**CONFIDENTIAL**
 Rev: 4 M
 By: HRP 5-17-50
 Apvd: PLP 5-14-76
 Page 1 of 1
Fisher Controls 1982, 1987 1991
 Revised By: W/H 1-14-89
 WITH 4-30-91
1. SCOPE

This specification covers virgin PTFE V-Ring products used as valve stem packing.

2. MATERIAL REFERENCE NOS.

- (a) 0101
- (b) 0111 for oxygen service, clean and handle per FGS 8A11
- (c) 010M for less than 200 ppm leachable chloride per FMS 17D16

3. COMPOSITION

Molded or machined plastic V-ring packing made of unfilled virgin PTFE (polytetrafluoroethylene), such as DuPont's Teflon 88. Material should comply with FDA regulations. *small s*

4. TEMPERATURE RANGE

-10°F to +450°F

5. APPROVED SOURCES

- (a) Crane Packing Co. John Crane International
Morton Grove, IL
Style Nos. Gummion C-VU or C-VH (High Pressure)
- (b) Chicago Basket Co.
Chicago, IL
Style No., VZQ-CWJ
- (c) Halogen Insulator & Seal Co. Norton Performance Plastics
Bik Grove, IL
Style No. 100 CVU
- (d) Argo Packing Co.
Oakmont, PA
(To be used only on rotary valve products with shafts over 2" diameter.)
- (e) Garlock-Mechanical Packing Div.
Sodus, NY
Style No. 7500

MAJOR REVISION

ECR/N NO. 111 CHKD 208 DATE 1/14/89
 BY W/H APVD NFB
 ENCLD STICK 1 REASON 1 SAFETY 5 STOSH
 1. X USE 2 MATL 6 CUST
 2. REMARK 3 SUPP/PROZ 7 MKTG/
 3. SCRAP/REV 4 ERROR 8 SALES
 4. SCRAP/REV

Update vendor names

MAY 02 1991

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03641

Fisher Controls

Material Specification

FMS 1707

PTFE RING PACKING

Rev: ① K
By: RHP 5-17-50
Apvd: RHP 5-14-76
Page 1 of 1

FISHER

CONFIDENTIAL

Fisher Controls 1902, 1988

Revised By: WHH 2-17-88

1. SCOPE

This specification covers virgin PTFE V-Ring products used as valve stem packing.

2. MATERIAL REFERENCE NOS.

- (a) 0101
- (b) 0111 for oxygen service, clean and handle per FGS B111
- (c) 018M for less than 200 ppm leachable chloride per FMS 17016

3. COMPOSITION

Molded or machined plastic V-ring packing made of unfilled virgin PTFE (polytetrafluoroethylene).

4. TEMPERATURE RANGE

-10°F to +450°F

5. APPROVED SOURCES

(lower one) (A) Crane Packing Co.
Morton Grove, IL
Style Nos. Chemlon C-VU or C-VH (High Pressure)

(b) Chicago Gasket Co.
Chicago, IL
Style No., V20-CVU

(c) Halogen Insulator & Seal Co.
Elk Grove, IL
Style No. 100 CVU

(d) Argo Packing Co.
Ontario, PA

(To be used only on rotary valve products with shafts over 2" diameter.)

APR 11 1988

MAJOR REVISION

REV. NO.	DATE
BY WHH	CRKD JL G-APVD NFR
1. RHP	5-17-50
2. RHP	5-14-76
3. WHH	2-17-88

Add additional source,
correct type.

TAYLOR V. S.M. COMPANY ET AL.

ROA_03642

Fisher Controls

Material Specification

FMS 1707

PTFE MOLDED RING PACKING

Rev: ^H
 By: RHP 5-17-80
 Appd: PLT 8-14-76
 Page 1 of 1

FISHER**CONFIDENTIAL**

Fisher Controls 1902, 1987

Revised By: W H H 9-15-87

1. SCOPE

This specification covers virgin PTFE V-Ring products used as valve stem packing.

2. MATERIAL REFERENCE NOS.

- (a) 0101
- (b) 0111 for oxygen service, clean and handle per FMS 6A11
- (c) 010M for less than 200 ppm leachable chloride per FMS 17D16

3. COMPOSITION

Molded plastic V-ring packing made of unfilled virgin PTFE (polytetrafluoroethylene).

4. TEMPERATURE RANGE

-40°F to +450°F

5. APPROVED SOURCES

- (A) Crane Packing Co.
Morton Grove, IL
Style No. 772-SV
Style: Chemlon C-VH (High Pressure)
- (b) Chicago Gasket Co.
Chicago, IL
Style No. V20-CWU
- (c) Halogen Insulator & Seal Co.
Elk Grove, IL
Style No. 100 CWU

Style Nos.
Chemlon CVU or CWU
(high pressure)

DEC 04 1987

MAJOR REVISION

ECR/R NO.	DATE
BY W H H	CHKD DEB
APVD NEG	
1 - USE	1 - SAFETY
2 - REVIEW	2 - FUEL
3 - SCRAP REVIEW	3 - SHIP/DROVE
4 - SCRAP NOS	4 - ERROR
	5 - 42028
	6 - 5051
	7 - 41747
	8 - 5415

Make correction to material designation

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03643

Fisher Controls

Material Specification

NO. FMS 1707 **E****FISHER**

PTFE MOLDED RING PACKING

CONFIDENTIAL

By MHP 5-17-51

App'd PLT 5-14-51

Page 1 of 1

©Fisher Controls 1982, 1986

Rev NRP 1-13-81

1. SCOPE

PTFE

This specification covers virgin **PTFE** V-ring products used as Valve stem packing.2. MATERIAL REFERENCE NOS.

(a) 0101

(b) 0111 for oxygen service, clean and handle per FGS 8A11

(c) 018M for less than 200 ppm leachable chloride per FMS 17D16

3. COMPOSITIONMolded plastic V-ring packing made of unfilled virgin **PTFE resin** PTFE (polytetrafluoroethylene).4. APPROVED SOURCES

S.

(a) Crane Packing Co.
Horton Grove, IL
Style No. 772-SV(b) Chicago Gasket Co.
Chicago, IL
Style No. V20-CVU(c) Halogen Insulator & Seal Co.
Elk Grove, IL
Style No. 100 CVU

FMSJ-36/1

5. TEMPERATURE RANGE

-40°F to +450°F

MAJOR REVISION APR 22 1987

ECR/NO. BY WJH CHKD DRB APVD NRP

800. OLD EPOCH	810. DESIGN	820. DRAWING
1. DISE	7. SEVEN	6. SIXTH
2. DESIGN	7. HAT	6. COSA
3. DESIGN/PROV	3. HAT/PROV	7. HAT/PROV
4. DESIGN/PROV	4. HAT/PROV	7. HAT/PROV

Standardize mod'l. description
Add temp. range

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03644

Fisher Controls

Material Specification

No. FMS 17D5

D

GRAPHITED ASBESTOS PACKING

By GFB

4-7-49

App'd TRB

1-25-50

Page

1 of 1

FISHER

CONFIDENTIAL

© Fisher Controls 1962, 1987

Rev

WNH 4-15-87

1. SCOPE

OBsolete

This specification covers a graphited asbestos compound for use as valve stem packing.

2. MATERIAL REFERENCE NO. 0106

3. COMPOSITION

Molded or die formed ring packing made of asbestos fiber, graphite and treated with a surface lubricant in braided jacket over core construction.

4. APPROVED SOURCE

Argo Packing Co.
P.O. Box 66
Dakmont, PA. 18139
Style No. 600

OBsolete REVISION
FMS 17D28

INACTIVE

CONFIDENTIAL

Packing shall be made from high grade Canadian white asbestos. The string shall be formed by twisting together lubricated single strands of asbestos.

Diameter of the packing shall be specified by the Fisher Governor Company.

The packing shall be suitable for use with air, hot water and steam up to 600°F.

The following materials have been approved:

1. Palmetto String Packing - Greene, Tweed & Company

INACTIVE BY 8849K

String Packing For Air, Hot Water & Steam				SIZE	TYPE
FISHER® GOVERNOR CO. MARSHALLTOWN, IOWA		BY HRJ	DATE 10-6-48	FILE SCALE	SUPERSEDES DESIGN
		CHKD 10-11-48	6-22-59	DWG. NO. EMLS1ZD4	
		REV. B			

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03647

CONFIDENTIAL

PACKING SHALL BE MADE FROM LONG FIBRE ASBESTOS YARN BY THE
BRAID OVER BRAID METHOD. PACKING IS TO BE LUBRICATED AND
GRAPHITED. FINISHED PRODUCT SHALL BE RESISTANT TO STEAM,
WEAK ACIDS, GAS, LYE AND CAUSTICS.

PACKING SHALL BE FURNISHED IN ROPE FORM.

THE FOLLOWING MATERIALS HAVE BEEN APPROVED:

1. GARLOCK NO. 233 (COIL FORM).

INACTIVE BY 8-22-88

TITLE: BRAIDED ROPE PACKING - FOR STEAM, WEAK ACID, GAS, LYE OR CAUSTIC SODA.				TYPE	
BY DATE OWN 8/10/43				DESIGN NO.	
DATE BY CHKD. TRCP.				SIZE	
REVISIONS				DRAWING NO.	
CHKD.				DRAWING NO.	
APPR.				FILE NO.	
SCALE				FMS 1703	

FISHER
GOVERNOR CO.
MARSHALLTOWN, IOWA

ALL DIMENSIONS ARE IN INCHES

FOR INFORMATION OF THE USER, THE FOLLOWING INFORMATION IS FURNISHED:

TAYLOR V. S.M. COMPANY ET AL.

ROA_03648

CONFIDENTIAL

FORMED PACKING TO BE MADE OF METAL PARTICLES, OIL-PROOF
BINDER, LONG FIBRE ASBESTOS AND MUST BE SUITABLE FOR USE
ON OILS AND PETROLEUM DISTILLATES AT TEMPERATURES UP TO
650°F.

THE FOLLOWING MATERIALS HAVE BEEN APPROVED:

1. JOHN CRANE SUPER-SEAL NO. 3.

				TITLE FORM PACKING-LONG FIBRE ASBESTOS, OIL-PROOF BOUND		TYPE	
				BY DATE		DESIGN NO.	
		DWN. 10-6-43				SIZE	
DATE	BY	CHKD.	TRCD.	FISHER GOVERNOR CO. MARSHALLTOWN, IOWA		DRAWN BY	
REVISIONS		CHKD.				FILE NO.	
SUPERSEDES		APPR.				DWG. NO.	
DWN. NO. FMSBAI		SCALE				FMSITD.	

CONFIDENTIAL

Material shall be compounded of cork particles and fibre compressed into sheet form. The sheet must have high compressibility, resilience, and tensile strength, and good flexibility.

The following materials have been approved:

1. Vellumoid No. 444 (Federal-Mogul)

DEC 21 1963

FIGURE 1
VIEW 1
VIEW 2
VIEW 3
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VIEW 6
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VIEW 100

MONTHLY REVIEW - PUT IN NEXT
FORMAT - CORRECTED

Cork Sheet Compounded Cord & Fibre Sheet				SIZE	TYPE COMPANY NAME
FISHER* GOVERNOR CO. MARSHALLTOWN, IOWA	BY	DATE	FILE	SUPERSEDES	DWG. NO. FMS17B1
	DWN	10-6-43	SCALE	DESIGN	
CHRD	6-12-59				

Fisher Controls

Document Cover Sheet

FMS 17A6

FLAT SHEET COMPOSITION GASKET MATERIAL

Rev:

By: WMB 10-14-85

Apvd: NFR 10-14-85

Page 1

FISHER**CONFIDENTIAL**

Fisher Controls 1985, 1992

Revised By: WMB 4-30-92

This page is the cover sheet of all documents containing 3 or more pages of specifications. The table below shows the revision level for each page of this document. A revision of this page will be made when any page of this document is revised. When referring to this document specify the revision level of this page.

PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL

1

2

3

4

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4

MAJOR REVISION 5-27-91

AUG 5 - 1997

ECRN No. 941378 Date 5-27-91
 By HLH Chkd PHD Apvd TAG
 040, Old Stock 030, Revision
 1. USE 1. SAFETY 5. STOZN
 2. REWORK 2. MATL 6. COST
 3. SCRAP NEW 3. IMPROVE 7. JAKTO/
 4. SCRAP NOW 4. ERROR 8. SALES

Updated to the new electronic format.
 Any changes to appearance, paragraph
 numbering, etc., were to accommodate
 the new document format style. The
 appearance of the document will not be
 the same as before. NO CHANGES TO
 CONTENT.

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03651

Fisher Controls

Material Specification

FMS 17A6

FLAT SHEET COMPOSITION GASKET MATERIAL
(CLOSE TOLERANCE)

Rev: 004

By: WMI 10-14-85

Apvd: NFR 10-14-85

Page 1-2-2 (cont)

FISHER

ADD COVER PAGE

*Fisher Controls 1985, (1991) 1992

Revised By: WMI 10-10-91

CONFIDENTIAL

4-30-92

1. SCOPE

- 1.1 This specification covers elastomer bound high temperature organic and/or inorganic fiber based flat sheet gasket materials. These materials are used for general purpose gasketing and are designed to replace similar asbestos based gasket materials. They are typically used to seal against oils, water, steam, air, natural gas and many other fluids and gases.

1.2 INCLUDED REFERENCES

2. MATERIAL REFERENCE NO. 0465 (or 0467 for low chloride per FMS 17F30)

see

see page 2

3. MATERIAL COMPOSITION

The material shall be composed of high temperature organic and inorganic fibers with nitrile elastomeric binder. Some inorganic filler may be used as long as the resulting sheet material meets the physical properties listed in Table 1. The material should contain no asbestos or cellulose fiber. The thickness and thickness tolerance of the gasket material shall be $0.031 \pm .003$ inches.

4. SERVICE TEMPERATURE

The material shall not deteriorate and shall function properly in the designated service at temperatures up to $+302^{\circ}\text{F}$ (or 150°C).

5. QUALIFICATION TESTING

Fisher Controls shall perform the qualification tests listed in Table 1 prior to approval under this specification. Following approval, the vendor of such material shall make no changes in the product without notifying Fisher Controls of said changes and the possible need for re-qualification.

6. APPROVED MATERIALS

MOVED
TO PAGE 3

DATE 4-30-92
BY WMI
CHKD JDC
APVD JDC
1. DESIGNED
2. DRAWN
3. CHECKED
4. ENGINEERED
5. STAMPED
6. APPROVED
7. RELEASED
8. REVISIONS
9. COMMENTS
10. SIGNATURES
11. DATES
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15. SIGNATURES
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98. REVISIONS
99. COMMENTS
100. SIGNATURES

- (a) Garlock, Mechanical Packing Div., Palmyra, NY
Compound: Blue-Gard 3000 (blue color with dark blue square grid)
Compound: 3003 (lt. yellow color, no markings)
Compound: 3000 from Mexico (lt. gray color, silver square grid)
- (b) Durable Manufacturing Co., Lionville, PA
Compound: Durion (lt. yellow-green color, silver Durable triangle)
- (c) Asberit S.A., Rio De Janeiro, Brazil
Imported by: Sealing Composites Co., P.O. Box 924306, Houston, TX
Houston, TX 77292-4306
Compound: Asberit NA-1001 (lt. green color, no markings)
- (d) Lydall, Composite Materials Div., Manchester, CT
Compound: Robestos D-7201-R (black color, no markings)

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03652

Fisher Controls

Material Specification

FMS 17A9

FLAT SHEET COMPOSITION GASKET MATERIAL
(CLOSE TOLERANCES)Rev: PG
By: WHH 10-14-85
App'd: NFR 10-14-85
Page 1 of 2**FISHER****CONFIDENTIAL**

*Fisher Controls 1985, 1990 1091

Revised By: WHH 4-16-90

10-10-91

1. SCOPE

This specification covers elastomer bound high temperature organic and/or inorganic fiber based flat sheet gasket materials. These materials are used for general purpose gasketing and are designed to replace similar asbestos based gasket materials. They are typically used to seal against oils, water, steam, air, natural gas and many other fluids and gases.

2. **MATERIAL REFERENCE NO.** 0466 (or 0467 for low chloride per FMS 17P30)

3. MATERIAL COMPOSITION

The material shall be composed of high temperature organic and inorganic fibers with nitrile elastomeric binder. Some inorganic filler may be used as long as the resulting sheet material meets the physical properties listed in Table 1. The material should contain no asbestos or cellulose fiber. The thickness and thickness tolerance of the gasket material shall be $0.031 \pm .003$ inches.

4. SERVICE TEMPERATURE

The material shall not deteriorate and shall function properly in the designated service at temperatures up to $+302^{\circ}\text{F}$ (or 150°C).

5. QUALIFICATION TESTING

Fisher Controls shall perform the qualification tests listed in Table 1 prior to approval under this specification. Following approval, the vendor of such material shall make no changes in the product without notifying Fisher Controls of said changes and the possible need for re-qualification.

6. APPROVED MATERIALS

- (a) Garlock, Mechanical Packing Div., Palmyra, NY
Compound: Blue-Gard 3000 (Blue color with dark blue square grid)
Compound: 3003 (Lt. yellow color, no markings)
Compound: 3000 from Mexico (Lt. gray color, silver square grid)
- (b) Durable Manufacturing Co., Lionville, PA
Compound: Durlon (Lt. yellow-green color, silver Durable triangle)
- (c) Asberit S.A., Rio De Janeiro, Brazil
Imported by: Sealing Composites Co., P.O. Box 924306, Houston, TX
Houston, TX 77292-4306
Compound: Asberit NA-1000 (Lt. green color, no markings)
- (d) Lydall, Composite Materials Div., Manchester, CT
Compound: Nobestos D-7201-R (Black color, no markings)

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TAYLOR V. S.M. COMPANY ET AL.

ROA_03653

Fisher Controls

Material Specification

FMS 17A6

FLAT SHEET COMPOSITION GASKET MATERIAL
(CLOSE TOLERANCE)Rev: ③
By: WHH 10-14-85
Apvd: NFR 10-14-85
Page 1 of 2**FISHER****CONFIDENTIAL**

*Fisher Controls 1985, 1988

Revised By: WHH 2-16-88

1. SCOPE

This specification covers elastomer bound high temperature organic and/or inorganic fiber based flat sheet gasket materials. These materials are used for general purpose gasketing and are designed to replace similar asbestos based gasket materials. They are typically used to seal against oils, water, steam, air, natural gas and many other fluids and gases.

2. MATERIAL REFERENCE NO. 0466 (or 0457 for low chloride per FMS 17P30)

3. MATERIAL COMPOSITION

The material shall be composed of high temperature organic and inorganic fibers with nitrile elastomeric binder. Some inorganic filler may be used as long as the resulting sheet material meets the physical properties listed in Table 1. The material should contain no asbestos or cellulose fiber. The thickness and thickness tolerance of the gasket material shall be $0.031 \pm .003$ inches.

4. SERVICE TEMPERATURE

The material shall not deteriorate and shall function properly in the designated service at temperatures up to +450°F.

5. QUALIFICATION TESTING

Fisher Controls shall perform the qualification tests listed in Table 1 prior to approval under this specification. Following approval, the vendor of such material shall make no changes in the product without notifying Fisher Controls of said changes and the possible need for re-qualification.

SEP 24 1988

6. APPROVED MATERIALS

MAJOR REVISION

(a) Garlock, Mechanical Packing Div., Palmyra, NY

Palmyra, NY

Compound No.: Blue-Gard 3000 or Garlock 3003

Also Garlock 3000 from Garlock de Mexico

(b) Duralba Manufacturing Co., Lionville, PA

Lionville, PA

Compound: Duralon (Identified by lt. yellow-green color, silver Duralba triangle)

(c) Asberit S.A.

Rua Da Ajuda, 35

26th Floor, P.O. Box 716

Rio De Janeiro, Brazil

Compound: Asberit NA-1000

Imported by:

Prudential Corp.

122 E. 42nd Street

New York, NY 10168-0136

Compound: Asberit NA-1000

(Identified by lt. green color, no markings)

FMS2-19/1

Compound: Blue-Gard 3000 (Identified by blue color with dark blue square grid)

" 3003 (Identified by lt. yellow color, no markings)

" 3000 from Mexico (Identified by lt. grey color, silver square grid)

TAYLOR V. S.M. COMPANY ET AL.

ROA_03656

Fisher Controls

Material Specification

FMS 17A6

FLAT SHEET COMPOSITION GASKET MATERIAL
(CLOSE TOLERANCE)Rev: ① C
By: WHH 10-14-83
Apvd: MFR 10-14-85
Page 1 of 2**FISHER****CONFIDENTIAL**

Fisher Controls 1985, 1988

Revised By: ZJZ 2-17-831. SCOPE

This specification covers elastomer bound high temperature organic and/or inorganic fiber based flat sheet gasket materials. These materials are used for general purpose gasketing and are designed to replace similar asbestos based gasket materials. They are typically used to seal against oils, water, steam, air, natural gas and many other fluids and gases.

2. MATERIAL REFERENCE NO. 0466 (or 0467 for low chloride per FMS 17F30)3. MATERIAL COMPOSITION

The material shall be composed of high temperature organic and inorganic fibers with nitrile elastomeric binder. Some inorganic filler may be used as long as the resulting sheet material meets the physical properties listed in Table 1. The material should contain no asbestos or cellulose fiber. The thickness and thickness tolerance of the gasket material shall be $0.031 \pm .003$ inches.

4. SERVICE TEMPERATURE

The material shall not deteriorate and shall function properly in the designated service at temperatures up to $+450^{\circ}\text{F}$.

5. QUALIFICATION TESTING

Fisher Controls shall perform the qualification tests listed in Table 1 prior to approval under this specification. Following approval, the vendor of such material shall make no changes in the product without notifying Fisher Controls of said changes and the possible need for re-qualification.

6. APPROVED MATERIALS

- (a) Garlock, Mechanical Packing Div.
Pulmyra, NY
Compound No.: Blue-Gard 3000 or Garlock 3003
Also Garlock 3000 from Garlock de Mexico
- (b) Durable Manufacturing Co.
Lionville, PA
Compound: Durlon
- (c) Asberit S.A.
Rua De Ajuda, 35
26th Floor, P.O. Box 716
Rio De Janeiro, Brazil
Compound: Asberit NA-1000

Imported by:
Prudential Corp.
122 E. 42nd Street
New York, NY 10168-0136
Compound: Asberit NA-1000

AUG 29 1986

MAJOR REVISION

ECR/N NO.	DATE
BY WHH	CHRD 2/17
DOO, CH O STOCK	APVD MFR
1 X USE	112 REASON
2 X CHECK	1 SAFETY
3 X SCRAP/ATN	2 WATT
4 X SCRAP HCN	3 X APPROVE
	4 ERROR
	5 STRN
	6 COST
	7 MCRD

ROA_03657

TAYLOR V. 3.M. COMPANY ET AL.

Fisher Controls

Material Specification

No. FMS 17A6

B

(A)

FISHERFLAT SHEET COMPOSITION GASKET MATERIAL
(CLOSE TOLERANCE)

By W.H.H. 10-14-85

APVD NFR 10-14-85

Page 1 of 2

Rev

© Fisher Controls 1985, 1988

1. SCOPE

This specification covers elastomer bound high temperature organic and/or inorganic fiber based flat sheet gasket materials. These materials are used for general purpose gasketing and are designed to replace similar asbestos based gasket materials. They are typically used to seal against oils, water, steam, air, natural gas and many other fluids and gases.

CONFIDENTIAL

2. MATERIAL REFERENCE NO. 0466 (or 0467 for low chloride per FMS 17F30)

3. MATERIAL COMPOSITION

The material shall be composed of high temperature organic and/or inorganic fibers with nitrile elastomeric binder. Some inorganic filler may be used as long as the resulting sheet material meets the physical properties listed in Table 1. The material should contain no asbestos or cellulose fiber. The thickness and thickness tolerance of the gasket material shall be 0.031 $\pm$ 0.003 inches.

4. SERVICE TEMPERATURE

The material shall not deteriorate and shall function properly in the designated service at temperatures up to +450°F.

5. QUALIFICATION TESTING

Fisher Controls shall perform the qualification tests listed in Table 1 prior to approval under this specification. Following approval, the vendor of such material shall make no changes in the product without notifying Fisher Controls of said changes and the possible need for re-qualification.

6. APPROVED MATERIALS

(a) Garlock, Mechanical Packing Div.
Palmira, N.Y.

Compound No.: Blue-Gard 3000 OR GARLOCK 3003

Identification: Blue Sheet with 2" square pattern, one side - delete

(b) Durable Manufacturing Co.
Lionville, PA

Compound: Durlon

Identification: Light Yellow/Green Sheet with Durable Triangle marking, one side - delete

ASBESTOS

RUA DA ATUDA, 55

2.4 TA FLOOR, ROYAL TIL

RIO DE JANEIRO, BRAZIL

Com Pared: ASBESTO RA-1000

IMPORTED BY:

PROUDENTIAL CORP.

121 E. 92nd Street

NEW YORK, N.Y. 10116-0001

COMPOUND: ASBESTO RA-1000

MAJOR REVISION

MAR 02 1988

CONTR NO. DATE
BY R.L.T. 10-14-85
SALES/STOCK 10-14-85
1. USE 1. SAFETY 5. STOCK
2. APPROV 2. SHIP 6. COST
3. SHIP/STOCK 3. SHIP/STOCK 7. DETAIL
4. SHIP/STOCK 4. SHIP/STOCK

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03658

Fisher Controls

Material Specification

FMS 17A5

FLAT SHEET COMPOSITION GASKET MATERIAL

FISHER

CONFIDENTIAL

 Rev: DL
 By: WHR 4-15-85
 Appd: WHR 4-15-85
 Page: 2 of 2
Fisher Controls 1985, 1991 1992Revised By: WHR 0-10-91

4-50-92

 moved to
 PAGE 1

 TABLE 1
 Qualification Tests

Property	Test Method	Units of Measurement	Criteria
Hardness	FGS 11A1	Shore "B" Durometer	90 $\pm$ 5
Resilience	FGS 11A2	Dashore	30 $\pm$ 10
Compression Set 15,000 PSI, RT, 24 hr.	FGS 11A4 (Type A)	%	20 max. (1)
24 hr. Creep	FGS 11A4	% thk. change after init. change	5 max.
Compressibility, 5000 psi	ASTM F36	%	5 to 17
Compression Set	ASTM F36	% change based on orig. thk.	10 max
Fluid Resistance (a) ASTM Fuel B 5 hr., R.T.	ASTM F146	% thk. change % wgt. change	15 max. (2) 20 max.
(b) ASTM #3 oil, 4d, RT	FGS 11A5	% thk. change % wgt. change	15 max. (2) 20 max.
(c) Hexane, 4d, RT +air dry	FGS 11A5	% thk. change % thk. change	10 max. (2) $\pm$ 5
(d) Methanol 4d, RT +air dry	FGS 11A5	% thk. change % thk. change	10 max. (2) $\pm$ 5
Sealability N ₂ at 30 psig 3000 psi gasket load	ASTM F37	ml./hr.	30 max.

Notes:

- (1) No delamination on removal from compression test platens.
 (2) Hardness change on soak or air dry shall not exceed $\pm$ 10 points from original hardness.

 MAY 27 1992
 FOR REVIEW
 OR MAJOR REVISION STAMP
 INFORMATION SEE COVER SHEET
 REVISION K TO L

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03659

FMS 17A5

Rev: Jk
By: WHH 4-15-85
Apvd: NFR 4-15-85
Page 2 of 2

FISHER

CONFIDENTIAL

Revised By: WHH (4-16-70)

(6-10-9)

TABLE 1
Qualification Tests

Property	Test Method	Unit of Measurement	Criteria
Hardness	FGS 11A1	Shore "D" Durometer	90 $\pm$ 5
Resilience	FGS 11A2	Bashore	80 $\pm$ 10
Compression Set 15,000 PSI, RT, 24 hr.	FGS 11A4 (Type A)	%	20 max. (1)
24 hr. Creep.	FGS 11A4	% thk. change after init. change	5 max.
Compressibility, 6000 psi	ASTM F36	%	5 to 17
Compression Set	ASTM F36	% change based on orig. thk.	10 max
Fluid Resistance			
(a) ASTM Fuel-B 5 hr., R.T.	ASTM F146	1/2 thk. change 1/2 wgt. change	15 max. (2) 20 max.
(b) ASTM, #3 oil, 4d, RT	FGS 11A5	1/2 thk. change 1/2 wgt. change	15 max. (2) 20 max.
(c) Hexane, 4d, RT +air dry	FGS 11A5	1/2 thk. change 1/2 thk. change	10 max. (2) $\pm$ 5
(d) Methanol 4d, RT +air dry	FGS 11A5	1/2 thk. change 1/2 thk. change	10 max. (2) $\pm$ 5
Sealability N ₂ at 30 psig 3000 psi gasket load	ASTM F37	ml./hr.	20 max. 30

Notes :

- (1) No delamination on removal from compression test platens.
- (2) Hardness change on soak or air dry shall not exceed ± 10 points from original hardness.

[illegible]

Fisher Controls

Material Specification

FMS 17A5

FLAT SHEET COMPOSITION GASKET MATERIAL

Rev: (H) J
 By: MHR 4-15-85
 Apvd: MHR 4-15-85
 Page 2 of 2

FISHER**CONFIDENTIAL**

*Fisher Controls 1985, (1989) 1990

Revised By: WMM 7-18-54

TABLE 1
 Qualification Tests

Property	Test Method	Units of Measurement	Criteria
Hardness	FGS 11A1	Shore "D" Durometer	90 $\pm$ 5
Resilience	FGS 11A2	Bashore	30 $\pm$ 10
Compression Set 15,000 PSI, RT, 24 hr.	FGS 11A4 (Type A)	%	20 max. (1)
24 hr. Creep	FGS 11A4	$\pm$ thk. change after init. change	5 max.
Compressibility, 5000 psi	ASTM F36	%	5 to 17
Compression Set	ASTM F36	$\pm$ change based on orig. thk.	10 max
Fluid Resistance (a) ASTM #3 oil, 5 hr., 300°F	ASTM F146	$\pm$ thk. change $\pm$ wgt. change	0 to 15 (2) 20 max.
(b) ASTM Fuel B 5 hr., R.T.	ASTM F146	$\pm$ thk. change $\pm$ wgt. change	0 to 15 (2) 20 max.
(c) Hexano, 4d, RT +air dry	FGS 11A5 FGS 11A5	$\pm$ thk. change $\pm$ thk. change	0 to 15 (2) 0 to 10 (2) 15 max.
(d) Methanol 4d, RT +air dry	FGS 11A5	$\pm$ thk. change $\pm$ thk. change	0 to 10 (2) $\pm$ 5 10 max.
Sealability N ₂ at 30 psig 3000 psi gasket load	ASTM F37	ml./hr.	20 max.

Notes:

- (1) No delamination on removal from compression test platens.
 (2) Hardness change on soak or air dry shall not exceed $\pm$ 10 points from original hardness.

MAJOR REVISION
 ECR/H NO. _____
 BY: WMM CHEN/DES AND MHR
 DATE: MAY 01 1990
 1-DESIGN 2-ANALYSIS 3-TESTING 4-REVIEW 5-APPROVAL 6-REVISION 7-DELETE
 1-DESIGN 2-ANALYSIS 3-TESTING 4-REVIEW 5-APPROVAL 6-REVISION 7-DELETE
 Change made by: _____
 Reason for change: _____
 Approved: _____

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03661

Fisher Controls

Material Specification

FMS 17A5

FLAT SHEET COMPOSITION GASKET MATERIAL

 Rev: G H
 By: WEN 4-15-85
 Appd: NFR 4-15-85
 Page 2 of 2
FISHER**CONFIDENTIAL**

Fisher Controls 1985, 1988 1987

Revised By: W/HN 9-15-88
 TABLE 1
 Qualification Tests

Property	Test Method	Units of Measurement	Criteria
Hardness	FGS 11A1	Shore "B" Durometer	90 $\pm$ 5
Resilience	FGS 11A2	Bashore	30 $\pm$ 10
Compression Set 15,000 PSI, RT, 24 hr.	FGS 11A4 (Type A)	%	20 max. (1)
24 hr. Creep	FGS 11A4	% thk. change after init. change	5 max.
Compressibility, 5000 psi	ASTM F36	%	5 to 17
Compression Set	ASTM F36	% change based on orig. thk.	10 max
Fluid Resistance (a) ASTM F3 oil, 5 hr., 300°F	ASTM F146	% thk. change % wgt. change	0 to 15 (2) 20 max.
(b) ASTM Fuel B 5 hr., R.T.	ASTM F146	% thk. change % wgt. change	0 to 15 (2) 20 max.
(c) Hexane, 4d, RT +air dry	FGS 11A5	% thk. change % thk. change	0 to 10 (2) $\pm$ 5
(d) Methanol 4d, RT +air dry	FGS 11A5	% thk. change % thk. change	0 to 10 (2) $\pm$ 5
Sealability N ₂ at 30 psig 3000 psi gasket load	ASTM F37	ml./hr.	20 max.

Notes:

- (1) No delamination on removal from compression test platens.
 (2) Hardness change on soak or air dry shall not exceed $\pm$ 10 points from original hardness.

MAJOR REVISION

DATE: JUL 24 1989

BY: W/HN

CHKD: JZG

APVD: NFR

BY: W/HN

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APVD: NFR

BY: W/HN

CHKD: JZG

APVD: NFR

BY: W/HN

CHKD: JZG

APVD: NFR

BY: W/HN

CHKD: JZG

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APVD: NFR

BY: W/HN

CHKD: JZG

APVD: NFR

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03662

Fisher Controls

Material Specification

FMS 17A5

FLAT SHEET COMPOSITION GASKET MATERIAL

 Rev: 6
 By: WHH 4-15-85
 Apvd: NFR 4-15-85
 Page 2 of 2
FISHER**CONFIDENTIAL**

*Fisher Controls 1985, 1988

Revised By: WHH R-14-88

 TABLE 1
 Qualification Tests

Property	Test Method	Units of Measurement	Criteria
Hardness	FGS 11A1	Shore "D" Durometer	90 $\pm$ 5
Resiliance	FGS 11A2	Bashore	30 $\pm$ 10
Compression Set 15,000 PSI, RT, 24 hr.	FGS 11A4 (Type A)	%	20 max. (1)
24 hr. Creep	FGS 11A4	% thk. change after init. change	5 max.
Compressibility, 5000 psi	ASTM F36	%	5 to 17
Compression Set	ASTM F36	% change based on orig. thk.	10 max
Fluid Resistance (a) ASTM 15 oil, 5 hr., 300°F	ASTM F146	% thk. change % wgt. change	0 to 15 (2) 20 max.
(b) ASTM Fuel B 5 hr., R.T.	ASTM F146	% thk. change % wgt. change	0 to 15 (2) 20 max.
(c) Hexane, 4d, RT +air dry	FGS 11A5	% thk. change % thk. change	0 to 10 (2) $\pm$ 5
(d) Methanol 4d, RT +air dry	FGS 11A5	% thk. change % thk. change	0 to 10 (2) $\pm$ 5
Sealability N ₂ at 30 psig 3000 psi gasket load	ASTM F37	ml./hr.	20 max.

Notes:

- (1) No delamination on removal from compression test platens.
 (2) Hardness change on soak or air dry shall not exceed $\pm$ 10 points from original hardness.

MAJOR REVISION

 REV. NO. DATE SEP 26 1988
 BY WHH
 FOR WHH
 1. REVISION
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TAYLOR V. 3.M. COMPANY ET AL.

ROA_03663

Fisher Controls

Material Specification

FMS 17A5.

FLAT SHEET COMPOSITION GASKET MATERIAL

 Rev: **CF**
 Py: WTR 4-15-85
 Apvd: NFR 4-15-85
 Page 2 of 2
FISHER**CONFIDENTIAL**

Fisher Controls 1985, 1988

Revised By: **RJ 2-17-88**
 TABLE 1
 Qualification Tests

Property	Test Method	Units of Measurement	Criteria
Hardness	FGS 11A1	Shore "B" Durometer	90 ± 6
Resilience	FGS 11A2	Bashore	90 ± 10
Compression Set 15,000 PSI, RT, 24 hr.	FGS 11A4 (Type A)		20 max. (1)
24 hr. Creep	FGS 11A4	% thk. change after init. change	5 max.
Compressibility, 5000 psi	ASTM F36	%	5 to 17
Compression Set	ASTM F36	% change based on orig. thk.	10 max
Fluid Resistance (a) ASTM F146 5 hr., 300 $^{\circ}$ F	ASTM F146	% thk. change % wgt. change	0 to 15 (2) 20 max.
(b) ASTM Fuel B 5 hr., R.T.	ASTM F146	% thk. change % wgt. change	0 to 15 (2) 20 max.
(c) Hexane, 4d, RT +air dry	FGS 11A5	% thk. change % thk. change	0 to 10 (2) ± 5
(d) Methanol 4d, RT +air dry	FGS 11A5	% thk. change % thk. change	0 to 10 (2) ± 5
Sealability N, at 30 psig 3000 psi gasket load	ASTM F37	ml./hr.	20 max.

Notes:

- (1) No delamination on removal from compression test platens.
- (2) Hardness change on soak or air dry shall not exceed ± 10 points from original hardness.

ECR/N NO.
 BY: WWH CHD 127 APUG NFR AUG 29 1988
 1. DATE
 2. CHECK
 3. PERMIT
 4. SIGNATURE
 5. SIGN
 6. CHECK
 7. SIGN
 8. SIGN
 9. SIGN
 10. SIGN
 Add Fisher to Mexico source

Fisher Controls

Material Specification

No. FMS 17A5

FISHER

FLAT SHEET COMPOSITION GASKET MATERIAL

CONFIDENTIAL

By	WHH	4-15-85
Appd	NRE	4-15-85
Page	2 of	2

Fisher Controls 1585, 1988

Rev	NRE	10-29-85

TABLE 1
Qualification Tests

Property	Test Method	Units of Measurement	Criteria
Hardness	FGS 11A1	Shore "D" Durometer	90 $\pm$ 5
Resilience	FGS 11A2	Bashore	30 $\pm$ 10
Compression Set 15,000 PSI, RT, 24 hr.	FGS 11A4 (Type A)	%	20 max. (1)
24 hr. Creep	FGS 11A8	% thk. change after init. change	5 max.
Compressibility, 5000 psi	ASTM F36	%	5 to 17
Compression Set	ASTM F36	% change based on orig. thk.	10 max.
Fluid Resistance (a) ASTM #3 oil, 5 hr., 300°F	ASTM F146	% thk. change	0 to 15 (2)
(b) ASTM Fuel B 5 hr., R.T.	ASTM F146	% wgt. change % thk. change % wgt. change	20 max. 0 to 15 (2) 20 max.
(c) Hexane, 4d, RT +air dry	FGS 11A5	% thk. change	0 to 10 (2)
(d) Methanol 4d, RT +air dry	FGS 11A5	% thk. change % thk. change % thk. change	$\pm$ 5 0 to 10 (2) $\pm$ 5
Sealability N ₂ at 30 psig 3000 psi gasket load	ASTM F37	ml./hr.	20 max.

Notes:

- (1) No delamination on removal from compression test platens.
- (2) Hardness change on soak or air dry shall not exceed $\pm$ 10 points from original hardness.

REASON REVISION

BY: [Signature]
DATE: [Date]
REASON: [Reason]
APPROVED: [Signature]
DATE: [Date]
REASON: [Reason]

Fisher Controls

Material Specification

No. FMS 17A5

FISHER

FLAT SHEET COMPOSITION GASKET MATERIAL

CONFIDENTIAL

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By WHH 4-15-85

Appd NRP 4-15-85

Page 2 of 2

Rev NRP 10-14-85

TABLE 1
Qualification Tests

10-29-85

Property	Test Method	Units of Measurement	Criteria
Hardness	FGS 11A1	Shore "B" Durometer	90 $\pm$ 5
Resilience	FGS 11A2	Bashore	30 $\pm$ 10
Compression Set 15,000 PSI, RT, 24 hr.	FGS 11A4 (Type A)	%	20 max. (1)
24 hr. Creep	FGS 11A4	% thk. change after init. change	5 max.
Compressibility, 5000 psi	ASTM F35	%	5 to 17
Compression Set	ASTM F36	% change based on orig. thk.	10 max.
Fluid Resistance (a) ASTM F3 oil, 5 hr., 300°F	ASTM F145	% thk. change	0 to 15 (2)
(b) ASTM Fuel Oil 5 hr., R.T.	ASTM F146	% thk. change % wgt. change	20 max. 0 to 15 (2) 20 max.
(c) Hexane, 4d, RT +air dry	FGS 11A5	% thk. change	0 to 10 (2)
(d) Methanol 4d, RT +air dry	FGS 11A6	% thk. change	$\pm$ 5 0 to 10 (2)
Sealability N ₂ at 30 psig 3000 psi gasket load	ASTM F37	ml./hr.	20 max.

Notes:

- (1) No delamination on removal from compression test platens.
- (2) Hardness change on soak or air dry shall not exceed $\pm$ 10 points from original hardness.

MAJOR REVISION
FOR NO. N/A
DATE: 11/7/85
BY: NRP
CHECKED: WHH
APPROVED: NRP
1 - DESIGN
2 - SAFETY
3 - MATERIALS
4 - TESTING
5 - STUB
6 - COST
7 - INQUIRY
8 - SALES
9 - AMPLIFY TOLERANCES ON PAGE 1

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03666

Fisher Controls

Material Specification

No. FMS 17A5

FISHER

FLAT SHEET COMPOSITION GASKET MATERIAL

CONFIDENTIAL

©Fisher Controls

By WHH 4-15-85

APWD NRP 4-16-85

Page 2 of 2

Rev NRP 7-17-85

TABLE I
Qualification Tests

Property	Test Method	Units of Measurement	Criteria
Hardness	FGS 11A1	Shore "B" Durometer	90 $\pm$ 5
Resiliance	FGS 11A2	Dashore	30 $\pm$ 10
Compression Set 16,000 PSI, RT, 24 hr.	FGS 11A4 (Type A)	%	20 max. (1)
24 hr. Creep	FGS 11A4	% thk. change after init. change	5 max.
Compressibility, 5000 psi	ASTM F36	%	5 to 17
Compression Set	ASTM F36	% change based on orig. thk.	10 max.
Fluid Resistance (a) ASTM F3 off, 5 hr., 300°F	ASTM F146	% thk. change	0 to 15 (2)
(b) ASTM Fuel O 5 hr., R.T.	ASTM F146	% thk. change % wgt. change	20 max. 0 to 15 (2) 20 max.
(c) Hexane, 4d, RT +air dry	FGS 11A5	% thk. change	0 to 10 (2)
(d) Methanol 4d, RT +air dry	FGS 11A5	% thk. change	+5 0 to 10 (2)
Sealability N ₂ at 30 psig 3000 psi gasket load	ASTM F37	ml./hr.	20 max.

Notes:

- (1) No delamination on removal from compression test platens.
- (2) Hardness change on soak or air dry shall not exceed $\pm$ 10 points from original hardness.

MAJOR REVISION

DATE: 10/21/85
BY: NRP
CHECKED: NRP
APPROVED: NRP
REVISIONS:
1. ADD TOLERANCES FOR GASKET THICKNESS, ADD LOW CHLORIDE MNR.

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03667

Fisher Controls

Material Specification

No. FHS 17A5

B

FISHER

FLAT SHEET COMPOSITION GASKET MATERIAL

CONFIDENTIAL

By WWH

4-15-85

App'd

NFR 4-15-85

Page

2 of 2

Rev

Fisher Controls 1985

TABLE 1
Qualification Tests

Property	Test Method	Units of Measurement	Criteria
Hardness	FBS 11A1	Shore "B" Durometer	90 ± 5
Resilience	FBS 11A2	Rebound	30 ± 10
Compression Set 15,000 PSI, RT, 24 hr.	FBS 11A4 (Type A)	%	20 max. (1)
24 hr. Creep	FBS 11A4	% thk. change after init. change	6 max.
Compressibility, 5000 psi	ASTM F35	%	5 to 17
Compression Set	ASTM F35	% change based on orig. thk.	10 max.
Fluid Resistance (a) ASTM #3 oil, 5 hr., 300°F	ASTM F146	% thk. change	0 to 15 (2)
(b) ASTM Fuel B 6 hr., R.T.	ASTM F146	% wgt. change % thk. change % wgt. change	20 max. 0 to 15 (2) 20 max.
(c) Hexane, 4d, RT +air dry	FBS 11A5	% thk. change	0 to 10 (2)
(d) Methanol 4d, RT +air dry	FBS 11A5	% thk. change % thk. change % thk. change	± 5 0 to 10 (2) ± 5
Sealability N ₂ at 30 psig 3000 psi gasket load	ASTM F37	ml./hr.	20 max.

Notes:

- (1) No delamination on removal from compression test platens.
- (2) Hardness change on soak or air dry shall not exceed ± 10 points from original hardness.

MAJOR REVISION

ECR/N NO. DATE: 7-15-85

BY: NFR CHD WWH APD NFR

1 - X USE

2 - APPROV

3 - DESIGN/ENG

4 - SPECIAL MGMT

5 - SUPPLY

6 - COST

7 - MFG

8 - QA

9 - X FISH

10 - X FISH

11 - X FISH

12 - X FISH

13 - X FISH

14 - X FISH

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Fisher Controls

Material Specification

CONFIDENTIAL

FISHERHEAVY DUTY ELASTOMER-BOUND ASBESTOS
GASKET MATERIAL

FMS 17A4		C
By	RGR	2-19-67
App'd	TKB	9-14-62
Page	1	of 1
Rev	WHH	2-15-68

© Fisher Controls 1082

1. SCOPE

This specification lists the approved source(s) for nitrile elastomer bound asbestos gasketing and describes the composition of the approved source(s), their producer name; and all approved substitutes for the approved source(s).

2. MATERIAL COMPOSITION

The material, as covered by this specification, shall be a compressed asbestos type sheet consisting of about 80-85% asbestos fibers with about 15-20% nitrile type elastomeric binder.

3. SURFACE RESISTANCE OF MATERIAL

The material surfaces shall be resistant to sticking to metals such as brass, aluminum, and steel. The material shall be resistant to compression relaxation under heavy loads.

4. GENERAL USAGE OF MATERIAL

The material shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical, and general processing type industries.

5. MATERIAL SUBSTITUTION

The approved source(s) may be substituted for the material source(s) shown on FMS17A2 provided:

- (a) The service conditions are acceptable to allow substitution.
- (b) The gasket cutter can furnish cut parts at prices equivalent to those for FMS17A2 material.

There is no approved substitute for FMS17A4 material.

6. APPROVED SOURCE(S)

The following material(s) have been approved:

- (a) Armstrong Asbestos AN-8012
(Cooper Manufacturing Co.)
Armstrong Industrial Products Div.
Lancaster, PA 17604

OBSOLETE

Superseded by
FMS 17A4
or 17P18

Form FMS17A4-10-1-64

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03670

Fisher Controls

Material Specification

HEAVY DUTY ELASTOMER-BOUND ASBESTOS
GASKET MATERIAL**FISHER**

Fisher Controls 1382

FMS 17A4

By: RSK 2-12-69

Appl: TKB 9-14-82

Page 1 of 1

Rev: 0.0 9-14-82

1. SCOPE

OBSOLETE

This specification lists the approved source(s) for nitrile elastomer bound asbestos gasketing and describes the composition of the approved source(s), their product name; and all approved substitutes for the approved source(s).

2. MATERIAL COMPOSITION

The material, as covered by this specification, shall be a compressed asbestos type sheet consisting of about 80-85% asbestos fibers with about 15-20% nitrile type elastomeric binder.

3. SURFACE RESISTANCE OF MATERIAL

The material surfaces shall be resistant to sticking to metals such as brass, aluminum, and steel. The material shall be resistant to compression relaxation under heavy loads.

4. GENERAL USAGE OF MATERIAL

The material shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical, and general processing type industries.

5. MATERIAL SUBSTITUTION

The approved source(s) may be substituted for the material source(s) shown on FMS17A2 provided:

- (a) The service conditions are acceptable to allow substitution.
- (b) The gasket cutter can furnish cut parts at prices equivalent to those for FMS17A2 material.

There is no approved substitute for FMS17A4 material.

OBSOLETESuperseded by
FMS 17A5 or
17F38

6. APPROVED SOURCE(S)

The following material(s) have been approved:

- (a) Armstrong Accobest AN-8012
(Cooper Manufacturing Co.)
Armstrong Industry Products Div.
Lancaster, PA 17604

MAJOR REVISION

ECR/NO.	DATE
BY: WHH	CHKD: DRB
APVD: HPR	
REASON	
1. NEW	2. SAFETY
3. REWORK	4. MATERIAL
5. SCRAP/NEW	6. IMPROVE
7. DISCARD/NEW	8. OTHER

Make obsolete - no longer
use asbestos

FEB 28 1989

TAYLOR V. S.M. COMPANY ET AL.

ROA_03671

FISHER
GOVERNOR CO.
MARSHALLTOWN, IOWA
USA

MATERIAL SPECIFICATION

HEAVY DUTY RUBBER-ASBESTOS GASKET MATERIAL
Elastomer Bond

FORM 17A48	(A)
ISSUED	REG 2-19-69
REV.	
PAGE	1 OF 1

Heavy Duty Rubber-Asbestos

Nitrile - butadiene rubber binder

The following materials have been approved.

- 1) Armstrong Accobest AN-8012
Cooper Manufacturing Company

SEP 21 1982

MAJOR REVISION

BY SPRCHND NRP APVD TKB DATE SEP 21 1982
#10, OLD STOCK ✓ #30, REASON
1. ✓ 1. SAFETY 6. ✓ STUDY
2. ✓ 2. MAIL 7. ✓ ST
3. ✓ 3. IMPROVE 7. ✓ ST
4. ✓ 4. ✓ 5. ✓ 6. ✓ 7. ✓

Completely rewritten to agree
with new format.

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03672

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5-20-

9-12

1 of 1

144

2-15-88

Superseded by
NMS 1705 or
17038

ROA_03673

Fisher Controls

Material Specification

CONFIDENTIAL

No.	FMS 17A3	①
By	HW	5-20-53
App'd	NFR	9-9-83
Page	1	of 1
Rev	MRP	9-9-83

FISHERASBESTOS GASKET SHEET
WITH NON-STICKING QUALITIES

©Fisher Controls 1983

1. SCOPE

OBSOLETE

This specification lists the approved source(s) for compressed asbestos sheet material used for general purpose gasketing.

2. MATERIAL REFERENCE NO. - 0403

3. MATERIAL COMPOSITION & PROPERTIES

The sheet is to be of the best grade long fiber asbestos and SBR elastomeric binder. When clamped between flanges it must not stick to the flanges, even though they are primed or painted.

4. APPROVED SOURCE(S)

- (a) Garlock Mechanical Packing Division
Palmyra, N.Y.
Style No. 900/7736
- (b) Nicolet Incorporated
Ambler, Pa.
Style No. 240

OBSOLETE

FEB 22 1988

Superseded by
FMS 17A3 or
17A3B

MAJOR REVISION

FOR N NO.	DATE
BY <u>WHH</u> CHKD <u>PRO</u> APVD <u>NFR</u>	
1 - PRE 2 - REWORK 3 - SCRAP/NEW 4 - SCRAP NOW	1 - SAFETY 2 - MATL 3 - IMPROVE 4 - FINISH 5 - STREN 6 - COST 7 - MKTG/ 8 - SALES

Make obsolete - no longer
use asbestos

CONFIDENTIAL

THE SHEET IS TO BE OF BEST GRADE LONG FIBRE ASBESTOS. WHEN CLAMPED BETWEEN FLANGES IT MUST NOT STICK TO THE FLANGES, EVEN THOUGH THEY ARE PRIMED OR PAINTED.

THE FOLLOWING MATERIALS HAVE BEEN APPROVED.

1. BARLOCK STYLE NO. 900/7735
2. NICOLLET NO. 240

SEP 23 1983

MAJOR REVISION

BY: *[Signature]*
 1. 10-16-79 CHD
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MONTHLY REVIEW
 PAGE IN NEW FORMAT
 Completely Retyped

TITLE ASBESTOS GASKET SHEET WITH NON-STICKING QUALITIES.				TYPE	
BY: <i>[Signature]</i> DATE: 8-20-83				DESIGN NO.	
DWG. NO.				DRAWER NO.	
FISHER GOVERNOR CO. MARSHALLTOWN, IOWA				DWG. NO. FMS-7A3	
SUPERSEDES DWG. NO.				REV.	
REVISIONS				SCALE	

CONFIDENTIAL

THE SHEET IS TO BE OF BEST GRADE LONG FIBRE ASBESTOS. WHEN CLAMPED BETWEEN FLANGES IT MUST NOT STICK TO THE FLANGES, EVEN THOUGH THEY ARE PRIMED OR PAINTED.

THE FOLLOWING MATERIALS HAVE BEEN APPROVED.

1. GARLOCK STYLE NO. 7735

900/7735

1022-79
 MAJOR REVISION
 BY 12212 CHKD 04-2 APVD [initials]
 REASON: 1. COST 2. SAFETY 3. SIZE
 1. COST 2. SAFETY 3. SIZE
 2. BELMADINE 3. J. BENT 4. COST
 3. SCRAPVIEW 4. IMPROVE
 4. SCRAP VIEW 5. IMPROVE
 UP-DATE APPROVED MATL
 E. DIXON

TITLE ASBESTOS GASKET SHEET WITH NON-STICKING QUALITIES				DESIGN NO.		TYPE	
BY DATE				DRAWER NO.		SIZE	
DWG. NO. 5-20-23				FISHER		B	
GOVERNOR CO.				DWG. NO.		FAC 17 A 21A	
MARSHALLTOWN, IOWA				APPROVED & DWG. NO.			
DATE	BY	CHKD	APVD				

TAYLOR V. 3.M. COMPANY ET AL.
 FISHER 000460

ROA_03676

OBSOLETE

CONFIDENTIAL

C.G. YK

ASBESTOS GASKET SHEET WITH NON-STICKING QUALITIES

The sheet is to be of best grade long fibre asbestos. When clamped between flanges it must not stick to the flanges, even though they are primed or painted.

The following materials have been approved.

1. Garlock style No. 7735

Page 1 of 1

Asbestos Gasket Sheet With Non-Sticking Qualities					SIZE	TYPE	
FISHER® GOVERNOR CO. McKINNEY, TEXAS					BY DWL	DATE 11/10/65	FILE
					BY CWD	DATE 11-11-65	SCALE
					SUPERSEDES FMS17A3		DESIGN
					DWG. NO. T10192		REV A

CONFIDENTIAL

Fisher Controls	Material Specification	No.	FMS 17A2	E
FISHER	HIGH GRADE LONG FIBRE ASBESTOS SHEET GASKET MATERIAL	Doc.	8-1 '75	
		App.	9-14-82	
		Page	1 of 1	
Fisher Controls 1983		Rev.	2-15-80	

1. SCOPE

OBSOLETE

This specification lists the approved source(s) for elastomer bound asbestos gasketing and describes the composition of the approved source(s), their surface resistance, general usage, product name; and all approved substitutes for the approved sources.

2. MATERIAL REFERENCE NO. 0402

3. MATERIAL COMPOSITION

The material, as covered by this specification, shall be a compressed asbestos type sheet consisting of about 80-85% asbestos fibers with about 15-20% elastomeric binder.

4. SURFACE RESISTANCE OF MATERIAL

The material surfaces shall be resistant to sticking to metals such as brass, aluminum, and steel. The material shall be resistant to compression relaxation under heavy loads.

5. GENERAL USAGE OF MATERIAL

The material shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical, and general processing type industries.

6. MATERIAL SUBSTITUTION

The approved material(s) listed under FMS 17A4 may be substituted for the approved material(s) listed below. The substitution may be made provided:

- (a) The service conditions are acceptable to allow substitution.
- (b) The gasket cutter can furnish cut parts at prices equivalent to those for FMS 17A2 material.

FMS 17A2 material may not be substituted for FMS 17A4 material.

7. APPROVED SOURCE(S)

The following material(s) have been approved:

- (a) Durabla -
Durabla Manufacturing Co.
Pott, PA 19301

FMSI-13/1

OBSOLETE

Superseded by
FMS 17A4 or
17A2

FORM 100-370-10-1-1

Fisher Controls

Material Specification

No. FMS 17A2

HIGH GRADE LONG FIBRE ASBESTOS SHEET
GASKET MATERIAL**FISHER****CONFIDENTIAL**

By CWW 8-7-73

APVD YKB 9-14-82

Page 1 of 1

© Fisher Controls 1982, 1983

Rev. 1/82 9-14-82

1. SCOPE

This specification lists the approved source(s) for nitrile elastomer bound asbestos gasketing and describes the composition of the approved source(s), their surface resistance, general usage, product name; and all approved substitutes for the approved sources.

2. MATERIAL REFERENCE No. 0402

3. MATERIAL COMPOSITION

The material, as covered by this specification, shall be a compressed asbestos type sheet consisting of about 80-85% asbestos fibers with about 15-20% nitrile type elastomeric binder.

4. SURFACE RESISTANCE OF MATERIAL

The material surfaces shall be resistant to sticking to metals such as brass, aluminum, and steel. The material shall be resistant to compression relaxation under heavy loads.

5. GENERAL USAGE OF MATERIAL

The material shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical, and general processing type industries.

6. MATERIAL SUBSTITUTION

The approved material(s) listed under FMS17A6 may be substituted for the approved material(s) listed below. The substitution may be made provided:

- (a) The service conditions are acceptable to allow substitution.
- (b) The gasket cutter can furnish cut parts at prices equivalent to those for FMS17A2 material.

FMS17A2 material may not be substituted for FMS17A4 material.

7. APPROVED SOURCES

The following material(s) have been approved:

- (a) Durable -
Durable Manufacturing Co.
Wayne PA 19087
Part: 14301

MAJOR REVISION 9/1/73
BY HRP CHKD WWH APVD UFR
1 - OLD SPEC 130 - REASON
1 - SAFETY 5 - STOK
1 - SURVIVOR 2 - HAW 6 - COST
1 - SCOR/NOV 3 - IMPROV
1 - SCOR/NOV 4 - TRADE

SEP 13 1983

7									

Material is to be an homogeneous construction.

1. Durabla

SEP 21 1982

BY CHIKO HIRANO JKB

144 OLD STOCK		834 REASON	
1 Δ USE	✓	2 - JASSET	6 - SIOZE
2 REMACHINE	✓	2 - HASE	9 - CUST
2 - F.	✓	2 KIMHOYE	7 - TOA
6 - CRIME. WOH	✓	4 - LKROE	SALES

Completely rewritten in new format
removed Johns. Mans. He as approved
5/11/02

High Grade Long Fibre Asbestos Sheet, Gasket Material				SIZE		TYPE	
QTY		BY		DATE		DESIGN	
OWN.		BY		DATE		DESIGN	
CHKD.		BY		DATE		DESIGN	
APVD.		BY		DATE		DESIGN	
SPECIAL		BY		DATE		DESIGN	
MARSHALLTOWN, IOWA		BY		DATE		DESIGN	
REV.		BY		DATE		DESIGN	

Fisher Controls

Material Specification

FMS 17F9

POLYCHLOROTRIFLUOROETHYLENE
FILM AND SHEETRev: ~~D~~
By: RKD 4-12-82
Apvd: TRS 11-8-82
Page 1 of 1**FISHER**

Fisher Controls 1982, 1990

Revised By: W.H.H. 4-18-9

CONFIDENTIAL

1. SCOPE

This specification covers polychlorotrifluoroethylene film and sheet products used primarily as gaskets, diaphragms and diaphragm protectors.

2. MATERIAL REFERENCE NO. 0504

3. SPECIFICATIONS

(a) Composition: IM Company's Kel-F resin LOX grade or equivalent.

(b) Form: Film or sheet

(c) Process: Melt extrusion

(d) Typical physical properties:

Tensile strength @ 73°F, ASTM D638
Elongation-at-Break @ 73°F, ASTM D638
Flexural modulus @ 73°F, ASTM D790
Hardness, ASTM D2240 (Type D)

5725 psi
150%
180,000 psi
75-80

12 References
a) ASTM D638 - Test Method for Tensile Properties of Plastics.

b) ASTM D790 - Test Method for Flexural Properties of Reinforced and Unreinforced Plastics.

c) ASTM D2240 - Test Method for Rubber Property - Durometer Hardness

MAJOR REVISION

EORN No. 761198

Date: 4-11-97

By: [Signature]

640, Old Stock

1. USER

2. REVIEW

3. SCHARNEW

4. SCHARNOW

640, New Stock
1. SAFETY
2. MATH
3. IMPROVE
4. ERROR

5. STUZN
6. COST
7. MARKS
8. SALES

FEB 10 1998

Updated to the new electronic format.
Any changes to appearance, paragraph numbering, etc., were to accommodate the new document format style. The appearance of the document will not be the same as before. NO CHANGES TO CONTENT.

ADDED REFERENCES

TAYLOR V. 3.M. COMPANY ET AL.
FISHER 000650

ROA_03682

Fisher Controls	Material Specification	No.	FMS 1789	③
FISHER	~~delete~~ KEL-F FILM AND SHEET	By	AKG	4-12-62
	POLYCHLOROTRIFLUOROETHYLENE	App'd	AKG	11-8-82
		Page	1	of 1
©Fisher Controls 1982 & 1990		Rev	AKG	11-4-82

1. SCOPE

CONFIDENTIAL

This specification covers polychlorotrifluoroethylene film and sheet products used primarily as gaskets and diaphragm protectors.

2. MATERIAL REFERENCE NO. 0504

diaphragms

3. SPECIFICATIONS

(a) Composition: 3M Company's Kel-F resin LOX grade or equivalent.

(b) Form: Film or sheet

(c) Process: Melt extrusion

(d) Typical physical properties:

Tensile strength @ 73°F, ASTM D636	5725 psi
Elongation-at-fail @ 73°F, ASTM D636	150%
Flexural modulus @ 73°F, ASTM D790	180,000 psi
Hardness, ASTM D2240 (Type D)	75-80

MAJOR REVISION

DATE MAY 01 1990

ECR/N NO. BY WJH CHG RJE ASVO AKG
 1. 2. 3. 4. 5. 6. 7. 8. 9. 10. 11. 12. 13. 14. 15. 16. 17. 18. 19. 20.
 1. 2. 3. 4. 5. 6. 7. 8. 9. 10. 11. 12. 13. 14. 15. 16. 17. 18. 19. 20.

Change title, add another usage.

CONFIDENTIAL

1. SCOPE

This specification covers polychlorotrifluoroethylene film and sheet products used primarily as gaskets and diaphragm protectors.

2 MATERIAL REFERENCE NO. 1504

Kcl-F Film

Lox Grade

Leont

Approved Source:

om. t

J. W. S. Shamban & Company, Part No. S-16892

3. SPECIFICATIONS

- (a) Composition: 100 Compaq's Pol-Ethylene LDX grade or equivalent.
- (b) Form: Film or sheet.
- (c) Process: Melt extrusion
- (d) Typical physical properties:

Tensile strength @ 72°F, ASTM D688	5725 psi
Elongation at break @ 72°F, ASTM D688	150%
Flexural modulus @ 72°F, ASTM D790	180,000 psi
Hardness, ASTM D2240 (Type D)	75-80

NOV 17 1982

MAJOR REVISION

641

ОУЧЕБНИК 10 КЛА АРХИВ ТКА

840, Old Stock 257, 75-1512

1 - 2031 1 - 2032 5 - 2033
1 - 2034 2 - 2035 6 - 2036

1 - SCRAP T-EN, EPI, 2 - IMPROVE 7. 1. 1

1. 10/15/22 ✓ 1. 11/20/22 SALES

NEWS OF CP CURRENT SPECI

Kel-T (Gasket Material) FLOW AND WHEEL

BOOK REVIEW

744

FISHER®

NY

DATE _____

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2017年12月25日

□

FMS 1154 15-1-12

CONFIDENTIAL

This laminated plant fiber sheet is a suitable water, gasoline and oil resistant gasket material. It must meet ASTM F104 (F324/28-H6).

The following materials have been approved.

1. Vellumoid No. 505 (Federal-Mogul)
2. Fibreflex Detroit

delete

1. SCOPE

This specification covers treated cellulose fiber sheet suitable for gasketing in water, gasoline and oil service.

2. MATERIAL REFERENCE No.

0401

3. SPECIFICATION

The material shall comply with ASTM F104 F324/28-H6

4. TEMPERATURE LIMIT

This material is suitable for continuous service up to +250°F.

5. ACCEPTED SOURCE(S)

(a) Vellumoid, Inc.
Worcester, MA 01606

JUN 08 1989

Style No. Vellumoid 505 Fibre MAJOR REVISION

ECR/N NO. DATE
BY WHM CHKD JLG RPHD NEW
PAC. GLE 19001
1. DESIGN 1. QUALITY 5. DRAWN
2. REWORK 2. UATL 6. COSI
3. SCRAP/NEW 3. KINSPOVE 7. PINTS/
4. SCRAP NEW 4. LKRON SALES
New Form, add MRN, delete Fibreflex

©1989

FIBER SHEET GASKET MATERIAL		SIZE	TYPE
C 1000 3-27-80 1000 3-27-80 1000 3-27-80	 MARSHALLTOWN, IOWA	BY DATE DWN. Eynd 5-26-87 CHKD. BRIS 4-1-80 APVD. BR 4-1-80	DESIGN DWG. NO. REV.

CONFIDENTIAL

This laminated plant-fiber sheet is a suitable water, gasoline and oil resistant gasket material. It must meet ASTM specification D1170-54T, material Type J, Number 3211.

The following materials have been approved.

1. Cooper Manufacturing Company "Gaskoid"

VELLUMOID. NO. 505 (FEDERAL-MOGUL)

MAJOR REVISION 10-22-79
BY: GR CHKD: GR APVD: GR
FOR: OLD STOCK NO. REASON
1 - USE 1 - SAFETY 5 - SIZING
2 - REINFORCE 2 - W. MAIL 6 - COST
3 - SCRAP/REN 3 - IMPROVE
4 - ERROR
UP. DATE APPROVED MATL
G. DIXSON

Title: Fiber Sheet Gasket Material

SIZE

TYPE

FISHER

BY

DATE

FILE

UNRECORDED

DT

Fisher Controls

Material Specification

FMS 17F3

POLYTETRAFLUOROETHYLENE (PTFE)

Rev: (2) H

By: HM 6-9-88

Apvd: FEB 7-8-76

Page 1 of 1

FISHER**CONFIDENTIAL**

Fisher Controls 1982, (1989) 1991

Revised By: WHH (1-24-84)

B-22-21

1. SCOPE

This specification describes a general purpose PTFE material used in a variety of applications. Most common uses are seat discs, o-rings, seal rings, slides, diaphragm protectors, spacers, bellows, displacers and gaskets.

2. MATERIAL REFERENCE NO. (1624)

3. SPECIFICATIONS

(A) Composition: Material composed of virgin, unfilled PTFE (polytetrafluoroethylene), such as DuPont's Teflon 88. Material should comply with FDA regulations.

(b) Form: Bar, sheet stock or finished shapes.

(c) Process: Compression molded or ram extruded.

4. PHYSICAL PROPERTIES

Tensile Strength - ASTM D 1708
Elongation at fail - ASTM D 1708
Hardness - ASTM D 2240 (Type D)
Specific Gravity - ASTM D 792

2000-1000 PSI 3700 PSI, Minimum
200-100% 275% , Min.
50-55
2.13 to 2.18 2.19

AUG 20 1991

MAJOR REVISION

DATE
BY: WHH CHKD: RIF APVD: NFR
EGR: JLD/STOCK
1-2-88
2-REWORK
3-REWORK
4-REWORK
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add oxygen service MIN
change Properties to minimum

Fisher Controls		Material Specification		No. FNS 17F3	
FISHER POLYTETRAFLUOROETHYLENE (PTFE) TFE		By	HW	6-9-48	E
		Appd	DBB	7-8-76	
		Page	1	of	
Fisher Controls 1962 (1984) 1988		Rev	NRP	9-11-84	

CONFIDENTIAL

1. SCOPE

PTFE

This specification describes a general purpose TFE resin material used in a variety of applications. Most common uses are seat disks, o-rings, seal rings, slides, diaphragm protectors, spacers, bellows, displacers and gaskets.

2. MATERIAL REFERENCE NO. 0624

3. SPECIFICATIONS

Virgin, unfilled PTFE

(a) Composition: Material composed of unfilled TFE Resin (polytetrafluoroethylene).

(b) Form: Bar, sheet stock or finished shapes.

(c) Process: Compression molded or ram extruded.

4. TYPICAL PROPERTIES

Tensile Strength - ASTM D 1708	2000-4000 psi
Elongation at fail - ASTM D 1708	200-400%
Hardness - ASTM D 2240 (Type II)	60-65
Specific Gravity - ASTM D792	2.13 to 2.18

MAJOR REVISION

ECR/N NO. DATE APR 20 1989
 BY WHH CHKD DBB APVD NRP
 1. USE 1. SAFETY 5. STOCK
 2. REWORK 2. SALE 6. COST
 3. SCRAP/RECYCLE 3. APPROVE 7. WASTE
 4. SCRAP NOW 4. ENRGE 8. SALES
 Upgrade nomenclature.

 MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. ETS 17F3 (B)
	TFE	CONFIDENTIAL	BY HW 6-9-44
			APPROVED BY 7-8-73
			PAGE 1 OF 1
			REV MS 7-8-73

TFE
(TETRAFLUOROETHYLENE)

Tensile Strength at 77°F - 2000-4500 PSI
Elongation at 77°F (In 2 Inches) - 200-400%
Flexural Strength at 77°F - 2000 PSI
Hardness 50 - 65-65 Durometer "D"
Compressive Strength at 0.1% Deformation - 1700 PSI

ENGINEERING DEPT. DATE 1-27-76
MAJOR REVISION
BY AS CHKD. RR APPD. PLT
DISPOSITION OF OLD STOCK
UPDATE - MATL
SPEC

MAJOR REVISION PRINT
DO NOT REMOVE FROM
ENGINEERING FILES

Fisher Controls

Material Specification

FMS 17D32

SPECIAL GRAPHITE ENVIRO-SEAL™
PACKING RING

FISHER

Rev: **AC**
BY: **PLG** 7-14-92
Apvd: **NFR** 7-14-92
Page 1 of 1

Fisher Controls 1992

Revised By:

1. SCOPE

1.1 This specification covers flexible graphite and PTFE composite packing rings used in rotary Enviro-seal™ applications.

1.2 This standard includes reference to the following document:

- (a) ASTM D792 Standard Test Methods for Specific Gravity (Relative Density) and Density of Plastics by Displacement.

2. MATERIAL REFERENCE NO.

011Y

3. SPECIFICATIONS

- (a) This packing shall consist of six layers of flexible graphite (Grade GTK Grafoil), each nominally 0.030" thick, alternating with five layers of 0.005" thick PTFE sheet and bonded by hot pressing to achieve a total nominal thickness of 0.205".
- (b) Density of the sheet before die cutting rings shall be 78 lb/ft³ ± 5 lb/ft³.
- (c) The GTK Grafoil shall contain a non-metallic, inorganic, passivating inhibitor for corrosion and oxidation resistance.
- (d) Die cut packing ring diameters shall conform dimensionally to the appropriate drawing and shall have a density greater than 85 lb/ft³ and less than 95 lb/ft³.

4. DENSITY MEASUREMENT

The density of the ring material shall be measured in a manner similar to ASTM D792, except that the rings shall be coated with a thin film of petroleum jelly prior to weighing. This film prevents penetration of water into the packing rings which would cause erroneous displacement readings.

5. APPROVED SOURCE(S)

- (a) Sheet Material
UCAR Carbon Co.
Factory "A"
Cleveland, OH
Grade TG-314

- (b) Finished Rings
Cooper Mfg. Co.
Marshalltown, IA
Rings die cut from approved sheet stock.

MAJOR REVISION

ECRN No. **4161398** Date **5/10/97**
By **HLH** Chkd **FMD** Apvd **TGS**
840, Old Stock 800, Reason
1. USE 1. SAFETY 6. STOZN
2. REWORK 2. MATL 8. COST
3. SCRAP NEW 3. IMPROVE 7. MKTG
4. SCRAP NOW 4. ERROR SALES

Updated to the new electronic format. Any changes to appearance, paragraph numbering, etc., were to accommodate the new document format style. The appearance of the document will not be the same as before. NO CHANGES TO

ROA_03691

TAYLOR V. 3.M. COMPANY ET AL.
EISENBERG 000644

Fisher Controls

Material Specification

(B) FMS 17D31

DIE MOLDED GRAPHITE RIBBON SEAL RING
WITHOUT CORROSION INHIBITORS

Rev: A
By: BPF 12-10-90
Apvd: NFR 12-11-90
Page 1 of 1

FISHER

Fisher Controls 1990

Revised By:

1. SCOPE

This specification establishes a procedure for purchasing, handling and assembly of packing materials which must not contain more than 100 ppm leachable chlorides.

2. PACKING RING MATERIAL REFERENCE NO.

011V

3. CERTIFICATION BY VENDOR

Material must be tested for leachable chloride content per ASTM D512.

4. PACKAGING BY VENDOR

Items must be packaged (one per package) in sealed plastic bags or envelopes that will prevent contamination. Each package must be labeled on the outside that item(s) contained in the package are certified to contain not more than 100 ppm leachable chlorides. The part number(s) and a lot number must also be labeled on the package.

5. HANDLING

All parts made to conform to this specification shall be handled in a manner that will maintain chloride content within specified limits.

6. DIE MOLDED GRAPHITE RIBBON SEAL RING SPECIFICATIONS

(a) Graphite content 95%.

(b) Packing ring density - 90 lb./ft.³ ± 5 lb./ft.³.

(c) Must be made from Union Carbide graphite GTD material.

AUG 18 1997

7. APPROVED SUPPLIERS

(a) Argo Packing Company, Inc.
P. O. Box 66
Oakmont, PA 15139

(b) EGC Enterprises Incorp.
7315 Industrial Parkway
Mentor, OH 44060

MAJOR REVISION

ECRN No. 961398 Date 5/29/97
By HLL Chkd PMD Apvd TOG
810, Old Stock 830, Reason
1 USE 1 SAFETY 8 STDN
2 REWORK 2 MATL 8 COST
3 SCRAP/NEW 3 IMPROVE 7 MKTG
4 SCRAP NOW 4 ERROR 8 SALES

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ROA_03692

TAYLOR V. 3.M. COMPANY ET AL.

Fisher Controls

Material Specification

FMS 17D28

MOLDED COMPOSITION PACKING

REV: ~~2~~

By: NFR 2-17-86

Apvd: NFR 2-17-86

Page 1 of 1

FISHER**CONFIDENTIAL***Fisher Controls 1986, ~~1990~~ 1992

Revised By: W HH 4-4-90

9-30-92

1. SCOPE

This specification covers molded composition compound for use as valve stem packing. This packing specification was developed to replace molded "graphited asbestos" packings in applications where non-asbestos packings are required.

2. MATERIAL REFERENCE NO. 01873. COMPOSITION

Molded plastic ring packing made of synthetic fiber, flake graphite and a small percentage of neoprene binder. The packing shall not contain ~~any~~ asbestos in any form.

4. TEMPERATURE RANGE

0°F TO +450°F

5. APPROVED SOURCE(S)

(a) John Crane International
Morton Grove, IL 60053
Style No. 172E

(b) Crane Packing Ltd.
Slough, Berkshire, England
Style No. 996AR

MAY 27 1992

MAJOR REVISION

REV. NO.	BY	CHKD	DATE
1	W HH	726	4-4-90
2	W HH	726	4-4-90
3	W HH	726	4-4-90
4	W HH	726	4-4-90
5	W HH	726	4-4-90
6	W HH	726	4-4-90
7	W HH	726	4-4-90
8	W HH	726	4-4-90
9	W HH	726	4-4-90
10	W HH	726	4-4-90

CORRECT GRAMMATICAL SPERR

Fisher Controls	Material Specification	No.	FMS 17028	(A)
FISHER	MOLDED COMPOSITION PACKING	By	W H M	2-17-66
		Appd	NFR	2-17-66
		Page	1 of 1	
Fisher Controls 1986, 1988		Rev		

CONFIDENTIAL

1. SCOPE

This specification covers molded composition compound for use as valve stem packing. This packing specification was developed to replace molded "graphited asbestos" packings in applications where non-asbestos packings are required.

2. MATERIAL REFERENCE NO. 0181

3. COMPOSITION

Molded plastic ring packing made of synthetic fiber, flake graphite and a small percentage of neoprene binder. The packing shall not contain any asbestos in any form.

4. TEMPERATURE RANGE

0°F to +450°F

5. APPROVED SOURCE(S)

(a) John Crane - Houdaille
Morton Grove, Ill. 60053
Style No. 172E

(b) Crane Packing Ltd.
Slough, Berkshire, England
Style No. 55GAR

JAN 28 1966

MAJOR REVISION

FOR THE NO.	DATE
BY W H M	2-17-66
APPROVED	NFR
1 - 1000	
2 - 1000	
3 - 1000	
4 - 1000	
5 - 1000	
6 - 1000	
7 - 1000	
8 - 1000	

ADD additional mat'l

Fisher Controls

Material Specification

FMS 17027

BRAIDED HIGH TEMPERATURE
N06600 WIRE REINFORCED
COMPOSITION PACKING

Rev: B C
By: WHH 2-7-86
Apvd: NFR 2-7-86
Page 1 of 1

FISHER**CONFIDENTIAL***Fisher Controls 1986, 1988 1992Revised By: WHH 3-2-88

9-30-92

1. SCOPE

This specification covers composition valve stem packing that is reinforced with totally encapsulated N06600 alloy wire. This packing specification was developed to replace braided "Asbestos-Inconel-Graphite" packings in applications where non-asbestos packings are required.

2. MATERIAL REFERENCE NO. 01863. COMPOSITION

Square braided fiber packing containing N06600 wire reinforcing which is totally encapsulated to reduce stem scoring. Packing shall be furnished in ring form with bevel joint. It may contain solid lubricants such as graphite or tungsten disulfide and corrosion inhibiting additives. The packing shall not contain ~~any~~ asbestos in any form.

4. TEMPERATURE RANGE

0°F to + 750°F

5. APPROVED SOURCE(S)

- (a) Garlock - Mechanical Packing Div.
Sodus, NY 14551
Style No. 1200-PRI

MAY 27 1992

MAJOR REVISION

EDR/R NO. _____ DATE 9-30-92
BY WHH CHKD TSG APVD NFR
1. L. HOF 1. SAFETY 3. STON
2. HALL 5. COH
3. L. HOF 7. BVE/
4. L. HOF 8. BVE/
5. L. HOF 9. BVE/

CORRECT GRAMMATICAL ERROR

Fisher Controls

Material Specification

FMS 17D26

BRAIDED PTFE-COMPOSITION PACKING

Rev: **(A)**
By: **(F)**
Apvd: MFR 1-22-86
Page 1 of 1

FISHER

CONFIDENTIAL

Fisher Controls 1986, 1992

Revised By: MFR 4-30-92

1. SCOPE

This specification covers composition valve stem packing impregnated with PTFE (polytetrafluoroethylene). This packing specification was developed to replace FMS 17D8, PTFE - Asbestos packing, for applications where non-asbestos packings are required.

2. MATERIAL REFERENCE NO. 018N

3. COMPOSITION

Square braided fiber packing impregnated with PTFE dispersion and furnished in ring form with bevel joint. It may contain a small amount of break-in lubricant. The packing shall not contain asbestos in any form.

3.1 Packing should be reasonably clean and free from graphite.

4. TEMPERATURE RANGE

-100°F to 450°F

5. RESTRICTIONS

Packing should not be used for oxygen service. Packing should not be used outside pH range of 3 to 12.

6. APPROVED SOURCES

- (a) Garlock-Mechanical Packing Div.
Sodus, NY 14551
Style No. 8922
- (b) John Crane International
Morton Grove, IL 60053
Style No. KL760
- (c) Crane Packing Ltd.
Slough, Berkshire, England
Style No. 20AR

AUG 18 1997

MAJOR REVISION

ECRN No. 961398 Date 5/12/97
By HLH Chkd CHD Apvd 706
#40, Old Stock 1 400, Benson
1. WORK 1. SAFETY 5. STUEN
2. REWORK 2. MATH 6. COST
3. SCRAP NEW 3. SUPP/IVE 7. MKTOV
4. SCRAP NEW 4. ERROR 8. SALES

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FMS 1703

Rev: C
By: WHH 1-22-86
Apvd: NER 1-23-86
Page 1 of 1

CONFIDENTIAL

Revised By: WHH 1-14-88

This specification covers composition valve stem packing impregnated with PTFE (polytetrafluoroethylene). This packing specification was developed to replace FMS 1708 for applications where non-asbestos packings are required.

3. COMPOSITION

Square braided fiber packing impregnated with PTFE dispersion and furnished in ring form with bevel joint. It may contain a small amount of break-in lubricant. The packing shall not contain any asbestos in any form.

3.1 Packing should be reasonably clean and free from graphite.

4. TEMPERATURE RANGE

-100°F to 450°F

5. RESTRICTIONS

Packing should not be used for oxygen service. Packing should not be used outside pH range of 3 to 12.

6. APPROVED SOURCES

- (a) Garlock-Mechanical Packing Div.
Sodus, NY 14551
Style No. 8922
- (b) John Crane ~~Houdaille~~ ^{Exalta} International
Morton Grove, IL 60053
Style No. KI760
- (c) Crane Packing Ltd.
Slough, Berkshire, England
Style No. 20AR

APR 18 1990

MAJOR REVISION

ECR/H NO. _____ DATE _____

BY: WJH _____

WFO, OLD STAGE _____

1 - XEROX _____

2 - BUREAU _____

3 - SCRIPTURE _____

4 - SCRAP ROOM _____

5 - STICK _____

6 - COST _____

7 - MGRS/ _____

8 - SELLER _____

Update name of your

FM52-12/1

TAYLOR V. 3.M. COMPANY ET AL.

ROA 03697

Fisher Controls

Material Specification

No. FMS. 17025

SQUARE BRAIDED ASBESTOS - GRAPHITE PACKING
WITH INCONEL WIRE

By W.H.H. 11-11-85

FISHER

CONFIDENTIAL

APPROVED BY W.H.H. 11-11-85

Page 1 of 1

©Fisher Controls 1985

Rev

1. SCOPE

This specification covers an asbestos, Inconel, graphite compound for use as high temperature valve stem packing.

OBSOLETE

2. MATERIAL REFERENCE NO. Q19K3. COMPOSITION

Manufactured in square cross section by braiding an Inconel wire inserted, AAA grade asbestos jacket over a high temperature resistant asbestos graphite core. The packing is treated with a corrosion inhibitor and given a surface treatment of dry type lubricant and graphite.

4. TEMPERATURE RANGE

.0 to +750°F

5. APPROVED SOURCE

Argo Packing Co.
P.O. Box 66
Oakmont, PA 15139
Style No. 615

MAJOR REVISION APR 22 1987

ECR/H NO. BY W.H.H. CHKD DEC APVD W.H.H.
#40, OLD STOCK
1. X-USE 2. X-REASON
3. X-REASON 4. X-REASON
5. X-REASON 6. X-REASON
7. X-REASON 8. X-REASON
9. X-REASON 10. X-REASON
11. X-REASON 12. X-REASON
13. X-REASON 14. X-REASON
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17. X-REASON 18. X-REASON
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85. X-REASON 86. X-REASON
87. X-REASON 88. X-REASON
89. X-REASON 90. X-REASON
91. X-REASON 92. X-REASON
93. X-REASON 94. X-REASON
95. X-REASON 96. X-REASON
97. X-REASON 98. X-REASON
99. X-REASON 100. X-REASON

with 7-20-87
then scrap

Obsolete, see none.
Asbestos elimination program

Fisher Controls

Material Specification

FMS 17D24

25% CARBON FILLED PTFE PACKING

Rev: **(E)**
By: BR 9-14-81
Apvd: BR 9-14-81
Page 1 of 1

FISHER

CONFIDENTIAL

Fisher Controls 1981, 1991

Revised By: WEH 8-23-91

1. SCOPE

This specification covers 25% carbon filled PTFE adaptor rings for use as an antistatic device for rotary valves.

2. MATERIAL REFERENCE NO. 019V

3. SPECIFICATIONS

Composition: 25% carbon filled PTFE (by weight)

Electrical Surface Resistivity: ASTM D257: 15,000 ohms maximum

4. TEMPERATURE RANGE

-40° F to +450° F

5. APPROVED SOURCES

- (a) John Crane International
Morton Grove, IL 60053
- (b) Norton Performance Plastics
Elk Grove, IL 60007

MAJOR REVISION

ECRN No. 461398 Date 5/20/97
By HLH Chkd PMY Apvd TCG
840, Old Stock
1. VUSE
2. REWORK
3. SCRAP NEW
4. SCRAP NEW
5. D30, Rodson
6. SAFETY
7. MATL
8. PROOVE
9. ERROR
10. STDZ
11. CORT
12. MKTE
13. SALES

AUG 18 1997

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TO CONTENT.

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03699

Fisher Controls	Material Specification	No. FMS 17D24	B
	PTFE	By HOP	9-14-81
FISHER	25% CARBON FILLED (TFE) PACKING	Appd BR	9-14-81
		Page 1 of 1	
Fisher Controls 1981, 1983		Rev HOP	10-13-83

CONFIDENTIAL

1. SCOPE

This specification covers 25% carbon filled (TFE) adaptor rings for use as an antistatic device for rotary valves.

2. MATERIAL REFERENCE NO. 019V

3. SPECIFICATIONS

Composition: 25% carbon filled (TFE) (by weight)

Electrical Surface resistivity: ASTM D257: 15,000 ohms maximum

4. APPROVED SOURCES

John Crane, Halogen or Equivalent.

4. TEMPERATURE RANGE

-40°F to +450°F

MAJOR REVISION

DATE APR 22 1987

ECR/11 NO. BY WJH GSKD DRS APVD DHC
 1.8 DSK 1. TAPKEY 6. STORR
 2. BENTON 2. HILL 6. DODD
 3. SCRAP/STU 3. KAPRIVE 7. DZRL
 4. CROCK AMH 4. BARNH 8. BATES

Standardize mat'l. description
 Add temp. range

Fisher Controls

Material Specification

No. FMS 17022



 GRAPHITE FILAMENT YARN - LOW CHLORIDE
 (CERTIFIED LESS THAN 100 PPM)

CONFIDENTIAL

By L.L.B. 9-27-79

Appd. ENER 9-27-79

Page 1 of 1

©Fisher Controls 1986

Rev. NRP 9-19-86

1. SCOPE

OBSOLETE

This specification covers low chloride square braided graphite filament packing for use as valve stem packing usually in conjunction with laminated graphite packing rings.

2. MATERIAL REF. NO. - 0195

3. SPECIFICATIONS

Graphite Content----- 99%
 Chloride Content----- 100 PPM Maximum at 1000°F

4. CERTIFICATION BY VENDOR

Items purchased to this specification must be tested for leachable chloride per ASTM D512-67. The items must also be manufactured, processed and packaged in a manner which will justify certification. Each order must be certified that the requirements have been met.

5. PACKAGING BY VENDOR

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

6. HANDLING AND ASSEMBLY BY FISHER

Specially processed parts made to conform to this specification shall be handled in a manner that will maintain chloride content within specified limit when certification is required by customer specification.

7. APPROVED SOURCES

(a) Norton/Chemplast
 150 Dey Rd.
 Wayne, NJ 07470
 Style No. 2000

(b) John Crane - Houdaille, Inc.
 6400 Oakton St.
 Morton Grove, IL 60053
 Style No. 16256F

 OBSOLETE
 SUPPLEMENT
 ALL DWS, etc.
 FMS 17019

MAJOR REVISION

ECR/H NO. DATE FEB 27 1987

 BY RWH CHG R/L APVD NRP
 1. 10/1/87
 2. 11/1/87
 3. 12/1/87
 4. 1/1/88

Now covered in FMS 17019

10-2-79	MATERIAL SPECIFICATION	NO. FMS 17022
CONFIDENTIAL	GRAPHITE FILAMENT YARN - LOW CHLORIDE (CERTIFIED LESS THAN 100 PPM)	BY <u>PPB</u> 3-27-77
MARSHALLTOWN, IOWA		APVD <u>PPB</u> 4-27-77
		PAGE 1 OF 1
		REV

1. SCOPE

This specification covers low chloride square braided graphite filament packing for use as valve stem packing usually in conjunction with laminated graphite packing rings.

CONFIDENTIAL

2. Material Ref. No. - 0198

3. Specifications

Graphite Content ----- 99%
Chloride Content ----- 100 PPM Maximum at 1000°F

4. Certification by Vendor

Items purchased to this specification must be tested for leachable chloride per ASTM D312-67. The items must also be manufactured, processed and packaged in a manner which will justify certification. Each order must be certified that the requirements have been met.

5. Packaging by Vendor

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

6. Handling and Assembly by Fisher

Specially processed parts made to conform to this specification shall be handled in a manner that will maintain chloride content within specified limit when certification is required by customer specification.

7. Approved Sources

Accepted Types:

(a) Chemplast Style 2000
Chemplast, Inc.
16 Quince St.
Granford N.J. 07016

Norton/Chemplast
180 Day Rd.
Wayne, New Jersey 07470
Style No. 2000

(b) Azena Style 1625GF
Crane Packing Co.
6400 Oakton St.
Morton Grove, Ill. 60053

John Crane - Houdaille, Inc.
6400 Oakton St.
Morton Grove, Ill. 60053
Style No. 1625GF

MAJOR REVISION

ECR/R NO.	DATE
BY <u>PPB</u>	<u>3-27-77</u>
CHKD <u>W.H.H.</u>	<u>4-27-77</u>
APVD <u>PPB</u>	<u>4-27-77</u>

1. USE 1. SAFETY 5. SUPER
2. REWORK 2. MAIL 6. COST
3. REPAIR 3. IMPROVE 7. WAGE
4. REPAIR 4. REPAIR 8. SALES

SPECIFICATIONS INACTIVATED BY MISTAKE,
RE-ACR/VME (WHATEVER)

Fisher Controls

Material Specification

GRAPHITE LAMINATE PACKING WITH SACRIFICIAL
ZINC WASHER - LOW CHLORIDE
(CERTIFIED LESS THAN 100 PPM)

FISHER

No. FMS 17021

By LLE 9-27-79

APPROVED DATE 9-27-79

Page 2 of 2

Rev NRP 9-19-86

©Fisher Controls 1986

7. APPROVED SOURCE(S)

Union Carbide Corporation
Carbon Products Division
Trade Name - Grafoil Grade BTN

OBSOLETE CONFIDENTIAL

OBSOLETE
SUPERSEDED BY

FMS 17017
MRN 019A

JAN 05 1988

MAJOR REVISION

ECN/H NO. A 9440 DATE
BY RIZ CHRG. W. H. H. APVD. NAC
DO. W. H. H. 1. 2. 3. 4. 5. 6. 7.
1. 2. 3. 4. 5. 6. 7.
2. 3. 4. 5. 6. 7.
3. 4. 5. 6. 7.
4. 5. 6. 7.

obsolete

10-2-79
MARSHALLTOWN, IOWA

MATERIAL SPECIFICATION

GRAPHITE LAMINATE PACKING WITH SACRIFICIAL
ZINC WASHER - LOW CHLORIDE
(CERTIFIED LESS THAN 100 PPM)

FORM 17021
BY: [] DATE: []
APVD: []
PAGE 1 OF 1
KEY: []

1. SCOPE

This specification covers laminated graphite packing for use as valve stem packing usually in conjunction with braided graphite filament and rings.

2. Material Ref. No. - 019R

3. SPECIFICATIONS

Packing shall consist of a laminated graphite packing ring with one .004 thick sacrificial washer packaged with each ring of packing.

(a) Laminated Graphite Specifications

Graphite Content - 99%
Density - 70 LB/FT³
Certified leachable chloride content 100 PPM maximum.
Lamination perpendicular to shaft.

(b) Sacrificial Washer Specification

Material - Zinc ASTM B69 or Equivalent
Nominal Thickness - .004"
Nominal I.D. = Packing Ring I.D. + 1/8 in.
Nominal O.D. = Packing Ring O.D. - 1/16 in.
Washer may be split to ease installation.

4. Certification by Vendor

Items purchased to this specification must be tested for leachable chloride per ASTM B312-67. The items must also be manufactured, processed and packaged in a manner which will justify certification. Each order must be certified that the requirements have been met.

5. Packaging by Vendor

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

6. Handling and Assembly by Fisher

Specially processed parts made to conform to this specification shall be handled in a manner that will maintain chloride content within specified limit when certification is required by customer specification.

APPROVED SOURCE(S)

7. Accepted Type:

Union Carbide Corporation
Carbon Products Division
Trade Name - Grafoil Grade GTN

MAJOR REVISION

FOR/N NO: [] DATE: []
BY: NRP CHKD: NHH APVD: NRP
REASON: []
1. X USE 1. SAFETY 2. SIGHT
2. REVIEW 2. MAT. 3. COST
3. SUBMIT/REVISE 3. IMPROVE 7. WEIGHT
4. SCRAP/REWORK 4. THINER 8. SIZE
SPECIFICATIONS INACTIVATED
BY: [] REACTIVATE & UPDATE FORMAT

CONFIDENTIAL

 MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. FMS 17D20 BY JHS APPR <i>ZER</i> PAGE 1 OF 1 REV <i>20/21</i> 2-27-80
	GRAPHITE LAMINATE PACKING HIGH DENSITY - LOW CHLORIDE WITH SACRIFICIAL ZINC WASHER		6-15-78 2-18-78

OBSOLETE CONFIDENTIAL

Material Reference No. 019P

Packing shall consist of a laminated graphite packing ring with one .004 thick sacrificial washer packaged with each ring of packing.

CERTIFICATION, PACKING AND ASSEMBLY REQUIRED PER FMS 17D16

Laminated Graphite Specifications

Graphite Content ----- 99%
 Density ----- 105 LB/FT³
 Certified leachables chloride content 100 PPM maximum
 Lamination perpendicular to shaft

Sacrificial Washer Specification

Material - Zinc ASTM B69 or equivalent
 Nominal Thickness - .004
 Nominal I.D. - Packing Ring I.D. + 1/8 in.
 Nominal O.D. - Packing Ring O.D. - 1/16 in.
 Washer may be split to ease installation.

OBSOLETE
SUPERSEDED BY

FMS 17D17

MRN 019P

Approved Material:

Union Carbide Corporation
 Carbon Products Division
 Trade Name - Urafoil

JAN 05 1988

MAJOR REVISION

ECR/R NO. *A9440* DATE
 BY *RLT* CHECKED *WHL* APPROVED *VER*
 1 - DESIGN 1 - SKETCH 3 - DESIGN
 2 - DRAWING 2 - REVIEW 4 - DESIGN
 3 - CHECKED 3 - X-REFS 7 - DESIGN
 4 - SIGNATURE 4 - DESIGN

Obsolete

Fisher Controls

Material Specification

FMS 17019

GRAINED GRAPHITE FILAMENT PACKING
WITH LOW IMPURITIES**FISHER**Rev: 1
By: 10-2-77
App'd: 10-2-77
Page: 2 of 2

Fisher Controls 1982, 1985

Revised by: 10-2-77

- (c) Gaskets used to construct the bonded outer jacket shall be composed of continuous graphite filament.

- (d) The bonded filament packing shall not contain any asbestos.

4. GENERAL RANGE OF GRAINED GRAPHITE FILAMENT PACKING RINGS

These packing rings shall be suitable for general purpose usage as anti-extrusion and valve stem outer rings in conjunction with graphite packing seal rings. They shall also be suitable for use in the petroleum, fossil and nuclear fueled power generation, chemical, and general process type industries. They must also be suitable for use at temperatures up to 700° F in machine workmanship and from 700° F to 1000° F in non-machining environments.

5. CERTIFICATION BY VENDOR

The packing must be manufactured, processed and handled in a manner that will allow certification. When certification is specified on the purchase order, the lot of packing material must be tested for the elements listed in 3 (a) above. A copy of the chemical analysis must accompany each individual order and/or package when certification is specified.

6. PACKAGING BY VENDOR

Packing rings must be individually packaged in sealed plastic bags or envelopes which will prevent contamination. All packing must be labeled with the date of manufacture.

7. PACKING AND ASSEMBLY

All packing made to conform to this specification shall be handled in a manner that will maintain low impurity contents as required.

8. QUALITY

The manufacturer of the packing shall be required to guarantee: (1) dimensional compliance to appropriate Fisher drawings and (2) compliance to this specification.

9. APPROVED SOURCES

- (a) WIP, Inc.
1802 Main St.
Chambersburg, PA 17211
(412) 784-4113
Attn: Style 1524 Nuclear Graphite Filament Worn Packing
- (b) John Crane International
5425 Willow Creek Dr. SW
Olathe, Kansas, IA 52404
(319) 364-2174
Style 1524 Nuclear Service Graphite Filament Worn Packing

Fisher Controls

Material Specification

FMS 17019

GRAINED GRAPHITE FILAMENT PACKING
WITH LOW IMPURITIES
AND FITE LUBRICATION**FISHER**Rev: 1
By: 10-2-77
App'd: 10-2-77
Page: 2 of 2

Fisher Controls 1982, 1985

Revised by: 10-2-77

8. QUALITY

The manufacturer of the packing shall be required to guarantee:

1. dimensional compliance to appropriate Fisher drawings and

2. compliance to this specification.

9. APPROVED SOURCES

- (a) Arpa Packing Company
Olathe, PA 17033
Fisher Style 1524

MAJOR REVISION Date: 5-7-86

See Cover Sheet Revision

H to J
for change information

CONFIDENTIAL

ROA_03706

TAYLOR V. 3.M. COMPANY ET AL.
FISHER 000611

Fisher Controls

Material Specification

FMS 17019

BRAIDED GRAPHITE FILAMENT PACKING

FISHER

CONFIDENTIAL

Rev: G
By: EE 2-9-77
Apvd: R2 2-16-77
Page 2 of 2

*Fisher Controls 1982, 1989

Revised By: W H H 6-1-89

7. HANDLING AND ASSEMBLY

All packing made to conform to this specification shall be handled in a manner that will maintain low chloride content as required by the particular application.

8. QUALITY

The manufacturer of the packing shall be required to guarantee, (1) dimensional compliance to appropriate Fisher drawings and (2) compliance to this specification.

9. APPROVED SOURCES

- (a) Argo Packing Company
Calumet, Pennsylvania 15139
(packing style 525)

MAY 02 1991

MINOR CHANGE

BY W H H CHD. BY DRG

DATE _____ ENGINEERING DEPT.

correct spelling

BRAIDED GRAPHITE FILAMENT PACKING
WITH LOW IM PURITIESREV: 5N
By: EE 2-9-77
Apvd: RZ 2-16-77
Page 1 of 2

FISHER

CONFIDENTIAL

Fisher Controls 1982, 1989

Revised By: WTHH 6-7-94

TDC 6-7-94

1. SCOPE

This specification covers braided graphite filament packing for use as valve stem packing, usually in conjunction with laminated or ribbon graphite packing rings.

1.1 This specification includes reference to the following documents:

2. MATERIAL REFERENCE NOS.

- 0159 Low Purity Graphite Filament Packing, Mechanical Properties Limits.
0196 Low Chloride Packing
0198 Packing-Certified to less than 100 ppm-leachable chloride
Certified Low Purity Graphite Filament Packing

3. SPECIFICATIONS

- (a) Packing Impurities shall not exceed limits as shown in the following table:
(b) The braided filament packing shall exhibit less than 25% weight loss when samples are subjected to a 1200° F. nitrogen environment for three and one half hours.
(c) Yarns used to construct the braided outer jacket shall be composed of continuous graphite filament.
(d) The braided filament packing shall not contain any asbestos.

4. GENERAL USAGE OF BRAIDED GRAPHITE FILAMENT PACKING RINGS

These packing rings shall be suitable for general purpose usage as well as extrusion and valve stem wiper rings in conjunction with graphite packing seal rings. They shall also be suitable for use in the petroleum, power generation, chemical, and general process type industries. They must also be suitable for use at temperatures up to 700° F. in oxidizing environments and from 700° F. to 1000° F. in non-oxidizing environments.

5. CERTIFICATION BY VENDOR

When certification is required, the packing must be tested for leachable chloride content per ASTM D512. The packing must be manufactured, processed, and handled in a manner that will allow certification.

6. PACKAGING BY VENDOR

Packing rings must be individually packaged in sealed plastic bags or envelopes which will prevent contamination. Certified low-chloride packing must be labeled as such. All packing must be labeled with the date of manufacture.

MAJOR REVISION

FMSI-10/1

DRAWING NO. 40911 DATE 6-10-94

BY TDC CHD D.B. APVD J.L.C.

JUN 14 1994

INCLUDED
PRODUCTION OF
HALLS, WINTER
MATERIALS, SULFUR
1. ... MATERIALS

1. SAFETY 3. STRENGTH
2. HAZARD 4. COST
3. IMPROVE 5. MAINTENANCE
4. ...

Fisher Controls

Material Specification

FMS 17D19

BRAIDED GRAPHITE FILAMENT PACKING

FISHER**CONFIDENTIAL**
 REV: 7
 By: EN 2-9-77
 Apvd: RZ 2-16-77
 Page 1 of 2
Fisher Controls 1982, 1987 1989Revised By: ...

1. SCOPE

This specification covers braided graphite filament packing for use as valve stem packing, usually in conjunction with laminated or ribbon graphite packing rings.

2. MATERIAL REFERENCE NOS.

- 0190 Low Chloride Packing
- 0198 Packing Certified to less than 100 ppm leachable chloride

3. SPECIFICATIONS

- (a) Leachable chloride content shall not exceed 100 ppm.
- (b) The braided filament packing shall exhibit less than 25% weight loss when samples are subjected to a 1200° F. nitrogen environment for three and one half hours.
- (c) Yarns used to construct the braided outer jacket shall be composed of continuous graphite filament.
- (d) The braided filament packing shall not contain any asbestos.

4. GENERAL USAGE OF BRAIDED GRAPHITE FILAMENT PACKING RINGS

These packing rings shall be suitable for general purpose usage as anti extrusion and valve stem wiper rings in conjunction with graphite packing seal rings. They shall also be suitable for use in the petroleum, power generation, chemical, and general process type industries. They must also be suitable for use at temperatures up to 700° F. in oxidizing environments and from 700° F. to 1200° F. in non-oxidizing environments.

5. CERTIFICATION BY VENDOR

When certification is required, the packing must be tested for leachable chloride content per ASTM D512. The packing must be manufactured, processed, and handled in a manner that will allow certification.

6. PACKAGING BY VENDOR

Packing rings must be individually packaged in sealed plastic bags or envelopes which will prevent contamination. Certified low chloride packing must be labeled as such. All packing must be labeled with the date of manufacture.

MAJOR REVISION

ECR/N NO.	DATE
BY <u>WNH</u>	CHKD <u>LOS</u> APVD <u>NCR</u>
848, OLD STOCK	530, RELEASE
1. <u>NOTE</u>	1. <u>SAFETY</u>
2. <u>REPAIR</u>	2. <u>WMI</u>
3. <u>REPAIR/REWORK</u>	3. <u>APPROVE</u>
4. <u>REPAIR/REWORK</u>	4. <u>REWORK</u>
5. <u>STUDY</u>	6. <u>COM</u>
7. <u>CRITIC</u>	8. <u>SAFETY</u>

Change Max. Rec. Form.

JUN 8 1988

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03709

Fisher Controls

Material Specification

No. FNS 17019

BRAIDED GRAPHITE FILAMENT PACKING

FISHER

CONFIDENTIAL

By EE 2-9-77

Apvd RE 2-16-77

Page 1 of 2

Fisher Controls 1282, 1287

Rev R17 5-7-87

1. SCOPE

This specification covers braided graphite filament packing for use as valve stem packing, usually in conjunction with laminated or ribbon graphite packing rings.

MAJOR REVISION OCT 08 1987

2. MATERIAL REFERENCE NOS.

- 0190 Low Chloride Packing
0195 Packing Certified to less than 100 ppm leachable chloride

ECR/H NO. A8557 DATE
BY RLT CHKD MHH APVD WFR
#10, OLD STOCK
1 - USE
2 - RETURN
3 - REPAIR/REWORK
4 - REPAIR/REWORK
5 - SAFETY
6 - HAZL
7 - IMPROVE
8 - ERROR
9 - SERIAL
10 - COST
11 - MISC
12 - SALES

3. SPECIFICATIONS

Deleted One supplier

- (a) Leachable chloride content shall not exceed 100 ppm.
(b) The braided filament packing shall exhibit less than 25% weight loss when samples are subjected to a 1200° F. nitrogen environment for three and one half hours.
(c) Yarns used to construct the braided outer jacket shall be composed of continuous graphite filament.
(d) The braided filament packing shall not contain any asbestos.

4. GENERAL USAGE OF BRAIDED GRAPHITE FILAMENT PACKING RINGS

These packing rings shall be suitable for general purpose usage as anti extrusion and valve stem wiper rings in conjunction with graphite packing seal rings. They shall also be suitable for use in the petroleum, power generation, chemical, and general process type industries. They must also be suitable for use at temperatures up to 700° F. in oxidizing environments and from 700° F. to 1200° F. in non-oxidizing environments.

5. CERTIFICATION BY VENDOR

When certification is required, the packing must be tested for leachable chloride content per ASTM D512. The packing must be manufactured, processed, and handled in a manner that will allow certification.

6. PACKAGING BY VENDOR

Packing rings must be individually packaged in sealed plastic bags or envelopes which will prevent contamination. Certified low chloride packing must be labeled as such. All packing must be labeled with the date of manufacture.

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03710

Fisher Controls

General Specification

No. FMS 17019

BRAIDED GRAPHITE FILAMENT PACKING

FISHER**CONFIDENTIAL**

By EEE 2-9-77

Appd. RB 2-16-77

Page 1 of 2

©Fisher Controls 1982, 1987

Rev. R17 2-12-87

1. SCOPE

This specification covers braided graphite filament packing for use as valve stem packing, usually in conjunction with laminated or ribbon graphite packing rings.

MAJOR REVISION MAY 13 198

2. MATERIAL REFERENCE NOS.

- 0190 Low Chloride Packing
0195 Packing Certified to less than
100 ppm leachable chloride

ECN/NO. DATE
BY RLB EXCHD. WITH REV'D NFR
12-8-8
2-11-87
3-1-87
4-1-87
5-1-87
6-1-87
7-1-87
8-1-87
9-1-87
10-1-87
11-1-87
12-1-87

ADD 2ND SOURCE

3. SPECIFICATIONS

- (a) Leachable chloride content shall not exceed 100 ppm.
(b) The braided filament packing shall exhibit less than 25% weight loss when samples are subjected to a 1200° F. nitrogen environment for three and one half hours.
(c) Yarns used to construct the braided outer jacket shall be composed of continuous graphite filament.
(d) The braided filament packing shall not contain any asbestos.

4. GENERAL USAGE OF BRAIDED GRAPHITE FILAMENT PACKING RINGS

These packing rings shall be suitable for general purpose usage as anti-extrusion and valve stem wiper rings in conjunction with graphite packing seal rings. They shall also be suitable for use in the petroleum, power generation, chemical, and general process type industries. They must also be suitable for use at temperatures up to 700° F. in oxidizing environments and from 700° F. to 1200° F. in non-oxidizing environments.

5. CERTIFICATION BY VENDOR

When certification is required, the packing must be tested for leachable chloride content per ASTM D612. The packing must be manufactured, processed, and handled in a manner that will allow certification.

6. PACKAGING BY VENDOR

Packing rings must be individually packaged in sealed plastic bags or envelopes which will prevent contamination. Certified low chloride packing must be labeled as such. All packing must be labeled with the date of manufacture.

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03711

 FISHER Controls MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. FMS 17D19.3
	GRAPHITE FILAMENT YARN - LOW CHLORIDE		BY EE 2-9-77
			APVD. EE 2-9-77
			PAGE 1 OF 1
			REV 016 4-25-77

Material Reference No. 0190

Certification, Packing and Assembly Required Per FMS 17D16

Specifications

Graphite Content ----- 99%
 Chloride Content ----- 200 TPH Maximum at 1,000 °F

Accepted Types:

Olempro Style 2000
 Champro, Inc.
 16 Quince St.
 Cranford N.J. 07016

Crane Style 16250F
 Crane Packing Co.
 6400 Oakton St.
 Morton Grove, Ill. 60053

MAJOR REVISION
 BY **EE** 2-9-77 APVD **EE** 2-9-77
 1 - REMACHINE 1 - SAFETY 1 - SIZING
 2 - REMACHINE 2 - MATE 2 - OIL
 3 - SCRAP NEW 3 - IMPROVE 3 - B 3/
 4 - SCRAP NEW 4 - ERROR 4 - S
 Update to new format

1. SCOPE

This specification covers square braided graphite filament packing for use as valve stem packing usually in conjunction with laminated graphite packing rings.

2. MATERIAL REFERENCE NO. 0190

3. SPECIFICATIONS

- (a) Graphite content - 99% min.
- (b) Chloride content - 200 ppm max. at 1000°F

4. SPECIAL HANDLING

Certification, packaging, handling and assembling required per FMS 17D16

5. APPROVED SOURCES

(a) Chemplast Inc.
 Seal and Packing Div.
 Clark, NJ 07066

(b) Crane Packing Co.
 Mechanical Packing Div.
 Morton Grove, Ill. 60053



MATERIAL SPECIFICATION

GRAPHITE LAMINATE PACKING
HIGH DENSITY - LOW CHLORIDE

NO.	FMS 17D18
BY	EE 2-9-77
APVD	OKS 2-16-77
PAGE	1 OF 1
REV	JHS 6-16-78

Material Reference No. 019H

OBsolete

CONFIDENTIAL

CERTIFICATION, PACKING AND ASSEMBLY REQUIRED PER FMS 17D16

Laminated Graphite Specifications

Graphite Content ----- 99%
Density ----- 105 LB/FT³
Certified leachable chloride content 200 PPM maximum
Lamination perpendicular to shaft.

OBsolete
SUPERSEDED BY

FMS 17D17

MRN 019H

Approved Material

Union Carbide Corporation
Carbon Products Division
Trade Name - Grafoil

JAN 05 1988

MAJOR REVISION

ECR/N NO. A 9440 DATED
BY RLZ CHECKED WHL APVD NFR
1. REVIS 2. REVIS 3. REVIS 4. REVIS 5. REVIS
6. REVIS 7. REVIS 8. REVIS 9. REVIS
10. REVIS 11. REVIS 12. REVIS

obsolete

 FISHER Controls MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. FMS 17D16 3
	GRAPHITE LAMINATE PACKING HIGH DENSITY - LOW CHLORIDE		BY EE 2-9-77
			APVD <i>CHS</i> 2-16-77
	PAGE 1 OF 1		
	REV <i>CHS</i> 1-30-79		

Material Reference No. '019E

CONFIDENTIAL

CERTIFICATION, PACKING AND ASSEMBLY REQUIRED PER FMS 17D16

Laminated Graphite Specifications

Graphite Content ----- 99%
 Density ----- 105 LB/FT³
 Certified leachable chloride content 200 PPM maximum
 Lamination perpendicular to shaft.

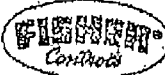
Approved Materials:

Union Carbide Corporation
 Carbon Products Division
 Trade Name - Grafoil

SACRIFICIAL WASHER SPECIFICATION:

MATERIAL - ZINC ASTM B69 OR EQUIVALENT
 NOMINAL THICKNESS ± .004
 NOMINAL I.D. = PACKING RING I.D. + $\frac{1}{8}$ IN.
 NOMINAL O.D. = PACKING RING O.D. - $\frac{1}{16}$ IN.
 WASHER MAY BE SPLIT TO EASE INSTALLATION

MAJOR REVISION *6-5-78*
 BY *CHS* CHND *CHS* APVD *CHS*
 OLD STOCK ☒ NEW REASON
 1. ☒ USE 1. SUPPLY 1. STRIP
 2. ☒ REFINISH 2. MATL 2. STRIP
 3. ☒ SCRAP/NEW 3. IMPROVE 3. STRIP
 4. ☒ SCRAP NOW 4. ERROR 4. STRIP
**NEED CLOSER CONTROL
 OF ZINC RINGS**

 MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. FMS 17D16	B
	GRAPHITE LAMINATE PACKING HIGH DENSITY - LOW CHLORIDE		BY EE	2-9-77
			APVD <i>WON</i>	2-16-77
			PAGE 1 OF 1	
		REV	WON	6-15-77

Material Reference No. 019H

CONFIDENTIAL

CERTIFICATION, PACKING AND ASSEMBLY REQUIRED PER FMS 17D16

Laminated Graphite Specifications:

Graphite Content ----- 99%
 Density ----- 10.12 g/cc
 Certified leachable chloride content 200 PPM maximum at 1000°F.
 Lamination perpendicular to shaft.

Approved Materials:

Union Carbide Corporation
 Carbon Products Division
 Trade Name - Grafoil

MAJOR REVISION 10-3-77
 BY *WON* CKD *WON* APVD *WON*
 1. SAFETY 5
 2. SAN 6
 3. ENV. 500
 4. CRASH
 REASON: clarification

Fisher Controls

Material Specification

FMS 17D17

GRAPHITE LAMINATE PACKING

FISHER
 Rev: 1
 By: EDH 5-18-76
 Apvd: RTW 9-10-76
 Page 1 of 2

Fisher Controls 1976, 1991

Revised By: WHH 10-10-91

CONFIDENTIAL**1. SCOPE**

This specification establishes a procedure for purchasing, handling and assembly of packing materials which must not contain more than 100 parts per million leachable chlorides.

2. CERTIFICATION BY VENDOR

Material must be tested for leachable chloride content per ASTM D512.

3. PACKAGING BY VENDOR

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination. Each bag or envelope must be labeled on the outside that each item is certified to contain not more than 100 parts per million leachable chloride content.

4. HANDLING AND ASSEMBLY

All parts made to conform to this specification shall be handled in a manner that will maintain chloride content within specified limits.

5. LAMINATED GRAPHITE PACKING RING (OR ASSEMBLY) SPECIFICATIONS

- (a) Laminations perpendicular to shaft
- (b) Graphite content—95% minimum
- (c) Packing ring density—see following table
- (d) Zinc washers—see following table

- (1) Material—Zinc ASTM B69 or Equivalent
- (2) Nominal Thickness = 0.004 inches
- (3) Nominal I.D. = Packing Ring I.D. + 1/16 Inch
- (4) Nominal O.D. = Packing Ring O.D. - 1/32 Inch
- (5) Washer may be split to ease installation
- (6) When zinc rings are required one zinc ring must with each graphite packing ring

MAJOR REVISIONECRN No. 941398 Date 5/21/91By WHH Chkd PMH Apvd 706

640 CH Stock	800, Reason
1 USE	1 SAFETY 8, STCZN
2 REWORK	5 MATL 6, COST
3 SCRAP NEW	6 IMPROVE 7, MKTG
4 SCRAP NOT	4 ERROR 9, SALES

AUG 18 1997

Updated to the new electronic format.
 Any changes to appearance, paragraph numbering, etc., were to accommodate the new document format style. The appearance of the document will not be the same as before. NO CHANGES TO CONTENT.

ROA_03716

TAYLOR V. B.M. COMPANY ET AL.

Fisher Controls

Material Specification

FMS 17D17

GRAPHITE LAMINATE PACKING

Rev: ~~2~~ 3

By: PWR 6-15-76

Apvd: RTW 9-10-76

Page 1 of 2

FISHER**CONFIDENTIAL**

*Fisher Controls 1S76, 1991

Revised By: ~~WHH~~ 4-30-91

10-10-91

1. SCOPE

This specification establishes a procedure for purchasing, handling and assembly of packing materials which must not contain more than 100 parts per million leachable chlorides.

2. CERTIFICATION BY VENDOR

Material must be tested for leachable chloride content per ASTM D512.

3. PACKAGING BY VENDOR

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination. Each bag or envelope must be labeled on the outside that each item is certified to contain not more than 100 parts per million leachable chloride content.

4. HANDLING AND ASSEMBLY

All parts made to conform to this specification shall be handled in a manner that will maintain chloride content within specified limits.

5. LAMINATED GRAPHITE PACKING RING (OR ASSEMBLY) SPECIFICATIONS

- (a) Laminations perpendicular to shaft
- (b) Graphite content ~~95%~~ 95% minimum
- (c) Packing ring density—see following table
- (d) Zinc washers—see following table

- (1) Material—Zinc ASTM B69 or Equivalent
- (2) Nominal Thickness = 0.004 Inches
- (3) Nominal I.D. = Packing Ring I.D. + 1/16 Inch
- (4) Nominal O.D. = Packing Ring O.D. - 1/32 Inch
- (5) Washer may be split to ease installation
- (6) When zinc rings are required one zinc ring must be packaged with each graphite packing ring.

OCT 30 1991

MAJOR REVISION

ECR/H NO.	DATE
BY ~~WHH~~ CHD ~~709~~ APVD ~~M R~~	
848 OLD STOCK	1. SAFETY
1. ~~WHH~~	2. ~~WHH~~
2. ~~WHH~~	3. ~~WHH~~
3. ~~WHH~~	4. ~~WHH~~
4. ~~WHH~~	5. ~~WHH~~
	6. ~~WHH~~
	7. ~~WHH~~
	8. ~~WHH~~

Change min. graphite content,
update vendor name.

Fisher Controls

Material Specification

FMS 17D17

GRAPHITE LAMINATE PACKING

 Rev: **CF**
 By: HDB 6-15-76
 Apvd: RTW 9-10-76
 Page 1 of 2
FISHER**CONFIDENTIAL**

Fisher Controls 1976, 1987, 1991

Revised By: **R/T 12-7-87**

W.H. 4-30-91

1. SCOPE

This specification establishes a procedure for purchasing, handling and assembly of packing materials which must not contain more than 100 parts per million leachable chlorides.

2. CERTIFICATION BY VENDOR

Material must be tested for leachable chloride content per ASTM D513.

3. PACKAGING BY VENDOR

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination. Each bag or envelope must be labeled on the outside that each item is certified to contain not more than 100 parts per million leachable chloride content.

4. HANDLING AND ASSEMBLY

All parts made to conform to this specification shall be handled in a manner that will maintain chloride content within specified limits.

5. LAMINATED GRAPHITE PACKING RING (OR ASSEMBLY) SPECIFICATIONS

- (a) Laminations perpendicular to shaft.
- (b) Graphite content—99%
- (c) Packing Ring Density—see following table
- (d) Zinc Washers—see following table

- (1) Material—Zinc ASTM B69 or Equivalent
- (2) Nominal Thickness = 0.004 Inches
- (3) Nominal I.D. = Packing Ring I.D. + 0.010 Inch
- (4) Nominal O.D. = Packing Ring O.D. - 0.010 Inch
- (5) Washer may be split to ease installation
- (6) When zinc rings are required one zinc ring must be packaged with each graphite packing ring

MAY 24 1991

MAJOR REVISION

ECR/NO.	DATE
BY: WHH	CHKD: DBB
APVD: NFR	
NO. IN STOCK	REASON
1. EXIST	1. SAFETY
2. NEW/REV	2. MATL
3. SCRAP/REV	3. IMPROVE
4. SCRAP/NOV	4. ERROR
	5. STOR
	6. COST
	7. MFG/SALES

Change tolerances on zinc washer



MATERIAL SPECIFICATION

GRAPHITE LAMINATE PACKING WITH SACRIFICIAL
ZINC WASHER - LOW CHLORIDE

NO. ENG 17017
BY WDA 6-15-76
APVD RTW 7-10-76
PAGE 1 OF 1
REV JHS 1-30-78

CONFIDENTIAL

Packing shall consist of a laminated graphite packing ring with one .004 thick sacrificial washer packaged with each ring of packing.

CERTIFICATION, PACKING AND ASSEMBLY REQUIRED PER ENG 17016

Laminated Graphite Specifications

Graphite Content 99%
Density 70 LB/PT³
Certified leachable chloride content 200 PPM maximum.
Lamination perpendicular to shaft.

Sacrificial Washer Specification

Material - Zinc ASTM B69 or Equivalent

NOMINAL

Thickness - .004"

NOMINAL I.D. = PACKING RING I.D. + $\frac{1}{8}$ IN.

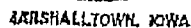
NOMINAL O.D. = PACKING RING O.D. - $\frac{1}{16}$ IN.

WASHER MAY BE SPLIT ~~TO~~ TO EASE INSTALLATION

Approved Material:

Union Carbide Corporation
Carbon Products Division
Trade Name - Grafoil Grade GTN

MAJOR REVISION - 6-5-78
BY WDA CHKD JHS APVD RTW
840, DRD STICK
EX USE
2 - REMACHINZ
3 - SCRAP/REH
4 - SCRAP WOH
DO, REASON
1 - SAFETY
2 - MAIL
3 - IMPROVE
4 - CRUD
5 - STUDEN
6 - COST
NEED CLOSER CONTROL
OF ZINC RINGS



GRAPHITE LAMINATE PACKING WITH SACRIFICIAL
ZINC WASHER - LOW CHLORIDE

NO.		FMS 17D17		(A)	
BY WDH		6-15-76			
APYD: RTW		9-16-76			
PAGE 1		OF 1			
REV					

CONFIDENTIAL

Union Carbide Corporation :
Carbon Products Division
Trade Name - Grafoil Grade GTN

MAJOR REVISION 10-3-7
BY CH CHND 76 AMYD 62
1-4 GLENN 62 62 62
1-1 62 62 62
2-1 ATTACHURE 62 62 62
2-2 62 62 62
2-3 62 62 62
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CONFIDENTIAL

Specification for Flexible Graphite
Packaging Rings With Low Concentrations

Rev: ^Y
BY: TDC 6-23-6
Apd: NFA 6-23-6
Page 2 of 2

FISHER

New Spec

*Fisher Controls

Revised By:

1. CERTIFICATION BY VENDOR

The packing must be manufactured, processed and handled in a manner that will allow certification. When certification is specified on the purchase order, the lot of packing material must be tested for the elements listed in 3 (c) above. A copy of the chemical analysis must accompany each individual order and/or package when certification is specified.

5. PACKAGING BY VENDOR

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and marked on the outside of the package to indicate that they have been specially processed. The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

6. PACKAGING AND ASSEMBLY

Specially processed parts made to conform to this specification shall be handled in a manner that will maintain integrity contact within specified the limit whether or not certification is required by customer specification.

7. APPROVED MATERIALS

- (a) UGAR Carbon Co., Inc.
P.O. Box 94637
Cleveland, OH 44161
(216) 529-3777
UGAR Grades G1A or G1B
- (b) ROC Enterprises, Inc.
7125 Industrial Parkway
Mentor, OH 44060
(216) 946-2210
UGAR Graphite Grades G1A or G1B
- (c) RSP, Inc.
1801 Main St.
Shanghaung, PA 15215
(412) 794-8415
Style #6109 Rings from UGAR Graphite Grades G1A or G1B

MAJOR REVISION DATE 6-10-79
FOR MAJOR REVISION STAMP
INFORMATION SEE COVER SHEET
REVISION 4 TO 1

ROA_03721

TAYLOR V. 3.M. COMPANY ET AL.
FISHER 000581

FMS 17F48

Rev: PG
By: WMR 11-8-85
Apvd: NFR 11-8-85
Page 1 of 1

*Fisher Controls 1985, 1990 1991

Revised By: WPHC 11-28-90

$$\{z_n = |q| + \alpha\}$$

1. 500PZ

This document describes a metal foil reinforced sheet graphite material, typically used for gasketing.

2. MATERIAL REFERENCE NO.

994E - Standard

994Y - Certified less than 100 ppm leachable chloride per FMS 17F4J.

3. SPECIFICATIONS

- (a) Composition: Graphite, $\geq 95\%$ with S31600 foil insert, 0.002 inches thick.
- (b) Thickness: $0.031 \pm .005$ inches.
- (c) Density: 70 lbs/cu. ft. graphite only.
- (d) Max. temperature limits: 300°F oxidizing media*
1300°F inert media

*Note: For oxygen service use FMS 17749

4. ACCEPTED SOURCES

- (p) Union Carbide Carbon Products Div.
Cleveland, OH
Style No. GMR
- (b) EGC Enterprises, Inc.
Mentor, OH
- (c) Flexitallic Gaskets Co.
6440 Remington Ave.
Pennsauken, NJ 08110
- USAR Carbon Co., Inc.
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- EUR/N NO. _____
BY WHH CHKD J
N TIAN

JAN 20 1972

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Update Vendor Name

Fisher Controls

Material Specification

FMS 17F46

METAL FOIL INSERT GRAPHITE
GASKET MATERIAL

Rev: EE
By: WWH 11-8-85
Apvd: NFR 11-8-85
Page 1 of 1

FISHER

*Fisher Controls 1985, 1990

Revised By: WWH P-27-90

CONFIDENTIAL

1. SCOPE

This document describes a metal foil reinforced sheet graphite material, typically used for gasketing.

2. MATERIAL REFERENCE NO.

994E - Standard

994Y - Certified less than 100 ppm leachable chloride per FMS 17F43.

3. SPECIFICATIONS

- (a) Composition: Graphite, 99% with 531600 foil insert, 0.002 inches thick.
- (b) Thickness: $0.031 \pm .005$ inches.
- (c) Density: 70 lbs/cu. ft. graphite only.
- (d) Max. temperature limits: 800°F oxidizing media;
1500°F inert media

*Note: For oxygen service use FMS 17F49

4. ACCEPTED SOURCES

- (a) Union Carbide
Carbon Products Div.
Cleveland, OH
Style No. GSR
- (b) EGC Enterprises, Inc.
Mentor, OH
- (c) Flexitall Gaskets Co.
Bellmore, NJ
Flexicarb SR

OCT 04 1989

MAJOR REVISION

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3 - FILE 3 - EXPRESS 7 - FILE
4 - FILE 1 - FILE 8 - FILE

Correct typo

FMS 17F40

METAL FOIL INSERT GRAPHITE
GASKET MATERIAL

Rev: B
By: WTH 11-8-85
AFVD: NFR 11-8-85
Page 1 of 1

FISHER

*Fishes Controls 1985, 1987, 1988

Revised By: WHH 10-29-87

CONFIDENTIAL

1. SCOPES

This document describes a metal foil reinforced sheet graphite material, typically used for gasketing.

2. MATERIAL REFERENCE NOS. 994E

3. SPECIFICATIONS

- (a) Composition: Graphite, $\pm$ 95% with SS1600 foil insert, 0.002 inches thick.
- (b) Thickness: 0.011 $\pm$.005 inches.
- (c) Density: 70 lbs/cu. ft. graphite only.
- (d) Max. temperature limits: 800°F oxidizing media*
1800°F inert media

*Note: For oxygen service use FMS 17F49

4. ACCEPTED SOURCES

- (a) Union Carbide
Carbon Products Div.
Cleveland, OH
Style No. GEM
- (b) EGC Enterprises, Inc.
Mentor, OH

994E. - standard

994Y - certified less than 100 ppm leachable chloride
per FMS 17F43

MAJOR REVISION

JAN 16 1990

ECR/H NO. DATE NFS

BY WJH/CHD DRP APVD

1. ADD. STUCK 2. STOCK

3. DATE 4. COST

5. REWORK 6. WARRANTY

7. WARRANTY 8. SALES

9. SCRAM 10. REWORK

ADD WRN for certified low chloride gasket.

Fisher Controls

Material Specification

FMS 17F43

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL
(CERTIFIED 100 PPM OR LESS)

Rev: ~~8~~ R
By: GJK 3-7-83
Apvd: EZA 3-7-83
Page 1 of 2

FISHER

Fisher Controls 1903, 1991

Revised By: WHH 4-30-91

CONFIDENTIAL1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 100 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel in the system.

REFERENCES

1) ASTM D512 - Test Methods for Chloride Ion in Water

2. MATERIAL REFERENCE NUMBERS

4-17-83-17-83

Listed in parenthesis under Approved Materials (Section 6 below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed, and packaged in a manner which will justify certification. Each order must be certified that the requirements have been met.

4. PACKAGING

To prevent contamination, items shall be individually packaged in sealed plastic bags or envelopes. Labels or markings outside the package will indicate "low chloride."

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

APR 8 1998

5. ASSEMBLY

Specially processed parts made handled by bare hands or under

MAJOR REVISION

ECRN No. 961379 Date: 4/8/91 all not be
By: GJK CRKd P.O. D. Apvd: T.O.G. be used.

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6. APPROVED MATERIALS

The following gasket materials leachable chlorides:

or less

(a) Spiral Wound Gaskets

N06600/GIS Graphit
S31603/Composition
S30400/Composition
S30403/Composition
S31603/Corr. Inhib

Updated to the new elec.
Any changes to appearance,
numbering, etc., were to acco:
the new document format sty:
appearance of the document wa:
the same as before. NO CHANG:
CONTENT.

Source(s): Flexitallic Gasket Company or as specified on PMS 17N2
or PMS 17N5

FMS 17F43

Rev: P
By: DJK 3-7-83
Apvd: EEA 3-7-83
Page: 1 of 2

Revised by W H N 8-29-90

CONFIDENTIAL WHH 4-30-91

or FMS 17N5

[illegible]

Fisher Controls

Material Specification

FMS 17F43

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL
(CERTIFIED 100 PPM OR LESS)

Rev: **H P**
By: OJK 3-7-83
Appd: EKA 3-7-83
Page 1 of 2

FISHER

*Fisher Controls 1983, 1990

Revised By: **WHH 4-6-90****CONFIDENTIAL**1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 100 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel in the system.

2. MATERIAL REFERENCE NUMBERS

Listed in parenthesis under Approved Materials (Section 6 below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed, and packaged in a manner which will justify certification. Each order must be certified that the requirements have been met.

4. PACKAGING

To prevent contamination, items shall be individually packaged in sealed plastic bags or envelopes. Labels or markings outside the package will indicate "low chloride."

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. APPROVED MATERIALS

The following gasket materials can be certified to contain 100 PPM or less leachable chlorides:

(a) Spiral Wound Gaskets

H06600/GTE Graphite, Low Chloride (9957)
S31603/Composition, FMS 17N2 (992U)
S30400/Composition, FMS 17N2 (992V)
S30403/Composition, FMS 17N2 (992W)

SEP 07 1990

Source(s): Flexitallic Gasket Company or as specified on FMS 17N2

MAJOR REVISION

ECR/N NO. **B8805** DATE
BY **WHH** CHKD **PLF** APVD.
FOR DISCLOSURE **IN PLAIN**

ROA_03727

TAYLOR V. 3.M. COMPANY ET AL.

Fisher Controls

Material Specification

FMS 17F43

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL
(CERTIFIED 100 PPM OR LESS)

Rev: ALN
By: QTK 3-7-83
Apvd: EHA 3-7-83
Page 1 of 2

FISHERFisher Controls 1983, 1989 1990Revised By: WPH 6-1-891. SCOPE**CONFIDENTIAL**

This specification establishes a procedure for purchasing, handling, and unsealing gasket materials, which must not contain more than 100 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel in the system.

2. MATERIAL REFERENCE NUMBERS

Listed in parenthesis under Approved Materials (Section 6 below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed, and packaged in a manner which will justify certification. Each order must be certified that the requirements have been met.

Each order must be certified that the requirements have been met. ~~delete~~

4. PACKAGING

To prevent contamination, items shall be individually packaged in sealed plastic bags or envelopes. Labels or markings outside the package will indicate "low chloride."

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. APPROVED MATERIALS

The following gasket materials can be certified to contain 100 PPM or less leachable chlorides:

(a) Spiral Wound Gaskets

N06600/GFM Graphite, Low Chloride (9957)
S31603/Composition, FMS 17N2 (992U)
S30400/Composition, FMS 17N2 (992V)
S30403/Composition, FMS 17N2 (992W)
S31600/Composition, FMS 17N2 (992X) ~~delete~~

Source(s): Plaxitallie Gasket Company or as specified on FMS 17N2

4-1-8 1990

DATE: APR 10 1990
BY: QTK
APPROVED: EHA
FMS 17F43
1. NAME
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Fisher Controls

Material Specification

FMS 17F43

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL
(CERTIFIED 100 PPM OR LESS)

Rev: ^DM
By: DJK 3-7-83
Apvd: EEA 3-7-83
Page 1 of 2

FISHER

*Fisher Controls 1983, (1988) 1989

Revised By: W/H/H 2-22-88

CONFIDENTIAL1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 100 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel in the system.

2. MATERIAL REFERENCE NUMBERS

Listed in parenthesis under Approved Materials (Section 6 below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed, and packaged in a manner which will justify certification. Each order must be certified that the requirements have been met.

Each order must be certified that the requirements have been met.

4. PACKAGING

To prevent contamination, items shall be individually packaged in sealed plastic bags or envelopes. Labels or markings outside the package will indicate "low chloride."

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

APPROVED MATERIALS

The following gasket materials can be certified to contain 100 PPM or less leachable chlorides:

(a) Spiral wound Gaskets

N05600/Gr Graphite, Low Chloride (9957)
S31603/Composition, FMS 17N2 (992X)
S30400/Composition, FMS 17N2 (992V)
S30403/Composition, FMS 17N2 (992W)
S31600/Composition, FMS 17N2 (992X)

Source(s): Flexitallic Gasket Company or as specified on FMS 17N2

*FMS1-5/1

JUN 06 1989

DATE: 6/6/89
BY: W/H/H
CHKD: DJK
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Fisher Controls

Material Specification

FMS 17F4

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL
(CERTIFIED 100 PPM OR LESS)

Rev: DL
By: OJK 3-7-83
Apvd: SEA 3-7-83
Page 1 of 2

FISHER

CONFIDENTIAL

Fisher Controls 1983, 1987, 1988

Revised By: WWH 11-15-1

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 100 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel in the system.

2. MATERIAL REFERENCE NUMBERS

Listed in parenthesis under Approved Materials (Section 6 below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D572. The items must also be manufactured, processed, and packaged in a manner which will justify certification. Each order must be certified that the requirements have been met.

Each order must be certified that the requirements have been met.

4. PACKAGING

To prevent contamination, items shall be individually packaged in sealed plastic bags or envelopes. Labels or markings outside the package will indicate "low chloride."

MAR 02 1988

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. APPROVED MATERIALS

The following gasket materials can be certified to contain 100 PPM or less leachable chlorides:

(a) Spiral Wound Gaskets

N06600/GrB Graphite, Low Chloride (9957)
S31603/Composition, FMS 17N2 (992U)
S30400/Composition, FMS 17N2 (992V)
S30403/Composition, FMS 17N2 (992W)
S31600/Composition, FMS 17N2 (992X)

Source(s): Flexitallc Gasket Company or as specified on FMS 17N2

DATE: MAR 02 1988
BY: WTH
CHKD: JLG
APVD: SEA
1. DESIGNED
2. CHECKED
3. ENGINEERED
4. APPROVED
5. TESTED
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7. ASSEMBLED
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Fisher Controls	Material Specification	No. FHS 17F43	⑤
FISHER	SPECIAL HANDLING SPECIFICATION FOR LOW-CHLORIDE GASKET MATERIALS (CERTIFIED 100 PPM OR LESS)	By OTK 3-7-83	
		APV BBA 3-7-83	
		Page 1 of 2	
©Fisher Controls 1983, 1987		Rev WHH 3-23-87	

CONFIDENTIAL

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 100 parts per million leachable chlorides. Presumably the chloride content must be minimized to reduce the degree of stress corrosion of stainless steel in the system.

2. MATERIAL REFERENCE NOS. - Listed in parenthesis under Approved Materials (Section 6, below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D612. The items must also be manufactured, processed and packaged in the manner which will justify certification. Each order must be certified that the requirements have been met.

4. PACKAGING

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

The sealed containers shall not be opened until ready for assembly in the appropriate assembly areas.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. APPROVED MATERIALS

The following gasket materials can be certified to contain 100 PPM or less leachable chlorides:

- (a) Spiral Wound Gaskets NO6603/G18 Graphite, Low Chloride (9957)
 S31603/Composition, FMS 17N2 (992U)
 S30408/Composition, FMS 17N2 (992V)
 S30403/Composition, FMS 17N2 (992W)
 S31600/Composition, FMS 17N2 (992X)

Source(s): Flexitallic Gasket Company or as specified on FMS 17N2.

MAJOR REVISION

ECR/H NO. 86150 DATE DEC 09 1987
 BY WHH CHD RFE APV NFR
 1. 10/1/87 1. 10/1/87
 2. 10/1/87 2. 10/1/87
 3. 10/1/87 3. 10/1/87

To prevent contamination, items shall be individually packaged in sealed plastic bags or envelopes. Labels or markings outside the package will indicate "low chloride".

Fisher Controls		Material Specification		No. FMS 17F43	
		SPECIAL HANDLING SPECIFICATION FOR LOW-CHLORIDE GASKET MATERIALS (CERTIFIED 100 PPM OR LESS)			
		By	JFK	3-7-83	
		App'd	J.A.	3-7-83	
		Page	1	of	2
Fisher Controls 1983		1986		Rev	NRP 1-17-84

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 100 parts per million leachable chlorides. Presumably the chloride content must be minimized to reduce the degree of stress corrosion of stainless steel in the system.

2. MATERIAL REFERENCE NOS. - Listed in parenthesis under Approved Materials (Section 6, below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D612. The items must also be manufactured, processed and packaged in the manner which will justify certification. Each order must be certified that the requirements have been met.

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The sealed containers shall not be opened until ready for assembly in the appropriate assembly areas.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. APPROVED MATERIALS

The following gasket materials can be certified to contain 100 PPM or less leachable chlorides:

- (a) Spiral Wound Gaskets
- 531603 Inconel 600 W/GTB/Graphite, Low Chloride (9957)
 - 530400 316L SST Composition, FMS 17N2 (992U)
 - 530400 304 SST Composition, FMS 17N2 (992V)
 - 530403 304 SST Composition, FMS 17N2 (992W)
 - 531600 316 SST Composition, FMS 17N2 (992X)

Sources: Flexitallic Gasket Company or as specified on FMS 17N2

MAJOR REVISION

ECR/R NO. _____ DATE APR 1 1987

BY WILLIAM CHRO J.L.G. APVD NRP

1. DESIGNED	1. CHECKED	5. REVIEWED
2. APPROVED	2. APPROVED	6. CORRECTED
3. SPECIFIED	3. APPROVED	7. REVIEWED
4. APPROVED	4. APPROVED	8. REVIEWED

Change to UNS designations.
No. 100 to 1000.

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03732

Fisher Controls

Material Specification

No. FMS 17FA3

G

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIALS
(CERTIFIED 100 PPM OR LESS)

FISHER

By OSK 8-7-83

APPR EBA 8-7-83

Page 1 of 2

Fisher Controls 1983 (1985) 1986

Rev NRP 7-16-85

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 100 parts per million leachable chlorides. Presumably the chloride content must be minimized to reduce the degree of stress corrosion at stainless steel in the system.

2. MATERIAL REFERENCE NOS. - Listed in parenthesis under Approved Materials (Section 6, below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed and packaged in the manner which will justify certification. Each order must be certified that the requirements have been met.

4. PACKAGING

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

The sealed containers shall not be opened until ready for assembly in the appropriate assembly areas.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. APPROVED MATERIALS

The following gasket materials can be certified to contain 100 PPM or less leachable chlorides:

- (a) Spiral Wound Gaskets Inconel 800 & HTS Graphite, Low Chloride (9957)
316L SST & Asbestos, Low Chloride (991R)
304 SST & Asbestos, Low Chloride (9917)
304L SST & Asbestos, Low Chloride (991U)
316 SST & Asbestos, Low Chloride (991V)
316L SST & Composition, FMS 17N2 (992U)
304 SST & Composition, FMS 17N2 (992V)
304L SST & Composition, FMS 17N2 (992W)
316 SST & Composition, FMS 17N2 (992X)

Sources: Flexitallic Gasket Company or as specified on FMS 17N2 JUL 1 1988

MAJOR REVISION

REMOVE ASBESTOS
GASKET SOURCES

ECR/N ED. DATE
BY NRP CXP D/LLH + own NRP
840, 0031021 210

ROA_03733

TAYLOR V. 3.M. COMPANY ET AL.

Fisher Controls

Material Specification

No. FMS 17F43

6
(F)

FISHER

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIALS
(CERTIFIED 100 PPM OR LESS)

By QSK 3-7-83

App SEA 3-7-83

Page 1 of 2

© Fisher Controls 1983, 1984

Rev NRP 9-4-84

CONFIDENTIAL

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 100 parts per million leachable chlorides. Presumably the chloride content must be minimized to reduce the degree of stress corrosion at stainless steel in the system.

2. MATERIAL REFERENCE NOS. - Listed in parenthesis under Materials Approved materials (Section 6, below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed and packaged in the manner which will justify certification. Each order must be certified that the requirements have been met.

4. PACKAGING

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

The sealed containers shall not be opened until ready for assembly in the appropriate assembly press.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. MATERIALS APPROVED MATERIALS

The following gasket materials can be certified to contain 100 PPM or less leachable chlorides:

- (a) Spiral Wound Gaskets Inconel 600 & GTB Graphite, Low Chloride (9957)
316L SST & Asbestos, Low Chloride (991R)
304 SST & Asbestos, Low Chloride (991T)
304L SST & Asbestos, Low Chloride (991U)
316 SST & Asbestos, Low Chloride (991Y)

Sources: Flexitallic Gasket Company or as specified on FMS 17N2

316L SST & Composition, FMS 17N2 (992U)
304 SST & Composition, FMS 17N2 (992V)
304L SST & Composition, FMS 17N2 (992W)
316 SST & Composition, FMS 17N2 (992X)

JUL 25 1985

FOR/IN NO. DATE
BY NRP 10/10/84
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CONFIDENTIAL

Fisher Controls	Material Specification	No. FNS 17F43	E
FISHER	SPECIAL HANDLING SPECIFICATION FOR LOW-CHLORIDE GASKET MATERIALS (CERTIFIED 100 PPM OR LESS)	By	DAK 3-7-83
		Appl	BEA 3-7-83
		Page	1 of 2
Fisher Controls 1983, 1984		Rev	NRP 3-26-84

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 100 parts per million leachable chlorides. Presumably the chloride content must be minimized to reduce the degree of stress corrosion at stainless steel in the system.

2. MATERIAL REFERENCE NOS. - Listed in parenthesis under Materials.

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512-67. The items must also be manufactured, processed and packaged in the manner which will justify certification. Each order must be certified that the requirements have been met.

4. PACKAGING

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

The sealed containers shall not be opened until ready for assembly in the appropriate assembly areas.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. MATERIALS

The following gasket materials can be certified to contain 100 PPM or less leachable chlorides:

- (a) Spiral Wound Gaskets Inconel 600 & GT8 Graphite, Low Chloride (9957)
- 316L SST & Asbestos, Low Chloride (991R)
- 304 SST & Asbestos, Low Chloride (991I)
- 304L SST & Asbestos, Low Chloride (991U)
- 316 SST & Asbestos, Low Chloride (991Y)

Sources: Flexitallic Gasket Company

SEP 6 1984

DATE	DATE	DATE
BY	BY	BY
1 - USE	1 - SAFETY	5 - STOR
2 - REPAIR/RE	2 - X MARK	6 - CUST
3 - SCRAP/RE	3 - IMPROVE	
4 - SCRAP MCV	4 - ERROR	

ROA_03735

TAYLOR V. S.M. COMPANY ET AL.

9

Fisher Controls	Material Specification						No. FMS 17743
	SPECIAL HANDLING SPECIFICATION FOR LOW-CHLORIDE GASKET MATERIALS (CERTIFIED 100 PPM OR LESS)						By OSK 3-7-83
							App'd EEA 3-7-83
							Page 2 of 2
							Rev NRP 2-3-84
©Fisher Controls	1983, 1984						

- (b) Flat Sheet graphite with 316 SS Screen. Can be certified less than 100 ppm leachable chlorides by the suppliers listed on PWS 17F39. If these gaskets are cut by an outside vendor, then that vendor must cut the gaskets per paragraph 4 and repackages per paragraph 5. (0432)

- (c) Flat Sheet Asbestos Gaskets, Asbestos Composition, Low Chloride

Sources Manville - Style MX-4707 Sheet Packing, Low Chloride (0459)

omit

NOTE: Sheet gasket material must be handled similarly to that used for oxygen service. Fisher shall keep material in the original wrapped roll in the white room and the white room personnel shall cut, package and handle the cut gaskets to prevent contamination.

FEB 28 1984

STATION MEMPHIS DATE 4/11/68
BY WFO AND WFO SPOT WFO
1 - MEMPHIS 1 - MEMPHIS 5 - MEMPHIS
2 - MEMPHIS 2 - MEMPHIS 6 - MEMPHIS
3 - MEMPHIS 3 - MEMPHIS 7 - MEMPHIS
4 - MEMPHIS 4 - MEMPHIS
5 - MEMPHIS

Fisher Controls

MATERIAL SPECIFICATION

CONFIDENTIAL

FMS 17F43 (B)

FISHER

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIALS
(CERTIFIED 100 PPM OR LESS)

By	CDK	3-7-83
App'd	AGB	3-7-83
Page	2	of 2

Fisher Controls 1283, 1984

Rev	1/182	7-22-83

(b) Flat Sheet graphite with 316 SST Screen. Can be certified less than 100 ppm leachable chlorides by the suppliers listed on FMS 17F38. If these gaskets are cut by an outside vendor, then that vendor must cut the gaskets per paragraph 4. and repackage per paragraph 5. (0452)

(c) Flat Sheet Asbestos Gaskets, Asbestos Composition, Low Chloride
Sources Manville - Style MX-4787 Sheet Packing, Low Chloride (0459)

NOTE: Sheet gasket material must be handled similarly to that used for oxygen service. Fisher shall keep material in the original wrapped roll in the white room and the white room personnel shall cut, package and handle the cut gaskets to prevent contamination.

FEB 7 1984

MAJOR REVISIONS
BY: CDK DATE: 1/182
REASON: FOR REASON
1 - X DED 1 - IMPROVE 5 - IMPROVE
2 - MISCELLANEOUS 2 - IMPROVE 6 - IMPROVE
3 - SUPPLY/DEB 3 - IMPROVE 7 - IMPROVE
4 - STRAP NOW 4 - IMPROVE 8 - IMPROVE

ADD NEW MATERIAL TO SUPPLY

REQUEST FR. 7/182
TO PROVIDE MATL FOR

Q.

Fisher Controls 	Material Specification SPECIAL HANDLING SPECIFICATION FOR LOW-CHLORIDE GASKET MATERIALS (CERTIFIED 100 PPM OR LESS)		No. FMS 17F43 (A)
	By CDK	3-7-83	Date 3-7-83
	Page 2 of 2		Rev MPD 7-22-83
	© Fisher Controls 1283		

(b) Flat Sheet graphite with 316 SST Screen. Can be certified less than 100 ppm leachable chlorides by the suppliers listed on FMS 17F08. If these gaskets are cut by an outside vendor, then that vendor must cut the gaskets per paragraph 4. and repackage per paragraph 5.

NOTE: Sheet gasket material must be handled similarly to that used for oxygen service. Fisher shall keep material in the original wrapped roll in the white room and the white room personnel shall cut, package and handle the cut gaskets to prevent contamination.

JUL 29 1983

MAJOR REVISION

BY: MRP CHKD: WMA APVD: NFR

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6.00.00.0000	6.00.00.0000	6.00.00.0000
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10.00.00.0000	10.00.00.0000	10.00.00.0000

DATE: 11/11/00

UPDATE PAGE 1

Fisher Controls

Document Cover Sheet

FMS 17F30

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORINE GASKET MATERIAL
(CERTIFIED 200 PPM OR LESS)

Rev: ~~55~~
By: DJG 12-11-72
Apvd: BR 11-13-79
Page 1

FISHER

CONFIDENTIAL

Fisher Controls 1984, 1992

Revised By: MN 4-30-92

This page is the cover sheet of all documents containing 3 or more pages of specifications. The table below shows the revision level for each page of this document. A revision of this page will be made when any page of this document is revised. When referring to this document specify the revision level of this page.

PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL

1
2
3
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1/8
3
A

FEB 10 1998

MAJOR REVISION

ECAN No. 961298 Date 4-14-97

By DJM Chkd LMD Apvd TOS

800, On Stock

1. USE

2. REWORK

3. SCRAP/REWORK

4. SCRAP/NOV

800, Reason

1. SAFETY

2. MATL

3. IMPROVE

4. ERROR

5. STDN

6. COST

7. MKTG

8. SALES

Updated to the new electronic format.
Any changes to appearance, paragraph
numbering, etc., were to accommodate
the new document format style. The
appearance of the document will not
be the same as before. NO CHANGES
TO CONTENT.

Fisher Controls

Material Specification

FMS 17F30

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORINE GASKET MATERIAL
(CERTIFIED 200 PPM OR LESS)

Rev: ⑤
By: DJG 12-11-72
Apvd: BR 11-13-79
Page 1 of 2

FISHER

CONFIDENTIAL

*Fisher Controls 1984, 1990, 1992

Revised By: W 114 2-29-90

4-30-92

1. SCOPE

- 1.1 This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 200 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel materials.

1.2 REFERENCES ADDED
2. MATERIAL REFERENCE NUMBERS

MRN's are listed in parenthesis under Approved Materials (Section 6 below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed, and packaged in a manner which will justify certification.

Each order must be certified that the requirements have been met.

4. PACKAGING

To prevent contamination, items shall be individually packaged in sealed plastic bags or envelopes. Labels or markings outside the package will indicate "low chloride."

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. APPROVED MATERIALS

The following gasket materials can be certified to contain 200 PPM or less leachable chlorides:

MAJOR REVISION (1) Spiral Wound Gaskets JUN 3 1992

DATE: 4-30-92
BY: DJG
CHKD: TDC
APVD: NRS
1. WHY
2. OLD STOCK
3. NEW
4. REWORK
5. SCRAP/REUSE
6. SCRAP WOV
7. REASON
8. SAFETY
9. NATL
10. IMPROVE
11. ETC
12. SOURCE(S): as specified on FMS 17N2 or FMS 17N5
13. added low chloride grades of graphite sheet

Fisher Controls

Material Specification

FMS 17F30

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL
(CERTIFIED 200 PPM OR LESS)

Rev: ^QQ
By: DVG 12-11-77
Apvd: BR 11-13-79
Page 2 of 2

FISHER

*Fisher Controls 1984, 1988

Revised By: W/HH 3-2-80

CONFIDENTIAL

(b) Metal Jacketed Gaskets

531503/composition, FMS 17N1, low chloride (993R)
N04400/composition, FMS 17N1, low chloride (993S)
S30400/composition, FMS 17N1, low chloride (993V)
copper/composition, FMS 17N1, low chloride (994C)

Source(s): as specified on FMS 17N1

(c) Flat Sheet Gaskets

Composition sheet, low chloride, FMS 17A5 (0464)
Composition sheet, low chloride, FMS 17A6 (0467)

Source(s): as specified on FMS 17A5

NOTES:

1. Sheet gasket material must be handled similarly to that used for oxygen service. Fisher shall keep material in the original wrapped roll in the white room. The white room personnel shall cut, package and handle cut gaskets to prevent contamination.
2. In addition to the above listed materials, any material listed in FMS 17F43 (100 ppm chloride or less) may be used for this specification.

(d) Spring Loaded Seal Rings

N10276 / PTFE with glass fiber and molybdenum
disulfide fillers, low chloride (994N)

MAJOR REVISION APR 26 1988

ECN#	NO.	DATE
24	WHH	APR 26 1988
24	WHH	APR 26 1988
24	WHH	APR 26 1988
24	WHH	APR 26 1988
24	WHH	APR 26 1988
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24	WHH	APR 26 1988

Add 3 new gasket
mats to spec.

Fisher Controls

Material Specification

FMS 17F30

FISHER

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL
(CERTIFIED 200 PPM OR LESS)

Rev: 007R
By: DJG 12-11-72
App'd: BR 11-13-79
Page 2 of 2

Fisher Controls 1984, 1988, 1990

Revised By: WHH 4-3-88

CONFIDENTIAL

(b) Metal Jacketed Gaskets

ST1603/composition, FMS 17N1, low chloride (993R)
N04600/composition, FMS 17N1, low chloride (993S)
S30600/composition, FMS 17N1, low chloride (993V)
Copper/composition, FMS 17N1, low chloride (994C)

Source(s): as specified on FMS 17N1

(c) Flat Sheet Gaskets

Composition sheet, low chloride, FMS 17A5 (0464)
Composition sheet, low chloride, FMS 17A6 (0467)

Source(s): as specified on FMS 17A5 or FMS 17A6

(d) Spring Loaded Seal Rings

N10276/PIPE with glass fiber and molybdenum disulfide fillers,
low chloride (994N)

NOTES:

1. Sheet gasket material must be handled similarly to that used for oxygen service. Fisher shall keep material in the original wrapped roll in the white room. The white room personnel shall cut, package and handle out gaskets to prevent contamination.
2. In addition to the above listed materials, any material listed in FMS 17F43 (100 ppm chloride or less) may be used for this specification.

SEP 07 1990

MAJOR REVISION

ECR/N NO.	BY	CHKD	DATE	APVD	DATE
BY W. H. H.	CHKD	DATE	APVD	DATE	
1. X USE	1. SAFETY	2. COST	3. STERN	4. COST	5. STERN
2. REMOVED	2. X-IMP	3. X-IMP	4. X-IMP	5. X-IMP	6. X-IMP
3. REMOVED	3. X-IMP	4. X-IMP	5. X-IMP	6. X-IMP	7. X-IMP
4. REMOVED	4. X-IMP	5. X-IMP	6. X-IMP	7. X-IMP	8. X-IMP

Add reference to FMS 17A6

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL
(CERTIFIED 200 PPM OR LESS)

Rev: QDP
By: DJS 12-11-72
Apvd: BR 11-17-79
Page 1 of 2

FISHER

CONFIDENTIAL

Fisher Controls 1984, (1987) 1988

Revised By: WWH 11-25-87

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 200 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel materials.

2. MATERIAL REFERENCE NUMBERS

NRN's are listed in parenthesis under Approved Materials (Section 6 below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed, and packaged in a manner which will justify certification.

Each order must be certified that the requirements have been met.

4. PACKAGING

To prevent contamination, items shall be individually packaged in sealed plastic bags or envelopes. Labels or markings outside the package will indicate "low chloride."

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. APPROVED MATERIALS

MAR 30 1988

The following gasket materials can be certified to contain ~~200 PPM~~ 200 PPM OR LESS leachable chlorides:

(a) Spiral Wound Gaskets
corr. inhibited

S31603/graphite, FMS 17N2 (994J)
S31603/composition, FMS 17N2 (992T)
S32100/composition, FMS 17N2 (993T)
S30400/composition, FMS 17N2 (993U)

SOURCE(s): as specified on FMS 17N2 or FMS 17N2.5

ECR/H NO.	CHKD	APVD	DATE
BY: WWH	CHKD: DJS	APVD: BR	11-17-79
040 010 001	1. ☒ MATERIAL	2. ☒ COST	3. ☒ INQUIRY
1. ☒ MFG	2. ☒ INQUIRY	3. ☒ INQUIRY	4. ☒ INQUIRY
2. ☒ MFG	3. ☒ INQUIRY	4. ☒ INQUIRY	5. ☒ INQUIRY
3. ☒ MFG	4. ☒ INQUIRY	5. ☒ INQUIRY	6. ☒ INQUIRY
4. ☒ MFG	5. ☒ INQUIRY	6. ☒ INQUIRY	7. ☒ INQUIRY
5. ☒ MFG	6. ☒ INQUIRY	7. ☒ INQUIRY	8. ☒ INQUIRY

Added another
SWG to list,
corrected one
gasket description

Fisher Controls

Material Specification

No. FMS 17F30

M

FISHERSPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL
(CERTIFIED 200 PPM OR LESS)

By DJG- 12-11-72

Apvd BR 11-13-72

Page 1 of 2

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Rev WHH 3-20-87

CONFIDENTIAL

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 200 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel materials.

2. MATERIAL REFERENCE NUMBERS

MRR's are listed in parenthesis under Approved Materials (Section 6, below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D612. The items must also be manufactured, processed, and packaged in a manner which will justify certification.

Each order must be certified that the requirements have been met.

4. PACKAGING

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. APPROVED MATERIALS

The following gasket materials can be certified to contain 200 PPM or less leachable chlorides:

- (a) Spiral Wound Gaskets S31603/graphite, FMS 17N3 (9943)
- S31603/composition, FMS 17N2 (992T)
- S32100/composition, FMS 17N2 (993T)
- S30400/composition, FMS 17N2 (993U)

Source(s): as specified on FMS 17N2 or FMS 17N3

MAJOR REVISION
EGR/M NO. 10150 DATE 10/15/87
BY WHH CHRD RIF APVD NFR
1. XUSE 1. SAFETY 5. STOR
2. RETOR 2. KATL
3. SEPARATE BY 3. KIMPROVE 7. CAVE

to prevent contamination, items shall be individually packaged in sealed plastic bags or envelopes. Labels or markings outside the package will indicate "low chloride".

ROA_03744

TAYLOR V. 3.M. COMPANY ET AL.

Fisher Controls		Material Specification		No. FMS 17P30	
		SPECIAL HANDLING SPECIFICATION FOR LOW-CHLORIDE GASKET MATERIAL (CERTIFIED 200 PPM OR LESS)			
		By DJG	12-11-72		
		Appl GR	11-13-74		
©Fisher Controls 1984, 1986		Page	of	2	
		Rev	NRP 6-17-86		

CONFIDENTIAL

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 200 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel materials.

2. MATERIAL REFERENCE NUMBERS

MRN's are listed in parenthesis under Approved Materials (Section 6, below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed, and packaged in a manner which will justify certification.

Each order must be certified that the requirements have been met.

4. PACKAGING

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. APPROVED MATERIALS

The following gasket materials can be certified to contain 200 PPM or less leachable chlorides:

- (a) Spiral Wound Gaskets
 - 316L and graphite, FMS 17N3 (9941)
 - 316L and composition, FMS 17N2 (9921)
 - 321 and composition, FMS 17N2 (9931)
 - 304 and composition, FMS 17N2 (9930)

Source(s): Flexitallic Gasket Company, or as specified on FMS 17N2

MAJOR REVISION

AUG 08 1986

ECB/R NO. 2000 WHT AND NRP DATE ADD 316L/GRAPHITE
 BY NRP 12-11-72 11-13-74 6-17-86
 FOR 12-11-72 11-13-74 6-17-86

Fisher Controls

Material Specification

FISHER

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIAL
(CERTIFIED 200 PPM OR LESS)

No.	FMS 17F30	(K)
By	DJG	12-11-72
Appd	BR	11-13-79
Page	2	of 2
Rev	NEP	6-17-86

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CONFIDENTIAL

(b) Metal Jacketed Gaskets

316L and composition, FMS 17N1, low chloride (993R)
304 and composition, FMS 17N1, low chloride (993S)
304 and composition, FMS 17N1, low chloride (993V)

Source(s): as specified on FMS 17N1

(c) Flat Sheet Gaskets

Composition sheet, low chloride, FMS 17A5 (0464)

Source: as specified on FMS 17A5

NOTES:

1. Sheet gasket material must be handled similarly to that used for oxygen service. Fisher shall keep material in the original wrapped roll in the white room. The white room personnel shall cut, package and handle cut gaskets to prevent contamination.
2. In addition to the above listed materials, any material listed in FMS 17F43 (100 ppm chloride or less) may be used for this specification.

AUG 08 1986

MAJOR REVISION

REQ'D NO. _____ DATE _____
BY NEP CHK WWH APPD NEP
REVISION _____
1. _____
2. _____
3. _____
4. _____
ADD 304L 1600PMT 304L 1600PMT

~~CONFIDENTIAL~~

Fisher Controls	Material Specification	No. FMS 17F30	KL
FISHER	SPECIAL HANDLING SPECIFICATION FOR LOW-CHLORIDE GASKET MATERIAL (CERTIFIED 200 PPM OR LESS)	By DSG	12-11-72
		Appd BR	11-18-79
		Page 1 of	
Fisher Controls 1284		Rev NRP	2-21-84

CONFIDENTIAL

1. SCOPE

This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 200 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel materials.

2. MATERIAL REFERENCE NUMBERS

MRN's are listed in parenthesis under Approved Materials (Section 6, below).

3. CERTIFICATION

Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed, and packaged in a manner which will justify certification.

Each order must be certified that the requirements have been met.

4. PACKAGING

Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.

The sealed containers shall not be opened until ready for assembly in the appropriate assembly area.

5. ASSEMBLY

Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

6. MATERIALS APPROVED MATERIALS

The following gasket materials can be certified to contain 200 PPM or less leachable chlorides:

- (a) Spiral Wound Gaskets 316L and asbestos, low chloride (9956)
321 and asbestos, low chloride (9971)
304 and asbestos, low chloride (9983)

Sources: Flexitallic Gasket Company or as specified on FMS 17F30

316L and composition	FMS 17F30	(9917)
321 " "	FMS 17F30	(9931)
304 " "	FMS 17F30	(9930)

ECR/H NO. 1284
 DATE 25 JUL 1985
 BY DSG
 APPD BR
 REV NRP
 12-11-72
 11-18-79
 2-21-84



MATERIAL SPECIFICATION

SPECIAL HANDLING SPECIFICATION
FOR LOW-CHLORIDE GASKET MATERIALS

NO.	THIS 17230
BY	11-13-79
APPROVED	11-13-79
PAGE	1 OF 1
REV	PSM/11-13-79
APP	32 2A-83

CONFIDENTIAL

1. Scope

- This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 200 parts per million leachable chlorides. Presumably the leachable chloride content must be minimized to reduce the degree of stress corrosion of stainless steel materials.

2. Purpose of Material Reference Test

- MRLH are listed in parentheses under Approved Materials (Section 6, below). Presumably the chloride content must be as low as practicable in components because of the danger of stress corrosion in stainless steel in the system.

3. Certification

- Items purchased to this specification must be tested for leachable chloride per ASTM D512. The items must also be manufactured, processed and packaged in a manner which will justify certification.
- Each order must be certified that the requirements have been met.

4. Packaging

- Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.
- The sealed containers shall not be opened until ready for assembly in the appropriate assembly areas.

5. Assembly

- Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

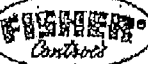
Materials

The following gasket materials can be certified to contain 200 PPM or less leachable chlorides:

- a) Spiral-Wound Gaskets 316L and Asbestos, Low Chloride (9951)
Inconel 600 or 690 Graphite Low Chloride
Sources: Flexitallic Gasket Company 304 and Asbestos Low Chloride (9970)
304 and Asbestos Low Chloride (9983)
- b) Metal-Clad Gaskets Monel and Asbestos Low Chloride
X15L and Asbestos Low Chloride
- c) Flat Sheet Asbestos Gaskets Asbestos Composition, Low Chloride (9435)
Sources: Johns-Manville Style HX-4787 Sheet Packing - Low Chloride

Notes: Sheet gasket material must be handled similarly to that used for oxygen service.
Fisher shall keep material in the original wrapped roll in the white room and the white room personnel shall cut, package and handle the

REVISION
BY NAME
DATE
1. 11-19-79
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 IRSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. FMS 17F10 F-1E
	SPECIAL HANDLING SPECIFICATION FOR LOW-CHLORIDE GASKET MATERIALS		BY DLS 12/11/72
			APVD
			PAGE 1 OF 1
		REV 5/15 9-22-77	

TESTED FOR LEACHABLE CHLORIDE PER ASTM D512-C7. THE ITEMS MUST ALSO BE MANUFACTURED, PROCESSED AND PACKAGED IN A MANNER WHICH WILL JUSTIFY CERTIFICATION.

CONFIDENTIAL

1. Scope
This specification establishes a procedure for purchasing, handling, and assembling gasket materials, which must not contain more than 200 parts per million leachable chlorides (at 1000°F) ~~omit~~
2. Purpose of Requirement
Presumably the chloride content must be as low as practicable in components because of the danger of stress corrosion in stainless steel in the system.
3. Certification
~~Items purchased to this specification must be manufactured, processed and packaged in a manner which will justify certification by the supplier.~~
Each order must be certified that the requirements have been met.
4. Packaging
Items must be packaged in sealed plastic bags or envelopes which will prevent contamination and which are marked to indicate that they have been specially processed.
The sealed containers shall not be opened until ready for assembly in the appropriate assembly areas.
5. Assembly
Specially processed parts made to conform to this specification shall not be handled by bare hands or unclean instruments. Clean gloves should be used.

MAJOR REVISION
 BY JHS CHD 2/27/77
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- Materials
- The following gasket materials can be certified to contain 200 PPM or less leachable chlorides (at 1000°F) ~~omit~~
- a. Spiral-Wound Gaskets 316L and Asbestos, Low Chloride
Inconel 600 & GTS Graphite, Low Chloride
Sources: Flexitallic Gasket Company
 - b. Metal Clad Gaskets Monel and Asbestos, Low Chloride
316L and Asbestos, Low Chloride
Sources: Johns-Manville Style 923
 - c. Flat Sheet Asbestos Gaskets Asbestos Composition, Low Chloride
Sources: Johns-Manville Style MX-4787 Sheet Packing - Low Chloride

NOTE: Sheet gasket material must be handled similarly to that used for oxygen service. Fisher shall keep material in the original wrapped roll in the white room and the white room personnel shall cut, package and handle the cut gaskets to prevent contamination.

Fisher Controls

Material Specification

FMS 17F29

PTFE COATED METAL GASKET MATERIAL

Rev: *JK*
By: REA 1-5-72
Apvd: TKB 10-16-81
Page 1 of 1**FISHER****CONFIDENTIAL**

Fisher Controls 1988, 1991

Revised By: WHH 12-19-91

1. SCOPE

This standard covers polytetrafluoroethylene (PTFE) coated metal sheet materials used in special gasket applications.

2. MATERIAL REFERENCE NOS.

9912 N04400/PTFE
9919 N60702 (Zirconium alloy)/PTFE
9922 N08020/PTFE, oxygen service, per FGS 8A11
9928 C11000/PTFE
993L N10668/PTFE
992M S31603/PTFE
992N N10276/PTFE
992F N08020/PTFE
994H S31603/PTFE, oxygen service, per FGS 8A11
994L S30403/PTFE
994U N88400/PTFE
994V N02200/PTFE
9991 N04400/PTFE, oxygen service, per FGS 8A11

3. MATERIAL DESCRIPTION

Cold rolled annealed metal sheet, as specified in Sec. 2, coated with PTFE .005" to .008" per surface. Adhesion should be equal to or greater than the strength of the PTFE coating.

4. MAXIMUM USE TEMPERATURE

450°F

FEB 10 1998

5. APPROVED SOURCES

- (a) K & L Precision Plastics
Richardson, TX
- (b) E/M Lubricants
West Lafayette, IN

MAJOR REVISION
ECRN No. *961398* Date *4-18-97*
By *DM* Chkd *PM* Apvd *TGG*
40, Old Stock 100, Reason
1. ☐ USE 1. SAFETY 5. ☐ STON
2. ☐ REFORM 2. ☐ MATL 6. ☐ COST
3. ☐ SCRAP NEW 3. ☐ IMPROVE 7. ☐ MKTG
4. ☐ SCRAP NOW 4. ☐ ERROR 8. ☐ SALES

Updated to the new electronic format.
Any changes to appearance, paragraph
numbering, etc., were to accommodate
the new document format style. The
appearance of the document will not
be the same as before. NO CHANGES
TO CONTENT.

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03751

Fisher Controls

Material Specification

FMS 17F29

PTFE COATED METAL GASKET MATERIAL

Rev: QH

By: REA 1-5-72

Apvd: TWB 10-16-81

Page 1 of 1

FISHER**CONFIDENTIAL**

*Fisher Controls 1988, 1989

Revised By: WHH 8-16-88

1. SCOPE

This standard covers polytetrafluoroethylene (PTFE) coated metal sheet materials used in special gasket applications.

2. MATERIAL REFERENCE NOS.

992L	N10665/PTFE	add {	992B	C11000 / PTFE
992M	S31603/PTFE		994U	R56400 / PTFE
9912	N04400/PTFE		994V	N02200 / PTFE
992N	N10276/PTFE			
992P	N08020/PTFE			
9991	N04400/PTFE, oxygen service, per FGS 8A11			
994H	S31603/PTFE, oxygen service, per FGS 8A11			
994L	S30403/PTFE			
9922	N08020/PTFE, oxygen service, per FGS 8A11			
9919	R60702 (Zirconium alloy)/PTFE			

(put in numerical order)

3. MATERIAL DESCRIPTION

Cold rolled annealed metal sheet, as specified in Sec. 2, coated with PTFE .005" to .006" per surface. Adhesion should be equal to or greater than the strength of the PTFE coating.

4. APPROVED SOURCES

- (a) K & L Precision Plastics
Richardson, TX
- (b) E/M Lubricants
West Lafayette, IN

MAJOR REVISION

NOV - 7 1989

ECR/N NO.	DATE
BY WHH	CHKD DRD APVD NFR
QTY. OLD STOCK	QTY. NEW
1. AS REQ.	1. SAFETY
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3. SECURE	3. IMPROVE
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	5. STRIN
	6. COST
	7. MAINT
	8. SALES

Add new materials

Fisher Controls		Material Specification		No.	FMS 17F29	(E)
		PTFE COATED METAL GASKET MATERIAL		By	REA	1-6-72
				App'd	RE	10-11-81
				Page	1 of 1	
©Fisher Controls 1981, 1986				Rev	NRP	6-17-86

CONFIDENTIAL

1. SCOPE

This standard covers polytetrafluoroethylene (PTFE) coated metal sheet materials used in special gasket applications.

2. MATERIAL REFERENCE NOS.

992L ~~(Hastelloy B-2/PTFE)~~ N10665 /PTFE
 992N ~~(316L SST/PTFE)~~ S31603 /PTFE
 9912 ~~(Monel Alloy 400 ASTM B127/PTFE)~~ N04400 /PTFE
 992N ~~(Hastelloy C-276/PTFE)~~ N10276 /PTFE
 992P ~~(Alloy 20/PTFE)~~ N08020 /PTFE
 9991 ~~(Hastelloy C-276/PTFE)~~ oxygen service, per FGS 8A11 N04400 /PTFE
 994H ~~(316L SST/PTFE)~~ oxygen service, per FGS 8A11 S31603 /PTFE
 994L ~~(316L SST/PTFE)~~ oxygen service, per FGS 8A11 S31603 /PTFE

3. MATERIAL DESCRIPTION

Cold rolled annealed metal sheet, as specified in Sec. 2, coated with PTFE .005" to .008" per surface. Adhesion should be equal to or greater than the strength of the PTFE coating.

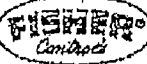
4. APPROVED SOURCES

- (a) K & L Precision Plastics
Richardson, TX
- (b) E/M Lubricants
West Lafayette, IN

MAJOR REVISION

ECR/R NO. _____ DATE _____
 BY WHH CHD DRB APYB NFR
 100, 100 STOCK
 1 USE
 2 REVERSE
 3 SCRAP/HON
 4 SCRAP/HON

Add new listing
 Convert existing material listings
 to new standard form.

 FISHER Controls MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. MMS 17E29
	PTFE COATED ~~MOBEL~~ GASKET MATERIAL		BY RGA 1-6-72
	METAL		APVD TCB 10-16-81
			PAGE 1 OF 1
			REV 3 10-15-81

1. SCOPE

polytetrafluoroethylene (PTFE)

CONFIDENTIAL

This standard covers ~~fluoroplastic~~ coated ~~MOBEL~~ Alloy 400 sheet materials used in special gasket applications.

2. MATERIAL REFERENCE NOS. ~~0912~~

- 9921 Hastelloy B-2 / PTFE
- 9924 316L SST / PTFE
- 9912 Monel Alloy 400, ASTM B127 / PTFE
- 9931 Hastelloy C-276 / PTFE
- 9928 Alloy 60 / PTFE
- 9991 Monel / PTFE, oxygen service, per FGS 841

3. MATERIAL DESCRIPTION

~~MOBEL~~ Alloy 400 ASTM B127 Cold rolled annealed, sheet, coated with ~~PTFE~~ .005" to .008" per surface. Adhesion should be equal to or greater than the strength of the PTFE coating.

4. APPROVED SOURCES

(a) Penn Dixon Corp.
Cliffon Heights, PA

(b) Johns-Manville
Denver, CO

(a) K & L Precision Plastics
Richardson, TX

(b) E/M Lubricants
West Lafayette, IN

APR 9 1985

MAJOR REVISION

BY NRP CHKD ~~KHH~~ APVD ~~ALR~~
 1. X USE 2. X REMACHINE 3. X SCRAP/NEW 4. X SCRAP NOW
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© FISHER CONTROLS, 1981, 1985

Fisher Controls

Material Specification

FMS 17F20

FLEXIBLE GRAPHITE SHEET
(GASKET MATERIAL)

Rev: *LG*
By: LHM 6-22-71
Apvd: NFR 9-27-88
Page 1 of 1

FISHER

*Fisher Controls 1988, 1993

Revised By: SDG 3-24-93

CONFIDENTIAL

1. SCOPE

1.1 This document describes the graphite material to be used in gasket applications.

1.2 This standard includes references to the following documents:

- (a) FGS 8A11, Cleaning and Handling for Oxygen and Other Special Services
- (b) FMS 17F20, Special Handling Specification for Low-Chloride Gasket Material
(Certified 200 ppm or less)
- (c) FMS 17F43, Special Handling Specification for Low-Chloride Gasket Material
(Certified 100 ppm or less)

2. MATERIAL REFERENCE NOS.

- (a) 0431 Standard Grade
- (b) 043B $\leq$ 100 ppm chloride per FMS 17F43
- (c) 043A $\leq$ 200 ppm chloride per FMS 17F20 & oxygen service per FGS 8A11

3. SPECIFICATIONS

- (a) Thicknesses and Tolerances 0.005" to 0.030" $\pm$.002"
(For Reference Only) 0.063" & 0.075" $\pm$.005"
- (b) Composition

- (1) Graphite 95% Minimum
- (2) Ash 5% Maximum

4. TYPICAL PROPERTIES

- (a) Nominal Density 70 lb/cu. ft.
- (b) Sublimation Point 6600°F

5. TEMPERATURE RANGE

- (a) -400°F to 850°F in oxidizing atmosphere
- (b) -400°F to 3000°F in inert atmosphere

6. ACCEPTED SOURCE

UCAR Carbon Co., Inc.

Trade Name - GIB or GIB Grafoil

FEB 10 1998

MAJOR REVISION

FORM No. 961398 Date: 4/4/97

By: *LM* Chkd: *DD* Apvd: *TOG*

8th, Old Stock 800, Hanson
1. USE 1. SAFETY 5. STORAGE
2. REMARK 2. MATERIAL 6. COST
3. REWORK 3. APPROVE 7. MKTG
4. SCRAP NOW 4. ERROR 8. SALES

Updated to the new electronic format.
Any changes to appearance, paragraph
numbering, etc., were to accommodate
the new document format style. The
appearance of the document will not be
the same as before. NO CHANGES TO
CONTENT.

ROA_03755

TAYLOR V. 3.M. COMPANY ET AL.

Fisher Controls

Material Specification

FMS 17F28

FLEXIBLE GRAPHITE SHEET
(GASKET MATERIAL)Rev: DE
By: LHM 6-22-71
Apvd: NFR 9-27-88
Page 1 of 1**FISHER****CONFIDENTIAL**Fisher Controls 1988, 1991, 1992Revised By: NFR 12-6-91

9-80-92

1. SCOPE

1.1 This document describes the graphite material to be used in gasket applications.

2. MATERIAL REFERENCE NOS.

- (a) 0431
 (b) 0438 ≤ 100 ppm chloride per FMS 17F43
 (c) 043A ≤ 200 ppm chloride per FMS 17F30 & oxygen service per FMS 8A11

3. SPECIFICATIONS

- (a) Thicknesses and Tolerances 0.005" to 0.030" ± .002
0.075" ± .005
 (b) Composition
 (1) Graphite 95% Minimum
 (2) Ash 5% Maximum

4. TYPICAL PROPERTIES

- (a) Nominal Density 70 lb/cu. ft.
 (b) Sublimation Point 6600°F

5. ACCEPTED SOURCE

UCAR Carbon Co., Inc.

Trade Name - GXB or GHA Grafoil

5. TEMPERATURE RANGE

- (a) -400°F to 850°F in oxidizing atmosphere
 (b) -400°F to 3000°F in inert atmosphere

MAJOR REVISION

JUN 16 1992

EDM/TH NO. _____ DATE 4-30-92
 BY WNA CHKD JCG APVD DAE
 P40 CAR-BOOK
 1. USE 1. SAFETY 5. STOCK
 2. WELD 2. HAZ 6. COST
 3. REPAIR/REPAIR 3. IMPROVE 7. ERTV
 4. REPAIR/REPAIR 1. ERROR 8. HAZ

Add application temperature range to list.
 111.

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03756

Fisher Controls

Material Specification

FMS 17F28

FLEXIBLE GRAPHITE SHEET
(GASKET MATERIAL)Rev: B/C
By: LHM 6-22-71
Appd: NFE 7-27-80
Page 1 of 1**FISHER**

CONFIDENTIAL

*Fisher Controls 1988, 1991

Revised By: LHM 6-26-88

8-23-91

1. SCOPE

This document describes the graphite material to be used in gasket applications.

2. MATERIAL REFERENCE NOS.

- (a) 0431
- (b) 0438 low chloride per FMS 17F43

3. SPECIFICATIONS

- (a) Thicknesses and Tolerances
 - 0.010" $\pm$.002
 - 0.020" $\pm$.002
 - 0.030" $\pm$.002
 - 0.075" $\pm$.005

(b) Composition

- (1) Graphite 95% Minimum
- (2) Ash 5 Maximum

4. TYPICAL PROPERTIES

- (a) Nominal Density 70 lb/cu. ft.
- (b) Sublimation Point 6600°F

5. ACCEPTED SOURCEUnion Carbide Corporation
Carbon Products Div.

UCAR Carbon Co., Inc.

Trade Name - CTS GrFoil

AUG 29 1991

MAJOR REVISION

ECR/H NO. _____ DATE _____
 BY: LHM CHKD: RTE APVD: NFE
 840, BIDS/STOCK 150, REASON
 1. USE 1. SAFETY 5. STORY
 7. REWORK 2. MAIL 6. COST
 3. SCRAP/REH 3. REWORK 7. MATERIAL
 4. SCRAP/REH 4. REWORK 8. SALES
 Change vendor

ROA_03757

TAYLOR V. 3.M. COMPANY ET AL.

Fisher Controls

Material Specification

FISHERGRAPHITE LAMINATE
(GASKET MATERIAL)

No.	RMS 17P23	
By	JDP	8-4-68
Apvd	TRB	11-8-82
Page	1	of 1
Rev	000	11-8-82

©Fisher Controls

1992

CONFIDENTIAL

WHH 4-30-91

1. SCOPE

This specification describes a laminated graphite material used primarily as a gasket.

2. MATERIAL REFERENCE NO. 0426

3. SPECIFICATIONS

- (a) Composition: Flexible graphite sheet
Ash content: < 0.1%
- (b) Density: 70 lb./cu. ft.
- (c) Sublimation Point: 6500°F
- (d) Recommended use temperature range:
-400°F to 650°F in oxidizing atmosphere
-400°F to 3000°F in inert atmosphere

4. APPROVED SOURCE

- (a) Union Carbide Corp. UCAR Carbon Co.
Carbon Products Div.
Chicago, IL
Trade Name - GYA Grafoil (High Purity Grade)

JUN 16 1992

MAJOR REVISION

ETCH/N NO. _____ DATE 4-30-92

BY WHH	CHKD TRB	APVD DRB
1. CHG. DESCRIPTION	2. REASON	3. ACTION
1. CHG. USE	2. DATE	3. DATE
2. STROKE	2. DATE	3. DATE
3. SIGNATURE	4. IMPROVE	5. DATE
4. SIGNATURE	4. DATE	5. DATE

Company name change.

ROA_03758

TAYLOR V. B.M. COMPANY ET AL.

FISHER®
GOVERNOR CO.
MARSHALLTOWN, IOWA
USA

MATERIAL SPECIFICATION

GRAPHITE LAMINATE
(GASKET MATERIAL)

NO. FMS 17F23 (A)

REVISED JDP 8-7-68

REV. JDP 8-12-68

PAGE 1 OF 1

CONFIDENTIAL

B

Thickness (In.)	.030 ± .002
Density	75 Lb/Cu Ft
Sublimation Point (°F)	6600
Thermal Expansion (10 ⁻⁶ In./In.°F)	
"CN" Direction or Normal to Layers (70-4000° F)	15
"A" Direction or Parallel to Layers	
70-2000° F	-0.2
2000-4000° F	0.5
Compressive Strength (Lb/Sq in.)	
"CN" Direction or Normal to Layers	800
10% Reduction in Thickness	12,000
Ultimate	

Approved Sources:

Union Carbide Corporation
Carbon Products Division
Trade Name - Grafol

GTA

MAJOR REVISION

BY DGS CHAD R. YAKAPUD

DATE 5-1-78

540, OLD STOCK

1. USE

2. RE-MACHINING

3. SCRAP/NEW

4. SCRAP/NEW

820, REASON

1. SAFETY

2. M/P/L

3. IMPROVE

4. ERROR

5. STD20

6. COST

CHANGE IN TRADENAME

FMS 17F20

Rev: CFC
By: KEN 10-26-61
Apvd: TKB 11-8-82
Page 1 of 1

Revised by WHH (8-25-90)

I. SCOPE

3. SPECIFICATIONS

- 7 (a) Composition: Virgin PTFE (polytetrafluoroethylene) with 25% carbon/graphite filler
- (b) Form: Bar or sheet stock, or finished shapes
- (c) Hardness: ASTM 2240 (Type D) 60-70
- (d) Maximum continuous use temperature: 400°C

4. APPROVED SOURCES

- (a) The Mather Co., Fluorotec Div.
Milan, MI.
Compound No. 1-X30-X-01
- (b) Norton Performance Plastics
Elk Grove, IL
Compound No. TF-16 (254)
- (c) Chicago Basket Co.
Chicago, IL
Compound: Ebslon No. 48

JCT 30 1991

FACILITY NO.		DATE	
NAME	TIME	TIME	VER
1. 10:00 AM	10:00 AM	10:00 AM	1. 10:00 AM
2. 10:00 AM	10:00 AM	10:00 AM	2. 10:00 AM
3. 10:00 AM	10:00 AM	10:00 AM	3. 10:00 AM
4. 10:00 AM	10:00 AM	10:00 AM	4. 10:00 AM
5. 10:00 AM	10:00 AM	10:00 AM	5. 10:00 AM
6. 10:00 AM	10:00 AM	10:00 AM	6. 10:00 AM
7. 10:00 AM	10:00 AM	10:00 AM	7. 10:00 AM
8. 10:00 AM	10:00 AM	10:00 AM	8. 10:00 AM
9. 10:00 AM	10:00 AM	10:00 AM	9. 10:00 AM
10. 10:00 AM	10:00 AM	10:00 AM	10. 10:00 AM

API max continuous use temp.

Fisher Controls

Material Specification

No. FMS 17F20

FISHER

PLASTIC ALLOY SEAT RING MATERIAL

By KEL 10-26-61App'd TKB 11-3-62

Page 1 of 1

Fisher Controls 1987. (1983) 1988

Rev NQP 10-13-83

CONFIDENTIAL

1. SCOPE

This specification describes a carbon/graphite filled fluoroplastic material primarily used in seat ring applications and valve stem packing applications.

2. MATERIAL REFERENCE NO. 0690

3. SPECIFICATIONS

- (a) Composition: Virgin ^{PTFE} ~~PTFE resins~~ (polytetrafluoroethylene) with 25% carbon/graphite filler
- (b) Form: Bar or sheet stock, or finished shapes.
- (c) Hardness: ASTM 2240 (Type D) 60-70

4. APPROVED SOURCES

- (a) The Mather Co., Fluorotec Div.
Milan, MI.
Compound No. 1-X30-X-D1
- (b) Halogen Insulator and Seal Corp.
Elk Grove, IL
Compound No. 7F-16 (25%)
- (c) Chicago Gasket Co.
Chicago, IL.
Compound: Ebonol No. 48

MAJOR REVISION SEP 26 1980

ENR/N HG. DATE
BY W/H CHXD R/L APVD WCP
OAG, CUD, CUDC, CUDV, CUDW, CUDX, CUDY, CUDZ
1. REVISION 2. DATE 3. APPROVED 4. SALES
5. REVISION 6. DATE 7. APPROVED 8. SALES
9. REVISION 10. DATE 11. APPROVED 12. SALES

Add application + change to
standard nomenclature.

FISHER & GOVERNOR CO. MARSHALLTOWN, IOWA USA	MATERIAL SPECIFICATION	REV. EHS 17F20 (B)
	PLASTIC ALLOY SEAT RING MATERIAL	ISSUED 10-26-67
	CONFIDENTIAL	REV. 12-23-68
		PAGE 1 OF 1

1. SCOPE

This specification describes a carbon/graphite filled fluoroplastic material primarily used in seat ring applications.

2. MATERIAL REFERENCE NO. 0000

3. SPECIFICATIONS

(a) Composition: Virgin TFE resins (polytetrafluoroethylene) with 25% carbon/graphite filler.

Material - Carbon Filled Plastic - TFE

Hardness - Durometer D62-D66

(b) Form: Bar or sheet, stock, or finished shapes.

(c) Hardness: ASTM D2240 Type D) 60-70

4. APPROVED SOURCES

(a) The Mather Co., Fluorocarbon Div.,
Milan, MI.
Compound No. J-X30-X-01

Approved Compounds:

The Mather Co. Compound #17-01-1095 (4397-1)

Purchase From:

The Mather Company, Fluorocarbon Division
525 Redman
Milan, Michigan 48160

(b) Halogen Insulation and Seal Corp.
Elk Grove, IL.
Compound No. TF-16 (25%)

NOV 17 1982

MAJOR REVISION

BY: <u>RECHD</u>	DATE: <u>11/17/82</u>
1 - DET	2 - SAFETY
2 - RELIABILITY	3 - COST
3 - SCRAP/REWORK	4 - UTILITY
4 - SCRAP R/W	5 - ERROR

Revised to current specifications

TAYLOR V. 3.M. COMPANY ET AL.

ROA_03762

Fisher Controls

Material Specification

FMS 17F16

25% GLASS FILLED PTFE

Rev: **11 J**
 By: FOS 8-4-66
 App'd: TRB 11-8-82
 Page 1 of 1

FISHERFisher Controls 1982, **1988** 1991Revised By: W H H **2-11-89**

7-2-91

CONFIDENTIAL1. SCOPE

This specification describes a glass filled PTFE material used primarily for gaskets, bushings, seat rings, and other special applications.

2. MATERIAL REFERENCE NOS.

- (a) 0418
 (b) 0449 for oxygen service and clean/handle per FOS 8411

3. SPECIFICATIONS

- (a) Composition: Virgin PTFE (polytetrafluoroethylene) with 25% glass filler. Compound should contain no reprocessed PTFE filler. Also no appreciable amount of color or tint should be added. (White, beige or grey acceptable).
 (b) Form: Bar stock, sheet or finished shape.
 (c) Process: Compression molded or ram extruded.

4. APPROVED SOURCES

- (a) Chicago Gasket Co.
 Chicago, IL
 Compound No. 23 Ebolean
 (b) Crane Packing Co.
 Morton Grove, IL
 Compound No. 70006
 (c) Halogen Insulator & Seal Corp.
 Elk Grove, IL
 Compound No. TF-8 (258)
 (d) **Fluorocarbon Co.** *Furon Advanced Polymers Group*
 Mundelein, IL
 Compound No. 409027
 (e) Argo Packing Co.
 Oakmont, PA
 Style No. 704
 (f) United Polymer Co.
 Houston, TX
 Style No. 1025

JUL 22 1991

MAJOR REVISION

ECR/D NO. _____ DATE _____
 BY **W H H** CHKD **DRB** APVD **NER**
 1. **FOR** 2. **REWORK** 3. **REWORK** 4. **REWORK**
 5. **REWORK** 6. **REWORK** 7. **REWORK** 8. **REWORK**
 9. **REWORK** 10. **REWORK** 11. **REWORK** 12. **REWORK**

Update Vendor Name

ROA_03763

TAYLOR V. 3.M. COMPANY ET AL.

Fisher Controls	Material Specification	No. FMS 17F16	(E)
FISHER	25% GLASS FILLED TFE RESIN	By FJS	A-4-65
		Appd. TKB	11-8-67
		Page 1	of 1
©Fisher Controls	982, 985, 1788	Rev. NRP	4-26-85

1. SCOPE

This specification describes a glass filled (IFE resin) material used primarily for gaskets, bushings, seat rings, and other special applications.

2. MATERIAL REFERENCE NOS.

(b) D449 for oxygen service and clean/handle per PGS-8A11

Virgin PTFE

- (a) Composition: TFE resin (polytetrafluoroethylene) with 25% glass filler. Compound should contain no reprocessed TFE filler. Also no appreciable amount of color or tint should be added. (White, beige or light gray acceptable).
- (b) Form: Bar stock, sheet or finished shape.
- (c) Process: Compression molded or ram extruded.

- (A) Chicago Gasket Co.
Chicago, IL.
Compound No. 23 Ebonol
- (b) Crane Packing Co.
Morton Grove, IL.
Compound No. 70006
- (c) Nather Co., Fluorotec Div.
Milan, MI.
Compound No. 1-005-X-01
- (d) Halogen Insulator & Seal Corp.
Elk Grove, IL.
Compound No. TF-8 (25%)

APR 26 1968

SEARCH NO. _____ DATE _____
BY WHH JWB DES MFT
NO. OF PAGES 7
1 - NAME 6 - TITLES
2 - AGENT 0 - CITY
3 - RESIDENCE 7 - EXTRA
4 - SPECIAL AGENT 4 - OTHER SALES

Upgrade nomenclature

Fisher Controls	Material Specification	No.	FMS 17716
FISHER	GASKET AND BUSHING MATERIAL	By	FJS 8-4-65
		APPROVED	11-8-82
		Page	1 of 1
Fisher Controls	1982, 1984	REV	12-9-82

CONFIDENTIAL

1. SCOPE

This specification describes a glass filled TFE resin material used primarily for gaskets and bushings, seat rings, and other special applications.

2. MATERIAL REFERENCE NOS.

- (a) 0418
- (b) 0449 for oxygen service and clean/handle per PCS 8A11

3. SPECIFICATIONS

- (a) Composition: TFE resin (polytetrafluoroethylene) with 25% glass filler. Compound should contain no reprocessed TFE filler. Also no appreciable amount of color or tint should be added. (White, beige or light gray acceptable).
- (b) Form: Bar stock, sheet or finished shape.
- (c) Process: Compression molded or ram extruded.

4. APPROVED SOURCES

- (a) Chicago Gasket Co.
Chicago, IL
Compound No. 23 Ebalon
- (b) Grano Packing Co.
Morton Grove, IL
Compound No. 70006
- (c) Peabody Dove Co.
Houston, TX
Fluorobrown E-120
- (d) Mather Co., Fluorotec Div.
Milan, MI
Compound No. 1-005-X-01
- (e) Halogen Insulator & Seal Corp.
Elk Grove, IL
Compound No. TF-B (25%)

JUL 18 1984

MAJOR REVISION
BY HRP CHKD *[initials]* APVD *[initials]*
DATE *[blank]*

010 OLD STOCK	130. REASON	
1 X USE	1 SAFETY	5 STRENGTH
2 REMACHINE	2 X UATL	6 COST
3 SCRAP/REWORK	3 IMPROVE	7 HX12
4 SCRAP HOW	4 ERROR	8 SALES

ADD HANDGEN MAT'L

 MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. FMS 17P16
	GASKET AND BUSHING MATERIAL		ISSUED FJS 844
			REV. (43) 9-26-7
			PAGE 1 OF 1

1. SCOPE

This specification describes a glass filled TFE resin material used primarily for gaskets and bushings.

Glass Filled TFE Gasket and Bushing Material
 25% Glass Filled
 No Reprocessed TFE Filler
 No Color or Tint Added
 (White, Beige, or Light Gray Acceptable)

CONFIDENTIAL

2. MATERIAL REFERENCE NOS.

(a) 0419

(b) 0449 for nigger service and clean/handle per FGS 8411

3. SPECIFICATIONS

(a) Composition: TFE resin (polytetrafluoroethylene) with 25% glass filler. Compound shall contain no reprocessed TFE filler. Also no appreciable amount of calc. extant shall be added. (White, beige or light gray acceptable).

Approved Sources and Material Specifications:

Chicago Gasket Co.
 Chicago, Illinois
 #22 Ebelon

Crane Packing Co.
 Morton Grove, Illinois
 Matl. No. 70006

John L. Dore Co.
 Houston, Texas
 Fluorobrown E-120

Harber Company, Fluorotec Division
 Milan, Michigan
 Resin X-105

Sparta Manufacturing Co.
 Dover, Ohio
 Fluorospax 725B

(b) Form: Bar stock, sheet or finished shape.

(c) Process: Compression molded or ram extruded.

4. APPROVED SOURCES

(a) Chicago Gasket Co.
 Chicago, IL.
 Compound No. 22 Ebelon

(b) Crane Packing Co.
 Morton Grove, IL.
 Compound No. 70006

(c) Peabody Dore Co.
 Houston, TX.
 Fluorobrown E-120

(d) Harber Co., Fluorotec Div.

NOV 17 1982

MAJOR REVISION

BY TECHNO	DATE 11/17/82
APPROVED TRB	
1 - USE	1 - SAFETY
2 - RELIABILITY	2 - LIATE
3 - SCRAP/NEW	3 - IMPROVE
4 - SCRAP NOW	4 - ERROR
	5 - STOW
	6 - COST
	7 - MFG/SALES

Revised to current spec. and

Fisher Controls

Material Specification

FLUORINATED ETHYLENE PROPYLENE
RESIN (FEP)
PLASTIC, FEP

FISHER

No.	PMS 17F12
By	PMK 1-16-64
Appd.	TAB 11-8-82
Page	1 of 1
Rev	11-8-82

Fisher Controls 1982, 1990

CONFIDENTIAL

1. SCOPE

This specification describes a general purpose ~~FEP~~ ^{fluorinated ethylene propylene (FEP)} resin material used in a variety of applications, such as, bearings, valve discs, valve stem packings, wipers, diaphragm protectors and valve linings. In general, FEP and ~~PTE~~ have similar chemical resistance, however FEP has a lower upper temperature limit and is less porous than ~~PTE~~ due to its melt processability.

2. MATERIAL REFERENCE NO. 0548

3. SPECIFICATIONS

(a) Composition: Material composed of unfilled FEP resin

~~(Fluorinated ethylene propylene)~~

Note: Material may contain inorganic coloring.

(b) Form: Standard rod, cube or finished shapes. It is usually not available in sheet form.

(c) Process: Injection molded or melt extruded.

(d) Typical Physical Properties

Tensile strength @ 73°F, ASTM D638	3000 psi
Hardness, ASTM D2240 (Type D)	57 to 60
Deformation under load, 1200 psi, 122°F, 24 hrs., ASTM D621	6%
Water Absorption, ASTM D570	< 0.01%
Flammability, UL94	V-0

4. APPROVED MATERIAL

DuPont Co.
Teflon FEP

MAJOR REVISION

DATE SEP 07 1990

EGR/H NO.	BY WHM	CHKD	DATE	APVD	NFR
NO. DISCARD	1 - SAFETY	5 - STAIN			
1 - USE	2 - MAIL	6 - COST			
2 - REUSE	3 - IN PROGRESS	7 - RETO			
3 - REPAIR/REWORK	4 - REUSE	SALES			

change title, all reference to PTFE

Fisher Controls

Material Specification

FMS 17F11

POLYCHLOROTRIFLUOROETHYLENE
MOLDED PRODUCTS

Rev: *G*
By: RRB 4-26-62
Apvd: NFR 9-11-67
Page 1 of 1

FISHER

Fisher Controls 1907, 1991

Revised By: WHH 10-10-91

CONFIDENTIAL

1. SCOPE

This specification covers polychlorotrifluoroethylene (CTFE) products used primarily as ball valve seals, valve discs or seats, diaphragm protectors, and gaskets.

References

2. MATERIAL REFERENCE NO.

0507

06CA for oxygen service, clean and handle per FGS 6A11

053L water quenched with minimum zero strength temperature of 320°F

3. SPECIFICATIONS

(a) Composition: Unplasticized polychlorotrifluoroethylene conforming to ASTM D1430-81, Type 1, Grade 1, Class C.

(b) Form: Sheet or molded parts

(c) Process: Melt extrusion or compression molded

(d) Typical physical properties:

Tensile strength @ 73° F, ASTM D638

5000 psi

Elongation-at-fail @ 73° F, ASTM D638

175%

Flexural modulus @ 73° F, ASTM D790

250,000 psi

Hardness @ 73° F, ASTM D2240 (Type D)

75

4. APPROVED MATERIALS

(a) 3M Co.
St. Paul, MN
Kel-F 81, Type 6060 or 6061

(b) Daikin-Kogyo Co.
Osaka, Japan
Daiflon CTFE, Type M-400H

FEB 10 1998

MAJOR REVISION

EGRM No. *961398* Date *9-11-99*
By *AKA* Chkd *DHN* Apvd *TGG*
M0, CM SSK 030, FMS
1. UBE 1. SAFETY 5. STUDY
2. RENCOK 2. MAIL 6. COST
3. SONARIN 3. WAREHO 7. WRITY
4. SCRAP NOW 4. ERMCH 8. SALES

Updated to the new electronic format.
Any changes in appearance, paragraph
numbering, etc. were to accommodate
the new document format style. The
appearance of the document will not
be the same as before. NO CHG NCT

TO CONTENT
A-DDED REVISION

ROA_03768

TAYLOR V. 3.M. COMPANY ET AL

Fisher Controls

Material Specification

FMB 17P11

POLYCHLOROTRIFLUOROETHYLENE
MOLDED PRODUCTSRev: D
By: RGR 4-26-62
Apvd: NFR 9-11-67
Page 1 of 1**FISHER**

Fisher Controls 1987, 1782

Revised By: W.H.H. 10-26-68

CONFIDENTIAL

1. SCOPE

This specification covers polychlorotrifluoroethylene (CTFE) products used primarily as ball valve seals, valve discs or seats, diaphragm protectors, and gaskets.

2. MATERIAL REFERENCE NO.

0507

06CA for oxygen service, clean and handle per FGS 8A11

3. SPECIFICATIONS

- (a) Composition: Unplasticized polychlorotrifluoroethylene conforming to ASTM D1430-61, Type 1, Grade 1, Class C.
- (b) Form: Sheet or molded parts
- (c) Process: Melt extrusion or compression molded
- (d) Typical physical properties:

Tensile strength @ 73° F, ASTM D638	5000 psi
Elongation-at-break @ 73° F, ASTM D638	175%
Flexural modulus @ 73° F, ASTM D790	250,000 psi
Hardness @ 73° F, ASTM D2240 (Type D)	76

4. APPROVED MATERIALS

- (a) 3M Co.
St. Paul, MN
Rel-F 81, Type 6060 or 4061
- (b) Daikin-Kogyo Co.
Osaka, Japan
Daiflon CTPE, Type M-400H

SEP 26 1968

MAJOR REVISION

ECR/N NO.	DATE
BY <u>W.H.H.</u> CHRO <u>DRB</u> APVD <u>NFR</u>	
012.001.1002	1. 10/1/67
1. 10/1/67	2. 10/1/67
2. 10/1/67	3. 10/1/67
3. 10/1/67	4. 10/1/67
4. 10/1/67	5. 10/1/67
5. 10/1/67	6. 10/1/67
6. 10/1/67	7. 10/1/67
7. 10/1/67	8. 10/1/67
8. 10/1/67	9. 10/1/67
9. 10/1/67	10. 10/1/67

ALL new compound number.

CONFIDENTIAL

FISHER GOVERNOR CO. MARSHALLTOWN, IOWA USA	MATERIAL SPECIFICATION		NO. FMS 17E11 ISSUED AKB 4-26-62 REV. met 11-30-62 PAGE 1 OF 1
	Kel-F Molded Sheet, LOX Grade POLYCHLOROTRIFLUOROETHYLENE MILDRED PRODUCTS		

1. SCOPE

This specification covers polychlorotrifluoroethylene (CTFE) products used primarily as ball valve seats, valve discs or seats, diaphragm protectors, and gaskets.

2. MATERIAL REFERENCE No.

0507

3. SPECIFICATIONS

- (a) Composition: Unplasticized polychlorotrifluoroethylene conforming to ASTM D 1130-61, Type I, Grade 1, Glass C.
- (b) Form: Sheet or molded parts
- (c) Process: Melt extrusion or compression molded.

Kel-F Molded Sheet
 Kel-F 81 Grade 3
 For LOX Service
 Unplasticized

delete.

(d) Typical physical properties:

Tensile strength @ 73°F, ASTM D 638	5000 psi
Elongation-at-break @ 73°F, ASTM D 638	175%
Flexural modulus @ 73°F, ASTM D 790	250,000 psi
Hardness @ 73°F, ASTM D 2240 (Type D)	70

Approved Sources:

Allied Nucleonics Corporation

delete

4. APPROVED MATERIALS

- (a) 3M Co.
 St. Paul, MN
 Kel-F 81, Type 1, Grade 1
- (b) Daikin-Kogyo Co.
 Osaka, Japan
 Daiflon CTFE, Type M-400H

MAJOR REVISION

FOR/H NO.	DATE
BY WHN	02 OCT 02 1987
1. J. H. H. H.	1. J. H. H. H.
2. J. H. H. H.	2. J. H. H. H.
3. J. H. H. H.	3. J. H. H. H.
4. J. H. H. H.	4. J. H. H. H.

Fisher Controls

Document Cover Sheet

FMS 17G24

SILICONE RUBBER GASKET MATERIAL

 Rev: J. K.
 By: WFR 8-13-84
 AFVD: NFR 8-14-84
 Page 0.1
FISHER**CONFIDENTIAL**

Fisher Controls 1984, 1991

Revised By: NFR 8-23-91

This page is the cover sheet of all documents containing 3 or more pages of specifications. The table below shows the revision level for each page of this document. A revision of this page will be made when any page of this document is revised. When referring to this document specify the revision level of this page.

PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL

0.1

1

2

3

4

MAJOR REVISIONECRN No. 9161398 Date 4/14/97By DM Chkd MD Apvd JCS

1. OBS	1. SAFETY	6. STCH
2. REWORK	2. MATL	8. COST
3. SCRAP/NEW	3. IMPROVE	7. MKTG
4. SCRAP/NEW	4. GRNCH	SALES

Updated to the new electronic format.
 Any changes to appearance, paragraph
 numbering, etc., were to accommodate
 the new document format style. The
 appearance of the document will not
 be the same as before. NO CHANGES
 TO CONTENT.

MAY 18. 1998

CONFIDENTIAL

Fisher Controls	Material Specification	No. EMS 17624	1
FISHER	SILICONE RUBBER GASKET MATERIAL	By DZ	S-1-SB
		App NRP	B-14-B4
		Page 1 of	
@Fisher Controls		Rev NRP	B-13-B4

1. SCOPE

This specification applies to rubber materials to be used as gaskets under adverse ambient temperature conditions, and in contact with air, natural gases, or other specialized services. Silicone rubber parts under this specification are used as gaskets in various types of gas or liquid control instruments. The gaskets may be of several shapes and sizes and will normally be used to seal air (or gas) pressures not in excess of 100 psig. The material usually would be used in applications where the control assemblies are subject to high or low ambient temperatures. The gaskets are generally used in specialized applications, and the normal service life of the assembly may be as much as 15 years or more without inspection or repair.

2. MATERIALS REFERENCE NOS. 0414 & 0447 for oxygen service per FGS BALL (C)
~~BA151 Delete~~ ~~Delete~~

3. BASIC MATERIAL AND PARTS

Solid synthetic rubber sheet cut into gaskets of various thicknesses, shapes, and sizes. The sheet or parts may be required to have manufacturer's identification marking as may be designated on detail drawings or at the end of this specification. The thickness tolerance of the sheet or cut gaskets shall be as follows:

Standard 1/64" thick - 0.016" ±.002"
 1/32" thick - 0.031" ±.003"
 1/16" thick - 0.062" ±.006"

4. SURFACE AND GENERAL QUALITY

The finished surfaces of the sheet or cut gaskets shall be smooth and free of imperfections such as holes or embedments of foreign particles. The material shall contain no flaws, voids, or inclusions and any cross section shall be dense, and free from porosity and other imperfections when a cut edge is viewed under 18 x to 20 x magnification.

5. SERVICE TEMPERATURE

The material shall not deteriorate and shall function properly in the designated service at temperatures of -60°F to +400°F.

FMS2-3/1
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MAJOR REVISION DATE JAN 18 1990
 FOR MAJOR REVISION STAMP
 INFORMATION SEE COVER SHEET
 REVISION G TO H

CONFIDENTIAL

 FISHER Controls MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. MS 17G24
	SYNTHETIC RUBBER GASKET MATERIAL		RESD D E 5-1-58
			REV 2 7-10-75
			PAGE 2 OF 2

12. Dimensional Tolerances - The thickness tolerance of the sheet or cut gaskets shall be as follows:

Standard 1/64" thick - 0.016" $\pm$.002"
 1/32" thick - 0.031" $\pm$.003"
 1/16" thick - 0.062" $\pm$.005"

13. Cold Temperature Resistance - Material must not be brittle after 5 hours at -90°F. Hardness must not exceed 90 Durometer A at -60°F. The hardness increase between 75°F and -60°F shall not be greater than 10 points Durometer A on any given sample.
14. Compression and Recovery - After loading a 1/2" thickness of the material to 400 psi at 75°F for 24 hours and allowing it to recover without load for 24 hours, the thickness shall return to within 6.5% of the original.
15. Aging Qualities - The material must have excellent aging qualities. After oven aging for 7 days at 350°F, the material shall show no visual evidence of cracking or other deterioration and the tensile strength shall not have changed by more than 10%. The material shall not be subject to surface cracking or checking under stressed static loading for long periods of time at ambient temperatures.
16. Qualification Testing - Items 3 through 15 as given above shall be considered as qualification tests which will be performed by Fisher Controls prior to approval of any material to be used under this specification. Following qualification approval of a material by Fisher Controls, the vendor of such material shall make no changes in the product without notifying Fisher of said changes and the possible need for re-qualification testing.
17. Quality Control - Items 3, 4, 5, 6, and 12 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of a production material approved under this specification.

On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.

18. Approved Materials - The following materials are considered as approved for production use under this specification.

A. DuPont No. 55-0070 (Silicone).

AUG 21 1984

FAIRBANKS

55-5570

CHANGE DuPont
 TO FAIRBANKS
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MAJOR REVISION		DATE
BY <u>AKS</u>	CHKD <u>WCH</u>	APVD <u>WPR</u>
1 - DESIG	2 - SAFETY	3 - DESIGN
4 - MATERIAL	5 - COST	6 - MFG
7 - SCRAPING	8 - FINISH	9 - OTHER
10 - SCRAPING	11 - FINISH	12 - OTHER

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Material Specification

FMS 17G24

SILICONE RUBBER GASKET MATERIAL

Rev: ^B_C
By: WHH 8-13-84
Appl: NFR 8-14-84
Page 3

FISHER

Fisher Controls

Revised By: WHH 1-4-90
WHH 8-22-91

TABLE 1
QUALITY CONTROL & QUALIFICATION TESTS

Property	Test Method	Units of Measurement	Criteria (1)
Hardness	POS 11A1	Shore "A" Durometer	70±5
Basic Material	—	—	See Section 3
Resilience	POS 11A2	Dashore	40±10
Surface and General Quality	POS 11A9	—	See Section 4

Note: (1) All properties measured at 70±15°F.

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INFORMATION SEE COVER SHEET
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Fisher Controls	Material Specification	No. FHS 17624	4
FISHER	SILICONE RUBBER GASKET MATERIAL	By WHH	8-13-84
		App NFR	8-14-84
		Page 3	of
©Fisher Controls		Rev	

TABLE 1
QUALITY CONTROL & QUALIFICATION TESTS

Property	Test Method	Units of Measurement	Criteria
Hardness	FGS 11A1	Shore "A" Durometer	70±5
Basic Material	---	---	See Section 3
Resilience	FGS 11A2	Dashore	40±10
Surface and General Quality	FGS 11A9	--	See Section 4

FMS2-3/3

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FMS 17G10

NEOPRENE RUBBER MATERIAL
95-96 DUREOMETER A HARDNESS

Rev: 10/P
By: WJS 09-13-54
Apvd: MFR 11-26-54
Page 0.1

FISHER

Fisher Controls 1982, 1984

Revised By: EDG 1-11-84

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PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL
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1	K						
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1.2	(B)B						
2	L						
3	C						
4	B						

MAJOR REVISION

ECAN No. 960950 Date 1-18-96
By: TGG Chkd: DKB, Apvd: [Signature]
040, Chk Stock
1. XUSE
2. FIGWORK
3. SCRAP NEW
4. SCRAP NOW
1. SAFETY
2. MAIL
3. IMPROVE
4. ERROR
5. STUZN
6. COST
7. SAKTV
8. SALES

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FMS 17G10

NEOPRENE RUBBER MATERIAL
85-95 DUROMETER A HARDNESS

Rev: CD M
By: RJS 09-13-52
Apvd: NFR 11-26-84
Page 0.1

FISHER

Fisher Controls 1982, 1990 1991

Revised By: WHH 9-11-90

8-23-91

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AUG 29 1991

MAJOR REVISION

ECR/N NO. DATE
BY WHL CHKD RJE APVD NFR
DAD, OLD STOCK ☒ 1. SATISF 5. OTHER
1.25 USE ☒ 2. MATL 6. COST
2. RETWORK ☒ 3. MFG PROVL 7. MISC
3. SCRAP/NEW ☒ 4. ERROR
4. SCRAP/OLD ☒
Add hardness change

TAYLOR & FRANCIS COMPANY, LTD.

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Fisher Controls

Material Specification

JAN 17 1984 FMB 17G10

NEOPRENE RUBBER MATERIAL,
85-95 DURENSTER A HARNESS

Rev: ③K
Dy: FUS 09-12-52
Apd: NFR 11-26-84
Page 1

FISHER

Fisher Controls

Revised By: W H H 9-11-90

1. SCOPE

This specification applies to rubber materials to be used as valve seat discs or gaskets which will be in contact with commercial Propane and Butane vapors and liquid, natural gas, anhydrous ammonia vapor and liquid, and all impurities normally contained in these fluids. Molded or cut parts made from materials approved under this specification are used as seat discs or gaskets in pressure regulators and valves which control the flow of various fluids. The discs are generally of circular shape and are attached to or contained in a metal holder. The part serves to form a tight shutoff seal, usually seating against a rather sharp-edged metal orifice which may tend to cause cutting or severe indentation of the rubber. The assembly is used in a system where the parts may be subjected to a maximum of 300 psig gas pressure. The normal service life of the assembly may be as much as 15 years or more without inspection or repair.

2. MATERIALS REFERENCE NO. 0303

3. BASIC MATERIAL

Synthetic rubber molded or cut in the form of circular shaped discs of various thicknesses and diameters, and molded or lathe-cut rings of several shapes, thicknesses and diameters. Parts may be required to have manufacturer's identification markings as may be designated on detail drawings or at the end of this specification.

3.1, 3.2, 3.3 (See attached 3.4)

5. SURFACE AND GENERAL QUALITY

The finished surfaces of the molded parts shall be smooth and free of imperfections such as holes or embedments of foreign particles. The material shall contain no flaws, voids, or inclusions and any cross-section shall be dense and free from porosity and other imperfections when a cut edge is viewed under 10x to 20x magnification. Molded undercuts such as "snap-on discs" must not have any cracks or tears resulting from stripping the disc from the mold.

When ground with a suitable grinding wheel, the resulting ground surface shall be a smooth, non-porous surface.

6. SERVICE TEMPERATURE

The material shall not deteriorate and shall function properly in the designated service at temperatures of -40°F to +180°F.

MAJOR REVISION DATE 7-11-91

FOR MAJOR REVISION STAMP

INFORMATION SEE COVER SHEET

REVISION A TO H

Fisher Controls 	Material Specification NEOPRENE RUBBER MATERIAL 85-95 DUROMETER A HARDNESS		No. FMS 17610 H
	CONFIDENTIAL		By FJS 9-13-52
			App NPK 11-26-54
	© Fisher Controls	Page 2 of	Rev WTH 12-12-56

6. QUALIFICATION TESTING

Fisher Controls shall perform the qualification tests listed in Tables 1 and 2 prior to approval under this specification. Following approval, the vendor of such material shall make no changes in the product without notifying Fisher Controls of said changes and the possible need for re-qualification.

7. QUALITY CONTROL TESTING

The tests listed in Table 1 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of a production material approved under this specification. On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.

8. PARTS IDENTIFICATION

The letters "GID" shall be printed on one face of each flat seat disc when the size of the part will allow. Printing color for each supplier shall be as listed below. Other identification where required for parts shall be as noted on the part drawing.

9. APPROVED MATERIALS

The following materials are considered as approved for production use under this specification.

- (a) Polmar Laboratories, Inc. AT64-R(1) (Neoprene) - identification color, tan..
- (b) Minnesota Rubber Co. 570A (Neoprene) - identification color, silver (may also have sprue dot on back side).

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 REVISION I TO K

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By FTS	9-13-52

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Page 0.1 of

B. Fisher Controls 1982, 1986

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NEOPRENE RUBBER MATERIAL
85-95 DUROMETER A HARDNESS

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WITHOUT PRIOR APPROVAL OF: UL

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Fisher Controls	Material Specification		No. FMS 17610
	NEOPRENE RUBBER MATERIAL 85-95 DUROMETER A HARDNESS		By FTS 9-13-57
			App. NRP 11-22-60
			Page 1 of
© Fisher Controls			Rev. NRP 11-19-65

1. SCOPE

This specification applies to rubber materials to be used as valve seat discs or gaskets which will be in contact with commercial Propane and Butane vapors and liquid and with natural gas and all impurities contained in these gases. ~~Contact with liquid or vapor ammonia should be avoided.~~ Molded or cut parts made from materials approved under this specification are used as seat discs or gaskets in pressure regulators and valves which control the flow of liquefied petroleum gases and natural gases. The discs are generally of circular shape and are attached to or contained in a metal holder. The part serves to form a tight shutoff seal, usually seating against a rather sharp-edged metal orifice which may tend to cause cutting or severe indentation of the rubber. The assembly is used in a system where the parts may be subjected to a maximum of 300 psig gas pressure. The normal service life of the assembly may be as much as 15 years or more without inspection or repair.

2. MATERIALS REFERENCE NO. 0303

3. BASIC MATERIAL

Synthetic rubber molded or cut in the form of circular shaped discs of various thicknesses and diameters, and molded or lathe-cut rings of several shapes, thicknesses and diameters. Parts may be required to have manufacturer's identification markings as may be designated on detail drawings or at the end of this specification.

4. SURFACE AND GENERAL QUALITY

The finished surfaces of the molded parts shall be smooth and free of imperfections such as holes or embedments of foreign particles. The material shall contain no flaws, voids, or inclusions and any cross-section shall be dense, and free from porosity and other imperfections when a cut edge is viewed under 10x to 20x magnification. Molded undercuts such as "snap-on discs" must not have any cracks or tears resulting from stripping the disc from the mold.

When ground with a suitable grinding wheel, the resulting ground surface shall be a smooth, non-porous surface.

5. SERVICE TEMPERATURE

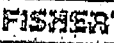
The material shall not deteriorate and shall function properly in the designated service at temperatures of -40°F to +180°F.

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Fisher Controls		Material Specification		No. FMS 17810	
		NEOPRENE RUBBER MATERIAL (90-95) DUROMETER A HARDNESS 85-95		By <u>FJS</u> 9-13-52 App'd <u>NRP</u> 11-26-54 Date 2 of	
		CONFIDENTIAL		Rev <u>NRP</u> 11-19-54	

6. QUALIFICATION TESTING

Fisher Controls shall perform the qualification tests listed in Tables 1 and 2 prior to approval under this specification. Following approval, the vendor of such material shall make no changes in the product without notifying Fisher Controls of said changes and the possible need for re-qualification.

7. QUALITY CONTROL TESTING

The tests listed in Table 1 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of a production material approved under this specification. On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.

8. PARTS IDENTIFICATION

The letters "GLO" shall be printed on one face of each flat seat disc when the size of the part will allow. Printing color for each supplier shall be as listed below. Other identification where required for parts shall be as noted on the part drawing.

9. APPROVED MATERIALS

The following materials are considered as approved for production use under this specification.

- (a) Pelmar Laboratories, Inc. AT64-R(1) (Neoprene) - identification color, green.
- (b) Minnesota Rubber Co. 570A (Neoprene) - identification color, silver (may also have sprue dot on back side).
- (c) Goshen Rubber Co. 1754 (Neoprene) - identification color, yellow.

NOV 27 1955

ALTER QUALIFICATION REQUIREMENTS TO REFLECT STD. TESTS AND APPROVED MATERIALS		MAJOR REVISION ECR/H NO. <u>NA</u> BY <u>NRP</u> <u>CHD</u> <u>WHL</u> <u>APD</u> <u>NRP</u> 018 FMS 17810 1 X ACE 2 X NRP 3 X CHD 4 X WHL		DATE 11-26-54 11-19-54 11-19-54 11-19-54

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TAYLOR V. B. COMPANY ET AL

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By: WMA		11-19-84			
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NEOPRENE RUBBER MATERIAL
90-96 DUROMETER A HARDNESS
85-95

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FISHER GOVERNOR CO. MARSHALLTOWN, IOWA USA	MATERIAL SPECIFICATION SYNTHETIC RUBBER DISC MATERIAL CONFIDENTIAL	NO. PMS-47G10 E ISSUE FJS 9-13-52 REV NRP-1-14-52 PAGE 1 OF 2

UPDATE FORMAT
 REMOVE OLD CLOW & ADAPT.
 RESTRUCTURE TESTS (NEW ORS.)
 CHANGE OLD TEMP. RESISTANCE
 REQUIREMENTS. ADD NEW DATA
 + 2 NEW PAGES.

MAJOR REVISION
 BY **W. B. WILKINSON**
 DATE **NOV 27 1954**

1. **General** - This specification applies to rubber materials to be used as valve seat discs which will be in contact with commercial Propane and Butane vapors and liquid and with natural gas and all impurities contained in these gases.
2. **Scope of Application** - Molded or cut parts made from materials approved under this specification are used as seat discs in pressure regulators and valves which control the flow of liquefied petroleum gases and natural gases. The discs are generally of circular shape and are attached to or contained in a metal holder. The part serves to form a tight shut-off seal, usually seating against a rather sharp-edged metal orifice which may tend to cause cutting or severe indentation of the rubber. The assembly is used in a system where the parts may be subjected to a maximum of 300 psig gas pressure. The normal service life of the assembly may be as much as 75 years or more without inspection or repair.
3. **Basic Material and Parts** - Synthetic rubber molded or cut in the form of circular shaped discs of various thicknesses and diameters. Parts may be required to have manufacturer's identification markings as may be designated on detail drawings, or as listed in Section 10 of this specification.
4. **Hardness** - 90 to 95 Durometer A at 75°F. (76 to 92 Durometer B.)
5. **Resilience** - 30 ± 10 Bashore at 75°F.
6. **Surface and General Quality** - The finished surfaces of the molded parts shall be smooth and free of imperfections such as holes or embedments of foreign particles. The material shall contain no flaws, voids, or inclusions and any cross-section shall be dense, and free from porosity and other imperfections when a cut edge is viewed under 16x to 20x magnification. Molded undercuts such as "snap-on discs" must not have any cracks or tears resulting from stripping the disc from the mold. When ground with a suitable grinding wheel, the resulting ground surface shall be a smooth, non-porous surface.
7. **Anti-Sticking Quality** - The material shall be compounded to provide maximum resistance against sticking to brass, to die cast materials, and to other metals, when the material is pressed against these metals for long periods of time at loads up to 2500 psi.
8. **Service Temperature** - The material shall not deteriorate and shall function properly in the designated service at temperatures of -40°F to +160°F.
9. **Tensile Strength** - 1800 ± 7000
400 psi at 75°F.
10. **Elongation** - 100 ± 100 %
40 at 75°F.
11. **Fluid Resistance**
 - Swelling** - During immersion for 96 hours at 75°F with dimensional checks being made every 24 hours, the volumetric swell in Hexane shall not exceed 20%. After immersion for 120 hours at 75°F in liquid Propane, the volumetric swell shall not exceed 10%.
 - Shrinkage** - The maximum volumetric shrinkage after removal from the cooking fluids and air dried at 75°F until no further change shall not exceed: Hexane, -5%, liquid Propane, -10%.

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FISHER
GOVERNOR CO.
USHALLTOWN, IOWA
USA

MATERIAL SPECIFICATION

SYNTHETIC RUBBER DISC MATERIAL

INC. FMS 17G10
ISSUED FJ6 9-13-52
REVISED 9-5-7-73
PAGE 2 OF 2

BY NRP CHIEF ENGINEER
DATE 10/18/52
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Cold Temperature Resistance - Material must not be brittle after 5 hours at -10°F. Hardness must not exceed 95 Durometer B at -20°F. The hardness increase between 75°F and -20°F shall not be greater than 15 points Durometer B on any given sample.

Compression and Recovery - After loading a 1/2" thickness of the materials to 400 psi at 75°F for 24 hours and allowing it to recover without load for 24 hours, the thickness shall return to within 1.5% of the original.

Cold Flow Resistance - When a disc of 5/16" Dia. by 3/16" thick is loaded to 2500 psi for 24 hrs. at 75°F, it shall not have a set of more than .020" (thickness decrease) 24 hrs. after removal of the load.

Indentation Resistance - When a disc of 5/16" Dia. by 3/16" thick is installed in a metal holder which supports both the bottom and sides of the disc and a load of 2500 psi is applied by a 5/32" Dia. flat anvil (centered on sample) for 24 hrs. at 75°F, the disc shall not show any signs of cutting nor shall it have an indentation of more than .020" immediately upon removal of the load.

16. Aging Qualities - The material must have excellent aging qualities. After oven aging for 14 days at 212°F, the material shall show no visual evidence of cracking or other deterioration and the tensile strength shall not have changed by more than 25%. The material shall not be subject to surface cracking or checking under high stress static loading for long periods of time at ambient temperature.
17. Quality Control - The vendor shall conduct adequate tests (maintaining records of same) on each production batch of the material to determine that the resilience, hardness, strength, and other physical properties are maintained within proper limits. Fisher Controls Company quality control procedures apply to all of the preceding requirements. Samples of any production batch which do not meet the requirements shall be subject to replacement by the vendor.
18. Parts Identification - The letters "G10" shall be printed on one face of each disc when the size of the part will allow. Printing color for each supplier shall be as listed below.
19. Approved Materials - The following materials are considered as approved for production use under this specification.
 - A. Peimor Laboratories, Inc. AT64-R(1) (Neoprene) - identification color, green.
 - B. Minnesota Rubber Co. 570A (Neoprene) - identification color, silver (may also have sprue dot on back side).
 - C. Goshen Rubber Co. 1754 (Neoprene) - identification color, yellow.

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Fisher Controls

Material Specification

FMS 17010

NEOPRENE RUBBER MATERIAL
85-95 DUREMETER A HARDNESS

Rev: 20
By: WHE 11-19-84
Apvd: NFR 11-26-84
Page 4

FISHER

Fisher Controls

Revised By: WHE 11-19-84

8-23-91

TABLE 2
ADDITIONAL QUALIFICATION TESTS

Property	Test Method	Units of Measurement	Criteria(3)
Tensile Strength	FGS 11A8	PSI	1400 min.
Tensile Elongation	FGS 11A8	%	60 min.
Cold Resistance	FGS 11A3		
(a) Hardness incr. RT to -40°F		Shore Duro	20 pts. max.
(b) Hardness at -40°F		Shore Duro	95B max. or 80D max.
(c) 180° Bend at -60°F, after 5 hrs.		pass/fail	pass
Compression Set 400 PSI, RT, 24 H.	FGS 11A4 (Type A)	%	1.5% max.
Oven Aging, 0 7 days at 212°F	FGS 11A8	change in tens. str.	+25% (1)
Fluid Resistance	FGS 11A5		
(a) Liquid anhydrous, Ammonia 5d, RT		Volume swell	15% max.
+ air dry		Volume shrink	-8% max.
Anti-Sticking Quality			See Note (2)

Notes:

- (1) The material shall show no visual evidence of cracking or other deterioration. Also, the hardness change shall not exceed +10 points.
- (2) The material shall be compounded to provide maximum resistance against sticking to brass, die cast materials and other metals, when the material is pressed against these metals for long periods of time at loads up to 2500 PSI.
- (3) All properties except cold resistance measured at 70±5°F.

MAJOR REVISION

DATE > AUG 20 1991

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TAYLOR V. 2 & COMPANY ET AL

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JAN 17 1984

Fisher Controls

Material Specification

No. FGS 17610

FISHER

NEOPRENE RUBBER MATERIAL
85-95 DURENOMETER A HARDNESS

D/W/H 11-19-84

APR 11-26-84

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Fisher Controls

NEB 11-19-85

TABLE 1

QUALITY CONTROL & QUALIFICATION TESTS

Property	Test Method	Units of Measurement	Criteria
Hardness	FGS 11A1	Shore Durenometer A	90±5 (1) or 75±5 (2)
Resilience	FGS 11A2	Bashore	25±10
Surface and General Quality	FGS 11A9	--	See Section 4
Fluid Resistance	FGS 11A5		
(a) Hexane 96 hrs. at R.T. + air dry to equilibrium		Volume Swell	+20% max.
		Volume Shrink	-8% max.
(b) Liquid Propane 120 hrs. at R.T. + air dry to equilibrium		Volume Swell	+10% max.
		Volume Shrink	-8% max.

Notes:

(1) on 76±5 Durenometer B

(2) (2) All properties measured at ^{RT±5} 70° ±5°F on ASTM sub sample

MAJOR REVISION DATE 1-11-84

FOR MAJOR REVISION STAMP

INFORMATION SEE COVER SHEET

REVISION M TO N

CONFIDENTIAL

Fisher Controls	Material Specification	No. EMS 17610
FISHER	NEOPRENE RUBBER MATERIAL	By J.H.H. 11-19-84
	80-95 DUROMETER A HARDNESS	Appd. WFC 11-26-84
	85-95	Page 3 of
		Rev
Fisher Controls		

TABLE 1
QUALITY CONTROL & QUALIFICATION TESTS

Property	Test Method	Units of Measurement	Criteria (2)
Hardness	FGS 11A1	Shore Durometer A	90+3 (1) 90±5
Resilience	FGS 11A2	Bashore	±5 30±10
Surface and General Quality	FGS 11A9	--	See Section 4
Fluid Resistance	FGS 11A5		
(a) Hexane 96 hrs. at R.T. + air dry to equilibrium		Volume Swell Volume Shrink	+20% max. -6% max.
(b) Liquid Propane 120 hrs. at R.T. + air dry to equilibrium		Volume Swell Volume Shrink	+10% max. -8% max.

Notes:
70±5
(1) or 79+3 Durometer B
(2) All properties measured at 70° ±5°F

NOV 27 1984

MAJOR REVISION

ALTER QUALIFICATION REQUIREMENTS TO REFLECT STD. TESTS AND RESULTS OF APPROVED MAT'LS	ECR/N NO. <u>11/2</u>	DATE <u>11/2</u>
	BY <u>WFC</u>	APPROVED <u>WFC</u>
	1. <u>WFC</u>	2. <u>WFC</u>
	3. <u>WFC</u>	4. <u>WFC</u>
	5. <u>WFC</u>	6. <u>WFC</u>
	7. <u>WFC</u>	8. <u>WFC</u>
	9. <u>WFC</u>	10. <u>WFC</u>

Fisher Controls

Document Cover Sheet

FMS 1703

NITRILE-HYALON OR NITRILE
RUBBER MATERIAL, 82-90
DURETHER HARDNESS

Rev: **DR**
By: BW 2-9-60
Apvd: NFR 11-13-64
Page 0.1

FISHER**CONFIDENTIAL**Fisher Controls 1982, **1991** 1992Revised By: **WFR/B-23-91**

4-30-92

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PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL
0.1	DR						
1	DM						
2	DP						
3	D						
4	CD						

NO CHANGE IN PART OR VENDOR OF PART ALLOWED
WITHOUT PRIOR APPROVAL OF: UL

JUN 16 1992

MAJOR REVISIONECR/W NO. _____ DATE **4-30-92**BY **WFR** CHKD **TGS** APVD **DRB**

NO. OLD STOCK _____
1. ☒ USE
2. ☐ REWORK
3. ☐ SCRAP/NEW
4. ☐ SCRAP/OLD

REASON
1. SAFETY
2. MARK
3. IMPROVE
4. EXISTOR

5. SURF
6. CORR
7. MTRX
8. KATE

Added tensile strength testing to current
specification.

Added reinforced specifications section.

Fisher Controls

Material Specification

FMS 17G3

NITRILE-HYPALON OR NITRILE
RUBBER MATERIAL, 02-90
DURCHETER HARDNESS

Rev: NDP
By: MM 2-9-60
Apud: NPR 12-13-84
Page 2

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Revised By: MM 4-30-91

6. QUALIFICATION TESTING

Fisher Controls shall perform the qualification tests listed in Tables 1 & 2 prior to approval under this specification. Following approval, the vendor of such material shall make no changes in the product without notifying Fisher Controls of said changes and the possible need for re-qualification.

7. QUALITY CONTROL TESTING

The tests listed in Table 1 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of a production material approved under this specification. On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.

8. PARTS IDENTIFICATION

Unless exception is noted on the part drawing, the designation "03" shall be printed on a non-critical surface of the part. When parts are too small to allow this, a color dot shall be applied. The identification color for this specification shall be yellow.

Note: If the material specified is the standard for a particular part, then the color code requirements may be waived by Fisher Engineering.

9. APPROVED MATERIALS

The following materials are considered as approved for production use under this specification.

- (a) Falcor Laboratories, Inc. AC52-MH-H (Nitrile-Hypalon)

MAJOR REVISION DATE 2-30-92
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INFORMATION SEE COVER SHEET
REVISION BQ TO B

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Fisher Controls

Material Specification

FMS 17G3

NITRILE-HYPALON OR NITRILE
RUBBER MATERIAL, 02-90
DUNLOP HARDSNESS

Rev: M N
By: HW 2-9-60
Apvd: NFR 11-13-84
Page 2

FISHER

Fisher Controls

Revised By: WHH 4-30-91

6. QUALIFICATION TESTING

Fisher Controls shall perform the qualification tests listed in Tables 1 & 2 prior to approval under this specification. Following approval, the vendor of such material shall make no changes in the product without notifying Fisher Controls of said changes and the possible need for re-qualification.

7. QUALITY CONTROL TESTING

The tests listed in Table 1 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of a production material approved under this specification. On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.

8. PARTS IDENTIFICATION

Unless exception is noted on the part drawing, the designation "G3" shall be printed on a non-critical surface of the part. When parts are too small to allow this, a color dot shall be applied. The identification color for this specification shall be yellow.

Note: If the material specified is the standard for a particular part, then the color code requirements may be waived by Fisher Engineering.

9. APPROVED MATERIALS

The following materials are considered as approved for production use under this specification.

(a) Belsor Laboratories, Inc. AL62-M3-II (Nitrile-Hypalon)

(b) Acadia Synthetic Products PB-165-88-J2 (Nitrile)

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MAJOR REVISION DATE >
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Fisher Controls

Material Specification

No. FMS 1763

1763

FISHER

NITRILE-HYPALON OR NITRILE
RUBBER MATERIAL, 82-90
DUROMETER HARDNESS

By HW 2-9-60

App'd NFR 1-12-64

Page 2 of

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Rev

NFR

6. QUALIFICATION TESTING

Fisher Controls shall perform the qualification tests listed in Tables 1 & 2 prior to approval under this specification. Following approval, the vendor of such material shall make no changes in the product without notifying Fisher Controls of said changes and the possible need for re-qualification.

7. QUALITY CONTROL TESTING

The tests listed in Table 1 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of a production material approved under this specification. On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.

8. PARTS IDENTIFICATION

The letters "03" shall be printed on one face of each disc or gasket when the size of the part will allow, except Peimor Laboratories will use a printed mottled pattern. Printing color for each supplier shall be as listed below. Other identification where required shall be as noted on the part drawing.

9. APPROVED MATERIALS

The following materials are considered as approved for production use under this specification.

(a) Peimor Laboratories, Inc. N-62-NH-H (Nitrile-Hypalon) - Identification color, green

(b) Minnesota Rubber Co., 4185 (Nitrile-Hypalon) - Identification color, silver, (may also have sprue dot on back side).

(c) Acacia Synthetic Products PB-165-08-03 (Nitrile) - Identification color, blue

FMS-25/R

Unless exception is noted on the part drawing, the designation "0-3" shall be printed on a non-critical surface of the part. When parts are too small to allow this, a color dot shall be applied. The identification color for this specification shall be yellow.

Notes: If the material specified is the standard for a particular part, then the color code requirements may be waived by Fisher Engineering.

MAJOR REVISION DATE >
FOR MAJOR REVISION STAMP
INFORMATION SEE COVER SHEET SEP 18 1990
REVISION M TO

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FMS 1763		(1)
BY- HW	2-2-60	
ADVE NBR	11-12-60	
Page	0.1 of	
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NITRILE-HYPALON OR NITRILE RUBBER MATERIAL,
82-90 DUROMETER A HARDNESS

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NO ORANGE IN PART OR VENDOR OF PART ALLOWED
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Fisher Controls

Material Specification

FISHER

NITRILE-HYPALON OR NITRILE
RUBBER MATERIAL, D2-90
DURCHETER HARDNESS

No.	FMS 1763	
By	HW	2-9-60
App'd	RFR	11-13-84
Page	1	of
Rev.	CNRP	11-12-84

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WHH 11-26-90

1. SCOPE

This specification applies to rubber materials to be used as valve seat discs or gaskets which will be in contact with air, hydrocarbon gases and liquids, and anhydrous ammonia vapor and liquid, and all impurities normally contained in these fluids. The molded or cut seat discs are generally of circular shape and are attached to or contained in a metal holder. The part serves to form a tight shutoff seal, usually seating against a rather sharp-edged metal orifice which may tend to indent and/or cut the rubber. Gaskets are generally cut from sheet stock and while usually annular in shape, can be any shape or size. These rubber parts in assembly may be subjected to pressures as high as 300 psig. The normal service life of the assembly may be as much as 15 years or more without inspection or repair.

2. MATERIALS REFERENCE NOS. - 0302

3. BASIC MATERIAL AND PARTS

Synthetic rubber molded or cut in the form of discs or gaskets of various thicknesses and sizes. Parts may be required to have manufacturer's identification markings as designated either on detail drawings or in Section B of this specification.

4. SURFACE AND GENERAL QUALITY

The finished surfaces of the molded parts shall be smooth and free of imperfections such as cracks, holes, or embedments of foreign particles. The material shall contain no flaws, voids, or inclusions and any cross-section shall be dense, and free from porosity and other imperfections when a cut edge is viewed under 18x to 20x magnification. Molded undercuts such as "snap-on discs" must not have any cracks or tears resulting from stripping the disc from the mold. When ground with a suitable grinding wheel, the resulting ground surface shall be a smooth, non-porous surface.

5. SERVICE TEMPERATURE

The material shall not deteriorate and shall function properly in the designated service at temperatures of -40°F to $+180^{\circ}\text{F}$.

-50°F

FMSZ-25/1

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FOR MAJOR REVISION STAMP
INFORMATION SEE COVER SHEET
REVISION 1 TO A

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TAYLOR V. 3.M. COMPANY FT AI

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FISHER GOVERNOR CO. MARSHALLTOWN, IOWA USA	MATERIAL SPECIFICATION	NO. FMS 1703	5
		ISSUED (REV) 2-9-60	
		REV NRP 1-11-84	
		PAGE 2 OF 2	

- B. Shrinkage - The maximum volumetric shrinkage after removal from the soaking fluids and air dried at 75°F until no further change shall not exceed: Hexane, -5%, liquid Propane, -6%, liquid anhydrous ammonia, -6%.
12. Cold Temperature Resistance - Material must not be brittle after 5 hours at -40°F. Hardness must not exceed 95 Durometer B at -20°F. The hardness increase between 75°F and -20°F shall not be greater than 23 points Durometer B on any given sample.
13. Compression and Recovery - After loading a 1/2" thickness of the materials to 400 psi at 75°F for 24 hours and allowing it to recover without load for 24 hours, the thickness shall return to within 2.5% of the original.
14. Aging Qualities - The material must have excellent aging qualities. After oven aging for 14 days at 212°F, the material shall show no visual evidence of cracking or other deterioration and the tensile strength shall not have changed by more than 10%. The material shall not be subject to surface cracking or checking under stressed static loading for long periods of time at ambient temperatures.
15. Quality Control - The vendor shall conduct adequate tests (maintaining records of some) on each production batch of the material to determine that the resilience, hardness, strength, and other physical properties are maintained within proper limits. Fisher Governor Company quality control procedures apply to all of the preceding requirements. Samples of any production batch which do not meet the requirements shall be subject to replacement by the vendor.
16. Parts Identification - The letters "GJ" shall be printed on one face of each disc when the size of the part will allow, except Felmor Laboratories will use a printed mottled pattern. Printing color for each supplier shall be as listed below.
17. Approved Materials - The following materials are considered as approved for production use under this specification.
- A. Felmor Laboratories, Inc. AL62-NH-H (Nitrile-Hypalon) - Identification color, green.
 - B. Minnesota Rubber Co., 418S. W. (Nitrile-Hypalon) - Identification color, silver (may also have sprue dot on back side).
 - C. Goshen Rubber Company, 1499 (Nitrile) - Identification color, yellow.
 - D. Acadia Synthetic Products PB-165-85-J3 (Nitrile) - Identification color, blue.

Note - A and B are to be considered as the preferred materials under this specification. C and D are to be used as "second" source or alternate materials only, due to their hardnesses being near or at the upper limit.

REWRITE TO BOTH
UPDATE FORMAT AND
MODIFY REQUIREMENTS

NOV 27 1984
MAJOR REVISION
BY NRP GMS LHR JPD NRP
400 DIS FILED
12/1/84
2 - DISCOUNT 1 - XERO
3 - FILE

Fisher Controls

Material Specification

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FMS 17G3

NITRILE-HYPALON OR NITRILE
RUBBER MATERIAL, 32-90
DURCHETER HARDNESS

Rev: C2
By: WHH 11-12-84
Apvd: NFR 11-13-84
Page 4

FISHER

Fisher Controls

Revised By: WHH/8-23-91

4-30-92

TABLE 2
ADDITIONAL QUALIFICATION TESTS

Property	Test Method	Units of Measurement	Criteria (3)
Tensile Strength	FGS 11A2	PSI	1600 min.
Tensile Elongation	FGS 11A2	%	100 min.
Cold Resistance	FGS 11A3		
(a) Hardness incr. RT to -30°F		Shore Duro	+24 Pts. max.
(b) Hardness at -30°F		Shore Duro	95B max. or 0DD max.
(c) 180° Bend at -50°F, after 5 hrs.		pass/fail	pass
Compression Set 400 PSI, RT, 24 hrs.	FGS 11A4 (Type A)	%	2.5% max.
Oven Aging, 7 days @ 212°F	FGS 11A2 (Ears. str.)	change in	118% (1)
Anti-Sticking Quality	—	—	See note (2) below

Notes:

- (1) The material shall show no visual evidence of cracking or other deterioration. Also, the hardness change shall not exceed +10 points.
- (2) The material shall be compounded to provide maximum resistance against sticking to brass, to die cast materials, and to other metals, when the material is pressed against these metals for long periods of time at loads up to 2500 psi.
- (3) All properties except cold resistance measured at 70° ±5°F.

MAJOR REVISION DATE 4-30-92
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INFORMATION SEE COVER SHEET

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Fisher Controls	Material Specification NITRILE-HYPALON OR NITRILE RUBBER MATERIAL, 02-90 DUROMETER HARDNESS	No. FMS 1763	
		By W H H	11-12-84
		APX JFR	11-13-84
		Page 4 of	
© Fisher Controls		Rev	W H H 11-26-90

TABLE 2
ADDITIONAL QUALIFICATION TESTS

Property	Test Method	Units of Measurement	Criteria (3)
Tensile Strength	FGS 11A8	PSI	1600 min.
Tensile Elongation	FGS 11A8	%	100 min.
Cold Resistance	FGS 11A3		
(a) Hardness incr. RT to ~~20°F~~ -30°F		Shore Duro	+24 (+23) Pts. max.
(b) Hardness at ~~-20°F~~ -30°F		Shore Duro	95B max. +180B max.
(c) 180° Bend at ~~50°F~~ (40°F) after 5 hrs.		pass/fail	pass
Compression Set 400 PSI, RT, 24 h.	FGS 11A4 (Type A)	%	2.5% max.
Oven Aging, 14 days, @ 212°F	FGS 11A3	change in tens. str.	+18% (1)
Anti-Sticking Quality	---	---	See note (2) below

Notes:

- (1) The material shall show no visual evidence of cracking or other deterioration.
- (2) The material shall be compounded to provide maximum resistance against sticking to brass, to die cast materials, and to other metals, when the material is pressed against these metals for long periods of time at loads up to 2500 psi.
- (3) All properties except cold resistance measured at 70° ±5°F.

FMS2-25/4

DEC 10 1990

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INFORMATION SEE COVER SHEET
REVISION M TO N

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Fisher Controls

Document Cover Sheet

FMS 17G1

NEOPRENE RUBBER GASKET OR DISC MATERIAL
(78 TO 88 DOROMETER "A" HARDNESS)

Rev: 1 (S)
By: DM 12-6-46
Apvd: NFA 9-30-85
Page 0.1

FISHER

*Fisher Controls 1985, 1996

Revised By: TDG 1-18-96

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APR 27 1998

MAJOR REVISION

ECRN No. 921398 Date 4/18/97
By DM Chkd EMD Apvd TDG

1. USE	2. REWORK	3. SCRAP NEW	4. SCRAP NOW
1. SAFETY	2. MATL	3. IMPROVE	4. ERROR
5. STODN	6. COST	7. MKTG	8. SALES

Updated to the new electronic format.
Any changes to appearance, paragraph numbering, etc., were to accommodate the new document format style. The appearance of the document will not be the same as before. NO CHANGES TO CONTENT.

Fisher Controls

Document Cover Sheet

NOV 10 1983 FMS 17Q1

NEOPRENE RUBBER GASKET OR DISC MATERIAL
(75 TO 80 DURENOMETER "A" HARDNESS)REV: *NP*
BY: *HW 12-6-86*
APVD: *NFR 9-30-85*
Page 0.1**FISHER****CONFIDENTIAL**

Fisher Controls 1985, 1992's

Revised By: *HW 12-6-86*
HER 8-23-91

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PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL

0.1 *NP*1 *L*2 *KL*3 *NO*4 *ED***MAJOR REVISION**

FOR/REV NO. *930226* DATE *10-13-03*
 BY: *HER* CHECKED: *IL CAPYD*
 APPROVED: *HER*
 1. *HER* 2. *HER* 3. *HER* 4. *HER*
 5. *HER* 6. *HER* 7. *HER* 8. *HER*

*Added Paragraph NO-5580 material as supplier
option. Review has stopped making this material*

*Changed cold bend test to -50°F as new
material could not pass -60°F test. No
alternate supplier could be found.*

[illegible]

APPROVED PRODUCTS

[1] Polys Laboratories Inc. 4025-4111 - (Proprietary)
Narcotization Color: Tan

[2] Anesth Synthetic Products INC. 1014 - (Proprietary)
Narcotization Color: Tan

[3] Zeeva Inc. - Volume 214, 4524 - (Proprietary)
Identification Color: Yellow
Approved for 100% Animal Goods Only

[4] Aitken Biological Products Co. Inc. 12-1242 - (Proprietary)
Identification Color: Yellow
Approved for 100% Animal Goods Only

DEPT. OF DEFENSE
 OFFICE OF THE SECRETARY
 INFORMATION RELATIONS
 DIVISION *L. E. G.*

Fisher Controls	Material Specification	Rev. 10-13-33
	NEOPRENE RUBBER GASKET OR SEAT DISC MATERIAL (78 TO 88 DIAMETER "AT HARNESS")	FMS 1781
FISHER		By HW 12-6-46
		App. HPR 9-30-55
		Page 2 of
Fisher Controls		Rev. WHH 12-12-50

6. QUALIFICATION TESTING

Fisher Controls shall perform the qualification tests listed in Tables 1 & 2 prior to approval under this specification. Following approval, the vendor of such material shall make no changes in the product without notifying Fisher Controls of said changes and the possible need for re-qualification.

7. QUALITY CONTROL TESTING

The tests listed in Table 1 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of a production material approved under this specification. On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.

8. PARTS IDENTIFICATION

The letters "G1" shall be printed on one face of each disc or gasket when the size of the part will allow. Printing color for each supplier shall be as listed below. Other identification where required shall be as noted on the part drawing.

9. APPROVED MATERIALS

The following materials are considered as approved for production use under this specification.

- (a) Peimar Laboratories Inc. AF67-F(1) - (Neoprene)
Identification Color, Tan
- (b) Acaula Synthetic Products 185E-3214 - (Neoprene)
Identification Color, Blue. *Wavy Lines*
- (c) Reeves Bros. - Vulcan Div. 448/R - (Neoprene)
Identification Color, Yellow / *Approved for Flat Sheet Goods Only*
Checkbook Pattern
- (d) Fairprene Industrial Products Co., Inc. NS-5500 - (Neoprene)
Identification Color, Yellow / *Approved for Flat Sheet Goods Only*

FMS-1572

MAJOR REVISION DATE 10-13-33
FOR MAJOR REVISION STAMP
INFORMATION SEE COVER SHEET
REVISION *R* *10* *P*

No. FMS 1761		(K)
By HW	12-6-40	
Apvd NFR	9-30-53	
Page 0.1 of		
Rev WNH	12-12-53	

NEOPRENE RUBBER GASKET OR DISC MATERIAL
(78 TO 88 DUROMETER "A" HARDNESS)

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Fisher Controls

Material Specification

FMS 1761	
By H.W.	12-6-46
App'd JFR	9-30-66
Page 1 of 1	
Rev	9-27-65



NEOPRENE RUBBER GASKET OR SEAT DISC MATERIAL
(78 TO 88 DUROMETER "A" HARDNESS)

Fisher Controls

1. SCOPE

This specification applies to rubber materials to be used as valve seat discs or gaskets which will be in contact with air, hydrocarbon gases and liquids, and anhydrous ammonia vapor and liquid, and all impurities normally contained in these fluids. The molded or cut seat discs are generally of circular shape and are attached to or contained in a metal holder. The part serves to form a tight shutoff seal, usually seating against a rather sharp-edged metal orifice which may tend to indent and/or cut the rubber. Gaskets are generally cut from sheet stock and while usually annular in shape, can be any shape or size. These rubber parts in assembly may be subjected to pressures as high as 300 psig. The normal service life of the assembly may be as much as 15 years or more without inspection or repair.

2. MATERIALS REFERENCE NOS. - 0301

3. BASIC MATERIAL AND PARTS

Synthetic rubber molded or cut in the form of discs or gaskets of various thicknesses and sizes. Parts may be required to have manufacturer's identification markings as designated either on detail drawings or in Section 8 of this specification. Tolerances on sheet stock furnished for die cutting of parts shall be as follows: 1/32" thick $\pm .002$; 1/16" thick $\pm .001$; and 3/32" or 1/8" thick $\pm .001$.

4. SURFACE AND GENERAL QUALITY

The finished surfaces of the molded parts shall be smooth and free of imperfections such as cracks, holes, or embeddings of foreign particles. The material shall contain no flaws, voids, or inclusions and any cross-section shall be dense, and free from porosity and other imperfections when a cut edge is viewed under 10x to 20x magnification. Molded undercuts such as "snap-on discs" must not have any cracks or tears resulting from stripping the disc from the mold. When ground with a suitable grinding wheel, the resulting ground surface shall be a smooth, non-porous surface.

5. SERVICE TEMPERATURE

The material shall not deteriorate and shall function properly in the designated service at temperatures of -40°F to +180°F.

FMS3-15/1

NOV 10 1967

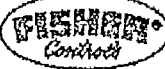
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INSTEAD OF MINOR REVISION STAMP
BY TAYLOR V. S. M. COMPANY ET AL

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ROA 03806

TAYLOR V. R. M. COMPANY ET AL

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 MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. FMS 1701
	SYNTHETIC RUBBER GASKET OR DISC MATERIAL		BY H.W. 12-16-46
			APVD
			PAGE 2 OF 2
			REV LMS 10-5-76

- D. Shrinkage - The maximum volumetric shrinkage after removal from the soaking fluids and air dried at 75°F until no further change shall not exceed: Hexane, -4%; liquid Propane, -4%.
12. Cold Temperature Resistance - Material must not be brittle after 5 hours at -40°F. Hardness must not exceed 95 Durometer B at -40°F. The hardness increase between 75°F and -40°F shall not be greater than 24 points Durometer on any given sample.
13. Compression and Recovery - After loading a 1/2" thickness of the material to 400 psi at 75°F for 24 hours and allowing it to recover without load for 24 hours, the thickness shall return to within 1.5% of the original.
14. Aging Qualities - The material must have excellent aging qualities. After oven aging for 168 hours at 212°F, the material shall show no visual evidence of cracking or other deterioration and the tensile strength shall not have changed by more than 25%. The material shall not be subject to surface cracking or checking under high stress static loading for long periods of time at ambient temperature.
15. Qualification Testing - Items 3 through 14 as given above shall be considered as qualification tests which will be performed by Fisher Controls prior to approval of any material to be used under this specification. Following qualification approval of a material by Fisher Controls, the vendor of such material shall make no changes in the product without notifying Fisher of said changes and the possible need for re-qualification testing.
16. Quality Control - Items 3, 4, 5, 6, and 11 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of production material approved under this specification.
- On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.
17. Parts Identification - The letters "G1" shall be printed on one face of each disc when the size of the part will allow. Printing color for each supplier shall be as listed below.
18. Approved Materials - The following materials are considered as approved for production use under this specification.
- A. Palmer Laboratories Inc. (AF67-B) (Neoprene) - identification color, green.
- B. Acadia Syn. Products 185E-3214 (Neoprene) - identification color, blue.
- C. Reeves Bros. - Vulcan Division 4451R (Neoprene) - identification color, white. Used for sheet goods only (gaskets, etc.). (Not approved for molded items such as seat discs, etc.)

YELLOW

MAJOR REVISION
 BY HRC CHND 12-16-46 APVD TMS
 DTD, OLD STOCK 1 - 100%
 1 - 100%
 2 - 100%
 3 - 100%
 4 - 100%

 FISHER Controls MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. FLS 1751	(F)
	SYNTHETIC RUBBER PAKET OF THIS MATERIAL		ISSUED H.W. 12-6-48	
	CONFIDENTIAL		REV. E.L.D. 11-21-73	
			PAGE 2 OF 2	

8. Shrinkage - The maximum volumetric shrinkage after removal from the soaking fluids and air dried at 75°F until no further change shall not exceed: Hexane, -4%; liquid Propane, -4%.

12. Cold Temperature Resistance - Material must not be brittle after 5 hours at -40°F. Hardness must not exceed 96 Durometer B at -40°F. The hardness increase between 75°F and -40°F shall not be greater than 24 points Durometer B on any given sample.

13. Compression and Recovery - After loading a 1/2" thickness of the materials to 400 psi at 75°F for 24 hours and allowing it to recover without load for 24 hours, the thickness shall return to within 1.5% of the original.

14. Aging Qualities - The material must have excellent aging qualities. After oven aging for 168 hours at 212°F, the material shall show no visual evidence of cracking or other deterioration and the tensile strength shall not have changed by more than 25%. The material shall not be subject to surface cracking or checking under high stress static loading for long periods of time at ambient temperature.

Qualification Testing - Items 3 through 14 as given above shall be considered as qualification tests which will be performed by Fisher Controls prior to approval of any material to be used under this specification. Following qualification approval of a material by Fisher Controls, the vendor of such material shall make no changes in the product without notifying Fisher of said changes and the possible need for re-qualification testing.

Quality Control - Items 3, 4, 5, 6, and 11 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of production material approved under this specification.

On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.

17. Parts Identification - The letters "G1" shall be printed on one face of each disc when the size of the part will allow. Printing color for each supplier shall be as listed below.

18. Approved Materials - The following materials are considered as approved for production use under this specification.

- A. Polmer Laboratories Inc. AF67-D (Neoprene) - identification color, green.
- B. Acadia Syn. Products 185E-214 (Neoprene) - identification color, blue.
- C. Reeves Bros. - Vulcan Division 4451R (Neoprene) - identification color, white. Used for sheet goods only (gaskets, etc.). (Not approved for molded items such as seal discs, etc.)

EX-100 PRINT
 REMOVE FROM
 ENGINEERING FILES

ENGINEERING DEPT. DATE 11-6-76
 MAJOR REVISION
 BY LMS CHANGED APPROVED
 DISPOSITION OF OLD STOCK
 Change to compound No. - 185E-214
 compound No longer available

CONFIDENTIAL

Flower Controls

Материалы исследования

11

371-534-1523

RECOMMEND: REPAIR OR REPLACE THE
DRAIN PIPE MATERIAL.
(1) TO THE EXISTING "N" JOINTS,

DATE	12
NY	8-27-85
REPORT	8-10-85
PAGE	4

Physical Controls

Revised by NAO 20-21-93

Additional Qualifications Training

Page 3

[illegible]

- (1) The principal shall cover the financial evidence of existing or anticipated financial condition. Also, the hardware change shall not exceed 10 percent.
- (2) The principal shall be required to provide written evidence of the financial condition of the principal and the ability to cover the cost of the hardware change. The principal shall provide evidence of the ability to pay for the hardware change. The principal shall provide evidence of the ability to pay for the hardware change. The principal shall provide evidence of the ability to pay for the hardware change.
- (3) All properties except the principal's principal shall be 10 - 5%.

ANSWER

REPORTING OFFICE (ADDRESS OR
HOT MUSIC NATIONAL
1700 17th St NW, Washington, D.C. 20036)

NAME	Σ
BYE	9-27-4
SPENCER	9-30-4

Physical Controls

Revised by: TDC 1-15-4

NOTE:
Additional Qualifications:

Energy	Yield	Heats of Measurement	Calorific Value
Quartzite (Pewabic)	200 lbs	200	1270 Btu.
Quartzite (Empire)	200 lbs		1290 Btu.
Gold sandstone	100 lbs	Quartz	
(a) sandstone, Iowa		Quartz	
200 to 400°		Quartz	2400 Btu. (calc.)
(b) sandstone, 40-40°		Quartz	
(c) 100° sand, 40-40°		Quartz	
(d) 200° sand, 40-40°		Quartz	
(e) 200° sand, 40-40°		Quartz	
(f) 200° sand, 40-40°		Quartz	
(g) 200° sand, 40-40°		Quartz	
(h) 200° sand, 40-40°		Quartz	
(i) 200° sand, 40-40°		Quartz	
(j) 200° sand, 40-40°		Quartz	
(k) 200° sand, 40-40°		Quartz	
(l) 200° sand, 40-40°		Quartz	
(m) 200° sand, 40-40°		Quartz	
(n) 200° sand, 40-40°		Quartz	
(o) 200° sand, 40-40°		Quartz	
(p) 200° sand, 40-40°		Quartz	
(q) 200° sand, 40-40°		Quartz	
(r) 200° sand, 40-40°		Quartz	
(s) 200° sand, 40-40°		Quartz	
(t) 200° sand, 40-40°		Quartz	
(u) 200° sand, 40-40°		Quartz	
(v) 200° sand, 40-40°		Quartz	
(w) 200° sand, 40-40°		Quartz	
(x) 200° sand, 40-40°		Quartz	
(y) 200° sand, 40-40°		Quartz	
(z) 200° sand, 40-40°		Quartz	

[illegible]

REASON REVISION DATE
FOR REATOR REVISION STATED
INFORMATION SEC. COM. OFF.
REVISION 0 TO 0

CONFIDENTIAL

Master Controls
 SUBSTRATE THERMAL COATING ON
 170 TO 48 DUSCHLER "A" ADDRESS)
FISHER
 Fisher Controls
 Revised by: 120 10-15-93

PAGE 1
 Quality Control & Qualification Tests

Property	Test Method	Units of Measurement	Criteria
Basic Material	—	—	See Section 3
Hardness	PO 11A1	Shore "A" Durometer	85±5 or 85±5 Shore "A"
Resiliency (1)	PO 11A2	Barbors	10 ¹¹ air
Surface and General Quality	PO 11A3	—	See Section 4
Liquid Penetration (a) 5% H ₂ O, RT	PO 11A3	Volume Swell	-10% max.
+ 96 hr. air dry		Volume Shrink	-11 max.
(b) Liquid Propene 120 hrs., RT		Volume Swell	-12% max.
+ 120 hr. air dry		Volume Shrink	-14 max.

Notes:
 (1) All properties measured at 70±5°F

Master Controls
 SUBSTRATE THERMAL COATING ON
 170 TO 48 DUSCHLER "A" ADDRESS)
FISHER
 Fisher Controls
 Revised by: 120 1-15-

PAGE 1
 Quality Control & Qualification Tests

Property	Test Method	Units of Measurement	Criteria
Basic Material	—	—	See Section 3
Hardness	PO 11A1	Shore "A" Durometer	85±5 or 85±5 Shore "A"
Resiliency (1)	PO 11A2	Barbors	10 ¹¹ air
Surface and General Quality	PO 11A3	—	See Section 4
Liquid Penetration (a) 5% H ₂ O, RT	PO 11A3	Volume Swell	-10% max.
+ 96 hr. air dry		Volume Shrink	-11 max.
(b) Liquid Propene 120 hrs., RT		Volume Swell	-12% max.
+ 120 hr. air dry		Volume Shrink	-14 max.

Notes:
 (1) All properties measured at 70±5°F

MAJOR REVISION DATE
 FOR MAJOR REVISION STAMP
 INFORMATION SEC. COVER SHEET
 REVISION 2 TO 2

Fisher Controls		Material Specification		No. FMS 1761
		NEOPRENE RUBBER GASKET OR SEAT DISC MATERIAL (78 TO 88 DUROMETER "A" HARDNESS)		By NRP 9-27-86
				App'd NRE 9-30-86
Fisher Controls				Page 4 of
				Rev

TABLE 2
ADDITIONAL QUALIFICATION TESTS **CONFIDENTIAL**

Property	Test Method	Units of Measurement	Criteria (3)
Tensile Strength	FQS 11AB	PSI	1200 min.
Tensile Elongation	FQS 11AB	%	100 min.
Cold Resistance	FQS 11A3		
(a) Hardness incr. RT to -40°F		Shore Duro	+24 Pts. max.
(b) Hardness at -40°F		Shore Duro	95B max.
(c) 180° Bend at -60°F, after 5 hrs.		pass/fail	pass
Compression Set 400 PSI, RT, 24 h.	FQS 11A4 (Type A)	%	1.5% max.
Oven Aging, 7 days, @ 212°F	FQS 11AB	change in tens. str.	28% (1)
Anti-Sticking Quality	---	---	See note (2) below

Notes:

- (1) The material shall show no visual evidence of cracking or other deterioration.
- (2) The material shall be compounded to provide maximum resistance against sticking to brass, to die cast materials, and to other metals, when the material is pressed against these metals for long periods of time at loads up to 2500 psi.
- (3) All properties except cold resistance measured at 70° ± 5°F.

The finishing treatment to produce the anti-sticking quality should not leave any permanent visible solid deposit on the material surface.

MAJOR REVISION DATE >
 FOR MAJOR REVISION STAMP
 INFORMATION SEE COVER SHEET
 REVISION 1 TO 1
 NOV 10 1987

Fisher Controls

Material Specification

FMS 17FE3

FEP (FDA) COATED METAL GASKET MATERIAL

FISHERRev: ~~3~~
By: ~~WMM~~ 4-20-89
Apvd: JFA 4-25-89
Page 1 of 1

*Fisher Controls 1989

Revised By:

1. SCOPE

This standard covers DuPont Teflon FEP coated metal sheet materials used for compliance with current FDA (U.S. Food and Drug Administration) regulations.

2. MATERIAL REFERENCE NOS.

9924 S31603/FEP

3. MATERIAL DESCRIPTION

Cold rolled annealed metal sheet, as specified in Sec. 2, coated with DuPont 959-205 brown Teflon-S primary coat followed by several applications of DuPont Teflon FEP 856-200 .001" to .002" per surface. Adhesion should be equal to or greater than the strength of the FEP coating.

4. APPROVED SOURCES

(a) K & L Precision Plastics
Richardson, TX

FEB 10 1998

*FMS1-12

MAJOR REVISION

ECRN No. 461398 Date 4/1/97

By ~~MM~~ Chkd ~~PMO~~ Apvd ~~TGG~~
BID, Old Stock 830, Reason
1. USE 1. SAFETY 6. STDZN
2. REWORK 2. MATL 6. COST
3. SCRAP/NEW 3. IMPROVE 7. MKTG/
4. SCRAP NOW 4. ERROR SALES

Updated to the new electronic form.
Any changes to appearance, paragraph numbering, etc., were to accommodate the new document format style. The appearance of the document will not be the same as before. NO CHANGE TO CONTENT.

ROA_03812

TAYLOR V. 3.M. COMPANY ET AL.

Fisher Controls

Material Specification

FMS 17F51

MATERIALS FOR FDA REQUIREMENTS

Rev: B C
By: WHH 1-24-89
Apvd: NFR 1-24-89
Page 1 of 1

FISHER

*Fisher Controls 1989

Revised By: WHH 2-8-89

1. SCOPE

This specification lists sources for Fisher components which have polymeric content known to qualify for compliance with current FDA (U.S. Food and Drug Administration) regulations.

2. MATERIAL REFERENCE NUMBERS

Listed in parenthesis under Approved Materials (See Section 3 below).

3. APPROVED MATERIALS

(a) O-Ring

Parker Seal Cpd. No. E1028-70, ethylene-propylene rubber,
70A Durometer (065Y)

(b) Back-Up Ring

Pelmor Labs. Cpd. No. AJ85-E, ethylene-propylene rubber,
75A Durometer (052X)

(c) Ball Seal

Virgin unfilled UHMWPE (Ultra High Molecular Weight Polyethylene)
Dixon Industries Cpd. Pannlon
or Fluorocarbon Fluoroloy GU or 25. (051A)

(d) Spring Loaded Seal Ring

Fluorocarbon N10276 spring with virgin unfilled UHMWPE cover,
Fluoroloy GU or compound 25. (994W)

(e) Flat Fluorocarbon Coated Gasket

K & L Precision Plastics (purchased through Cooper Mfg.) 831603
coated with DuPont 959-205 brown Teflon-S primary coat followed by
several applications for DuPont Teflon FEP 856-200. The coating
procedure shall be according to guidelines recommended by DuPont
Company. (9924) FMS 17F53

(f) Spiral Wound Gasket

Flexitallic 831600 with virgin unfilled PTFE filler, DuPont's Teflon
7A or 8A. (994X)

FMS-12/1

ECR/N NO.

BY WHH

DATE

1. K&L

2. K&L

3. K&L

4. K&L

5. K&L

6. K&L

7. K&L

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9. K&L

10. K&L

MAJOR REVISION

MAY 11 1989

TAYLOR V. 3.M. COMPANY ET AL.

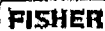
ROA_03813

Fisher Controls

Material Specification

FMS 17F49

METAL FOIL INSERT GRAPHITE
GASKET MATERIAL
FOR OXYGEN SERVICE



Rev: A B
By: W H H 10-27-87
Apvd: NFR 10-27-87
Page 1 of 1

Fisher Controls 1987

Revised By:

CONFIDENTIAL

1. SCOPE

This document describes a metal foil reinforced sheet graphite material with inorganic passivating corrosion inhibitor used for oxygen service gasketing.

2. MATERIAL REFERENCE NO. 994P3. SPECIFICATIONS

- (a) Composition: Graphite, $\geq 95\%$ with S31600 foil insert, 0.002 inches thick.

Graphite contains uniformly distributed non-metallic inorganic passivating corrosion inhibitor.

- (b) Special Handling: Handle and package per FOS Q411 for oxygen service.

- (c) Thickness: 0.031 $\pm$.003 inches
or 0.062 $\pm$.006 inches.

- (d) Density: 70 lbs/cu. ft. graphite only.

- (e) Max. temperature limits: 800°F oxidizing media
1500°F inert media

4. ACCEPTED SOURCES

- (a) Union Carbide
Carbon Products Div.
Cleveland, OH
Style No. TG-285 (CTR Grafoil with metal foil insert)

Updated to the new electronic format.
Any changes to appearance, paragraph numbering, etc., were to accommodate the new document format style. The appearance of the document will not be the same as before. NO CHANGES TO CONTENT.

FEB 10 1998

MAJOR REVISION

EORN No. 961398 Date 4-11-97By MM Chkd END Apvd TGG

DWG. CHG. STOK	1. SAFETY	5. OTHER
1. USE	2. MATL	6. COST
2. REWORK	3. APPROVE	7. MGTG
3. BORAPREV	4. ETRCH	8. SALES
4. BORAPHOW		

Fisher Controls	Material Specification	No.	FMS 17F48	(A)
FISHER	FLEXIBLE GRAPHITE SHEET WITH CORROSION INHIBITOR GASKET MATERIAL 0.030" delete	BY	W.H.H.	4-2-87
		APPROVED	HFR	4-2-87
		Page	1	of 1
Fisher Controls	1987, 1988	Rev		

CONFIDENTIAL

1. SCOPE

This document describes a flexible graphite material with inorganic passivating corrosion inhibitor to be used in gasket applications.

2. MATERIAL REFERENCE NOS. 0469

- (a) 0469
- (b) 0471 for oxygen service (See Note 1)

3. SPECIFICATIONS

- (a) Thickness Tolerances $0.010" \pm 0.002"$
 $0.030" \pm 0.002"$
- (b) Composition
 - (1) Graphite 95% minimum
 - (2) Ash 5% maximum
 - (3) Contains uniformly distributed non-metallic inorganic passivating corrosion inhibitor

4. TYPICAL PROPERTIES

- (a) Nominal Density 70 lb/cu. ft.
- (b) Sublimation Point 5500°F

5. ACCEPTED SOURCE

Union Carbide Corporation
Carbon Product Division

Trade Name - GTX Grafo11

MAJOR REVISION

ECR/N NO. DATE
BY W.H.H. CHND R. J. APVD MFR
0469, 040 STOCK 0469, 040 STOCK
1 - USE 1 - IMPROVE 8 - STORM
2 - STORM 2 - IMPROVE 8 - COST
3 - SCRAP/IMP 3 - IMPROVE 7 - COST
4 - SCRAP/IMP 4 - IMPROVE 7 - COST
Add MFR for oxygen service,
plus note on packaging.
Also tolerances for .010" & .030" thick

Note 1. Gasketing must be packed in sealed clean plastic bags or envelopes, which will prevent contamination and which are marked on the outside of the package. Marking should read "This gasketing is clean, free from oil or other contamination, and is suitable for oxygen service"

Signed _____ Inspector

CONFIDENTIAL

Fisher Controls

Material Specification

FMS 17F46

METAL FOIL INSERT GRAPHITE
GASKET MATERIAL

Rev: Q J
By: PER 11-8-85
Apvd: NFR 11-8-85
Page 1 of 1

FISHER

Fisher Controls 1985, 1998

Revised By: TCG 5-24-93

6-3-94

1. SCOPE

This document describes a metal foil reinforced sheet graphite material, typically used for gasketing.

2. MATERIAL REFERENCE NO.

994E - Standard

994Y - Certified less than 100 ppm leachable chloride per FMS 17F43.

3. SPECIFICATIONS

- (a) Composition: Graphite, $\geq 95\%$ with 531600 foil insert, 0.002 inches thick.
- (b) Thickness (for reference only): 0.031, 0.062 & 1.250 $\pm$.005 inches.
- (c) Density: 70 lbs/cu. ft. graphite only.
- (d) Max. temperature limits: 800°F oxidizing media*
1500°F inert media

*Note: For oxygen service use FMS 17F49

4. ACCEPTED SOURCES

- (a) UCAR Carbon Co., Inc.
Cleveland, OH
Style No. GHR
- (b) EGC Enterprises, Inc.
Mentor, OH
- (c) Flexitallic Gaskets Co.
8440 Remington Ave.
Pennsauken, NJ 08110

(d) Flexitallic, Inc.

8915 L. Port. Rd.

Deer Park, TX 71536

(713) 475-3431

MAJOR REVISION

JUN 16 1994

REQ/IN NO. 940912 DATE 6-3-94

BY TCG CHKD JLG APVD NFR

50, 510 RTRG	50, 510 RTRG	50, 510 RTRG	50, 510 RTRG
1 - SAFETY	2 - QA	3 - QA	4 - QA
5 - QA	6 - QA	7 - QA	8 - QA
9 - QA	10 - QA	11 - QA	12 - QA

Added new vendor location



FBI NICS

National Instant Criminal Background Check System
Federal Bureau of Investigation
Post Office Box 4278
Clarksburg, West Virginia 26302-4278



Transmittal Request for Final Disposition or Police Report

NTN 100M8SM6G

To: Agency: <u>Spartanburg Co General Ses</u> ATTN: _____ Phone: <u>864-596-2591</u> FAX: <u>864-596-2259</u>	From: Examiner: <u>Wanda W</u> Supervisor: <u>A. Crumbliss</u> Phone: <u>1-877-324-6427, ext. #3046257926</u> FAX: <u>1-888-550-6427 (Toll Free)</u> E-mail: <u>wawhite@fbi.gov</u>

Date Faxed: 05/17/18Created Date: 05/17/18No. Pages: 2 including cover page

Special Handling Instructions: The pages following this cover sheet contain Personally Identifiable Information (PII).

WHY DOES NICS EXIST?

The Brady Handgun Violence Prevention Act (Brady Act) requires that background checks be conducted through the National Instant Criminal Background Check System (NICS) to determine whether a prospective firearms transfer would violate federal or state law. The Brady Act does not prohibit the transfer of a firearm after three business days unless information is received that dictates the transfer of the firearm should not take place. Please Note: A firearm may be transferred to a prohibited person if a final response is not received within three business days of the NTN creation date (initial NICS inquiry).

WHAT CAN I DO TO HELP?

Please provide disposition information on the attached Final Disposition Report (Form NICS-1) or furnish a copy of the police report attached Police Report Request (NICS-MCDV form) and return it to the attention of the NICS Examiner and Supervisor listed above. Thank you for your help.

WHAT IF I DO NOT HAVE THE INFORMATION YOU NEED?

Should you be unable to furnish this information, please indicate below the person or agency which may be able to provide the information requested.

00000001639103

Please return this document with any additional documentation.

WARNING

Information attached to this cover sheet is U.S. Government property. If you are not the intended recipient of this information, disclosure, reproduction, or distribution, use of this information is prohibited. (18 U.S.C. § 641)
Please notify the originator or the local FBI office immediately to arrange for proper disposition.

FM-0013

ROA_03817

R-84 (Rev. 08-31-1999)

FINAL DISPOSITION REPORT

Leave Blank

Note: This vital report must be prepared on each individual whose arrest fingerprints have been forwarded to the FBI

Criminal Justice Information Services Division without final disposition noted thereon. If no final disposition is available to arresting agency, complete left side and forward the form when case referred to prosecutor and/or courts. Agency on notice as to final disposition should complete this form and submit to: FBI, CJIS Division, Clarksburg, WV 26306.

FBI UCN 697759PC7		Final Disposition & Date (If convicted or subject pleaded guilty to lesser charge, include this modification with disposition.)
Name on fingerprint Card Submitted to FBI Last First Middle young, charles,		
Date of Birth 03/04/1989 Sex M		
Henry Fingerprint Classification From FBI 1-P Response		
State Bureau No. (SID) SC01742613	Social Security No. (SOC) 248778343	This Form Submitted By: (Name, Title, Agency, ORI No., City & State) Signature Date Title
Contributor of Fingerprints (Include complete name and location of agency together with ORI number.) SC0420300 DUNCAN PD		
Arrest No. (OCA) 21086FH		
Date Arrested or Received 12/09/2009		☐ COURT ORDERED EXPUNGEMENT: Certified or Authenticated Copy of Court Order Attached.

Offenses Charged at Arrest

CARRY CONCEALED WEAPON

Please provide the charge of conviction or the court docket. The state record only shows convicted of City Ord and we need the convicting charge and state statute.

Thank you

00000001639103

Please return this document with any additional documentation.

ROA_03818

Fisher Controls

11BE251

Page 6

Rev: C

OBSOLETE PACKING MATERIAL REFERENCE
NUMBERS AND SUGGESTED ALTERNATIVES

By: WRM 9-23-07

Chk'd: DRB 9-23-07

App'd: NWR 9-24-07

FISHER

Fisher Controls

Revised by: LDCS 3-20-90

Obsolete HRN	Description	Alternative(s)
0114	Braided asbestos with graphite.	See alternatives for 011F.
0115	Braided asbestos with graphite.	See alternatives for 011F.
0116	Molded carbon filled PTFE.	Use 35% carbon filled PTFE O-ring packing (HRN019V).
0118	Braided asbestos with PTFE suspensoid - oxygen service.	See alternatives for 011F.
0121	Braided asbestos with Inconel wire.	Use (1) graphite ribbon/filament system. (HRN's: 0110 & 0190) or (2) braided composite packing with Inconel wire (HRN0188). Note 1: Graphite system will require a dif- ferent packing arrangement drawing. Note 2: If obsolete packing was used as a conductive ring, then graphite filament packing (HRN0190) should be used.
0122	Braided asbestos jacket with mica.	See alternatives for 011F.

Fisher Controls

OBSOLETE PACKING MATERIAL REFERENCE
NUMBERS AND SUGGESTED ALTERNATIVES

1188251

Page 10

Rev: B

Bp/VHM 9-21-87

CHM/JRC 8-23-87

Apoc/HFA 1-14-87

FISHER

Fisher Controls

Revised By: VHM 11-19-88

ICIEIMSI | | | | | | | |

Obsolete MNR	Description	Alternative(s)
0107	Braided asbestos with PTFE suspension.	See alternatives for 0107.
0108	Braided PTFE, no lubricant, for oxygen service.	Use PTFE molded V-ring packing certified for oxygen service. (MSM 0211 or MSM 0176). Note: A different packing arrangement drawing will be required.
0109	Braided asbestos & Inconel wire jacket over asbestos core with high temperature lube.	See alternatives for 0121.
0109	Braided asbestos jacket over asbestos core with wire finish.	See alternatives for 0109.
0180	Braided asbestos & Inconel wire jacket over asbestos core with wire finish.	See alternatives for 0121.
0180	Plastic packing containing PTFE powder, graphite and synthetic binder with braided PTFE yarn cover.	See alternatives for 0107.
0181	Braided asbestos jacket with asbestos and PTFE core.	See alternatives for 0107.

Fisher Controls

OBsolete PACKING MATERIAL REFERENCE
NUMBERS AND SUGGESTED ALTERNATIVES

1180261

Page 16

Rev: A

By: WMM 9-23-07
CND: DRG 9-23-07
Apvd: HFE 9-23-07

FISHER

*Fisher Controls

Revised By:

Obsolete Item	Description	Alternative(s)
019A	Braided asbestos & Inconel wire over asbestos core with graphite.	See alternatives for 0121.
019B	Braided PTFE packing.	See alternatives for 0110.
019C	Elastic PTFE packing.	See alternatives for 0110.
019F	Braided PTFE packing.	See alternatives for 0110.
019G	Braided packing containing asbestos, Inconel wire and Polytetrafluoroethylene.	See alternatives for 0121.
019K	Braided asbestos & Inconel wire jacket over asbestos & graphite core.	See alternatives for 0121.
019L	PTFE packing.	See alternatives for 0110.

Fisher Controls

11B5257

Page 13

Rev: A

GRAPOLITE PACKING MATERIAL REPERMUTED
NUMBER 810 SUGGESTED ALTERNATIVES

By: W/M 4 9-24-87

Chkd: DAB 9-24-87

App'd: WFC 9-24-87

FISHER

Fisher Controls

Revised By:

Change NO.	Description	Alternative(s)
0169	Braided asbestos packing with NITE suspended for oxygen service.	See alternatives for 0118.
0170	Asbestos jacket over asbestos, rubber, graphite and glycerol lubricant core.	See alternatives for 0118.
0173	Square braided asbestos rope.	Use fiber glass rope packing or graphite braided packing (FHM:0150).
0174	Braided asbestos & Inconel wire jacket over asbestos and graphite core.	See alternatives for 0121.
0179	Braided blue African asbestos with graphite.	See alternatives for 0118.
0180	Braided asbestos, Inconel wire & tungsten disulfide jacket over asbestos and graphite core.	See alternatives for 0121.

Fisher Controls

CEMENTE PACKING MATERIAL RESEARCH
NUMBERS AND SUGGESTED ALTERNATIVES

11B5251

Page 11

Rev 1 A

By: VWHM 7-25-87
Chd: DAB 7-25-87
Apd: HPK 7-25-87

FISHER

Fisher Controls

Revised Epi

Obsolete Item	Description	Alternative(s)
0153	Aluminum & asbestos strands spiraled over an asbestos core with graphite finish.	See alternatives for 0106.
0154	Aluminum & asbestos strands spiraled over an asbestos core with aluminum finish.	See alternatives for 0106.
0155	Braided asbestos with PTFE suspensoid.	See alternative for 0107.
0157	Braided asbestos jacket over asbestos, binder & graphite core with corrosion resist- ing additives.	If application is rotary valve, use also formed graphite ribbon packing with corrosion inhibitor (HSC-0113). If sliding stem, see alternatives for 0106.
0159	Separate braided asbestos with PTFE suspensoid.	See alternatives for 0107.
0160	Plastic packing consisting of graphite, asbestos and binder.	See alternatives for 0117.

Fisher Controls

11B5231

Page 9

Rev: A

CONSULTS PACKING MATERIAL SUBSTITUTIONS
NUMEROUS AND SUGGESTED ALTERNATIVES

By: W. M. H. 4-22-87
Chd: P.R.G. 4-23-87
App'd: N.R.C. 4-24-87

FISHER

Fisher Controls

Revised By:

Obsolete PN#	Description	Alternative(s)
0130	Braided blue African asbestos with graphite & high temperature lubricant.	See alternatives for 0117.
0140	Braided asbestos & monel wire jacket with asbestos & graphite core.	See alternatives for 0121.
0161	Braided asbestos with PTFE suspensoid.	See alternatives for 0107.
0142	Braided asbestos, Inconel wire jacket with asbestos graphite core.	See alternatives for 0131.
0165	Braided PTFE with PTFE suspensoid.	See alternatives for 0110.
0146	Molded RTV with 25% glass fiber-wedge seal.	Use PTFE with fiberglass filler molded V-ring packing (PN# 0130). Note: This will require a different packing arrangement drawing.

Fisher Controls

DISPOSABLE BACKING MATERIAL RESEARCH
NOMENCLATURE AND SUGGESTED ALTERNATIVES

11B5281

Page 7

Rev. A

By: W/HH 3-29-87
CDD: PLS 4-21-87
APC: HX 4-24-87

FISHER

Fisher Controls

Revised By:

Obsolete Qty	Description	Alternative(s)
0123	Braided asbestos with mica,	See alternatives for 0117.
0124	Braided asbestos & monel wire jacket with mica & asbestos core.	See alternatives for 0121.
0125	Braided asbestos with heat resistant coating.	See alternatives for 0117.
0126	Braided asbestos with monel wire and graphite.	See alternatives for 0121.
0127	Braided asbestos with mica.	See alternatives for 0117.
0128	Braided asbestos & monel wire jacket with asbestos, graphite core.	See alternatives for 0121.
0129	Braided blue African asbestos with PTFE sus- pended.	See alternatives for 0107.

Fisher Controls

11B8251

Page 4

Rev: A

OBSELETE PACKING MATERIAL REFERENCE
NUMBERS AND SUGGESTED ALTERNATIVES

By: V/HH 9-23-67
Chk'd: DAB 9-23-67
App'd: V/K 9-24-67

FISHER

*Fisher Controls

Revised By:

Obsolete ADM	Description	Alternative(s)
011P	Elastic packing with asbestos, lead and graphite.	Up to 450°P use (1) PTFE molded V-ring packing (ADM:0101, etc.) or (2) molded composition packing (ADM:0187). Note: use of V-ring packing will require a different packing arrangement drawing. Above 450°P - use alternatives for 0106.
011Q	Braided asbestos packing with tungsten disulfide coating.	See alternatives for 0106.
011H	Braided asbestos with PTFE encapsulated.	See alternatives for 0107.
011J	Braided PTFE yarn with PTFE encapsulated + oil.	See alternatives for 011C.
011K	Braided blue African asbestos with PTFE encapsulated.	See alternatives for 0107.

Fisher Controls

FISHER

OBSOLETE ASBESTOS-CONTAINING PACKING

Rev	1089000	B
CDL	2/10/86	
REV	2/10/86	
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Rev	100	8/16/86

Fisher Controls

OBSOLETE PART NUMBERS

61344001362	0135	061503K9012	0122	H1434401282	0128
01344101362	0136	661960K0012	0142	H1438201672	0167
01344201362	0136	661961K0012	0142	H1438901262	0126
01344301362	0136	662150K0012	0182	H1439401292	0129
01344401362	0136	662151K0012	0182	H1439901252	0125
01344501362	0136	662152K0012	0182	H1441201222	0122
01344601362	0136	662153K0012	0182	H1441301342	0134
01344701282	0128	662154K0012	0142	H1446801342	0134
01344801292	0129	H1000401292	0129	H1467101222	0122
01344901292	0129	H1097101282	0128	H1467201242	0124
01345001292	0129	H1097201282	0128	H1467601222	0122
01345101292	0129	H1103901572	0157	H146801342	0134
01345201292	0129	H1114601572	0157	H1490301362	0136
01345301292	0129	H1114800012	0157	H1498901142	0134
01345401292	0129	H1160201282	0128	H1502301262	0126
01345501242	0124	H1185401282	0128	H1502401312	0131
01345601222	0122	H1185501312	0131	H1506201262	0126
01345701232	0123	H1204401672	0167	H1506301262	0126
01345801292	0129	H1204601672	0167	H1515801262	0126
01345901292	0129	H1206301312	0131	H1527801262	0126
01346001282	0128	H1206401262	0126	H1528701262	0126
01346101282	0128	H1224701282	0128	H1540801262	0126
01346201362	0136	H1224801312	0131	H1561001422	0142
01346301282	0128	H1235301222	0122	H1561101422	0142
01346401232	0123	H1235401232	0123	H1561201262	0126
01346501272	0127	H1271601292	0129	H1569001422	0142
01346601272	0127	H1273101282	0128	H1569001662	0166
01346701272	0127	H1291701292	0129	H1569001252	0125
01346801362	0136	H1301601282	0128	H1569001312	0131
01346901362	0136	H1304001282	0128	H15791301102	0110
01347001232	0123	H1304101262	0126	H1579201362	0136
01347101232	0123	H1314801312	0131	H1579201662	0166
01347201282	0128	H1316001282	0128	H1584801362	0136
01347301422	0142	H1320701142	0114	H1584801882	0188
01347401422	0142	H1320801142	0114	H158501362	0136
01347501222	0122	H1351501362	0136	H1586200012	0186
01347601362	0136	H1351500012	0186	H1589101672	0167
01347701242	0124	H1370301342	0134	H1589201362	0136
01347801592	0159	H1370901682	0168	H1589301672	0167
01347901672	0167	H1375301342	0134	H1589301672	0167
0134800012	0187	H1376001342	0134	H15904301672	0167
01348101242	0124	H1421701142	0114	H15919501662	0166
01348200012	0124	H1422001142	0114	H15933601342	0138

OBSOLETE

Fisher Controls

FISHER

OBSOLETE ASBESTOS-CONTAINING PACKING

No.	1089000	B
Rev.	2/12/86	
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Fisher Controls

OBSOLETE PART NUMBERS

OBSOLETE

0000601102	0110	10749101142	0114	1E3190X0162	0121
07083201102	0110	10749101362	0136	1E3190X0172	0157
0Y0001X0012	0110	10749101672	0167	1E3190X0182	0194
10A2235X012	0173	107491X0012	0113	1E3190X0192	0105
10A2070X012	0173	107491X0022	0166	1E3190X0202	0167
10A1655X012	0173	10749501062	0106	1E3190X0212	0166
10A5874X012	0173	107496100A2	0161	1E3190X0222	0182
10A6074X0A2	0136	107518X0052	0107	1E3190X0232	0195
14A0915X062	0140	107518X0062	0140	1E3190X0252	0168
14A0918X082	0136	107518X0082	0134	1E3190X0272	0160
14A0916X032	0134	107518X0092	0166	1E3190X0282	0168
14A0915X062	0180	107518X00A2	0161	1E3190X0292	011F
14A0916X102	0168	107518X0102	0167	1E3190X0302	0110
14A1933X062	0196	107518X0112	0166	1E3190X0312	0179
18A0101X012	0190	107518X0142	0160	1E3190X0372	011H
1A5883X0022	0110	107518X0182	0160	1E3190X0402	0180
1D747401052	0106	107518X0192	0142	1E3190X0462	0141
1D747401142	0114	107518X0202	018X	1E3190X0482	0104
1D747401362	0136	10751901052	0106	1E3190X0492	0107
1D7474X0012	0114	10752001102	0110	1E3190X0422	0142
1D7474X00A2	0142	107520X0102	0161	1E3190X0602	0107
1D747501032	0106	107520X0082	0136	1E3190X0652	0140
1D747501142	0114	107520X0092	0140	1E3190X0072	0141
1D747501362	0136	107520X00A2	0167	1E3190X0092	0134
1D7475X0012	0114	107520X0102	0134	1E3190X0102	0136
1D7475X00A2	0142	107520X0122	0167	1E3190X0122	0129
1D748401052	0106	107520X0142	0186	1E3190X0162	0167
1D748501052	0106	107520X0182	0180	1E3190X0162	0167
1D748701052	0106	107520X0202	0180	1E3190X0172	0106
1D748701142	0114	107520X0012	0110	1E3190X0182	0186
1D748701342	0134	107520X0102	0110	1E3190X0192	0182
1D748701402	0140	107520X01102	0110	1E3190X0202	0161
1D7487X0012	0142	107520X01102	0110	1E3190X0212	0194
1D7487X0022	0187	10759001102	0110	1E3190X0222	0198
1D748801062	0106	1E319000A2	0109	1E3190X0232	0160
1D748801142	0114	1E3190001422	0142	1E3190X0242	0168
1D749001052	0106	1E3190X0052	0110	1E3190X0252	0116
1D749001142	0114	1E3190X0062	0134	1E3190X0262	0190
1D749001362	0136	1E3190X0072	0134	1E3190X0282	0180
1D749001672	0167	1E3190X0092	0107	1E3190X0362	0116
1D7490X0012	0113	1E3190X0102	0129	1E3190X0022	0136
1D7490X0022	0186	1E3190X0112	0140	1E3190X0032	0194
1D749101052	0106	1E3190X0132	0161	1E3190X0022	0142

89-13/1-11

Fisher Controls

Fisher Controls

FISHER

OBSOLETE ASBESTOS-CONTAINING PACKING

No.	1089000	A
By	COL	2/10/86
App'd		2/10/86
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Rev		

Fisher Controls

DESCRIPTION OF OBSOLETE MATERIALS

OBSOLETE

Material Reference Number	Vendor	Description
0107	FMS 17D10	ASBESTOS, BLUE, TFE
0108	FMS 17D4	ASBESTOS
0110	CRANE SUPERSEAL 3	ASBESTOS, GRAPHITE
0113	UNSPECIFIED	ASBESTOS, NICA
0114	CRANE 177-37	ASBESTOS, GRAPHITE
0116	GARLOCK 103	ASBESTOS, GRAPHITE
0118	CRANE 709	ASBESTOS, TFE
0117	ACE-O-PAX 1	ASBESTOS, LEAD, GRAPHITE
0119	ACE-O-PAX 1124	ASBESTOS, TUNGSTEN DISULPHIDE C70
011H	GARLOCK 8080	ASBESTOS, TFE
011K	GARLOCK 8290	ASBESTOS, BLUE AFRICAN
011N	GARLOCK 8780	ASBESTOS/TFE, OXYGEN SERVICE
011P	JM A-2024	ASBESTOS/TFE, OXYGEN SERVICE
0121	UNSPECIFIED	ASBESTOS, INCONEL
0122	ACE-O-PAX 5	ASBESTOS, NICA
0123	ACE-O-PAX 90	ASBESTOS, NICA, LUBE
0124	ACE-O-PAX 6N0	ASBESTOS, INCONEL, NICA
0125	ACE-O-PAX 16	ASBESTOS
0126	CRANE 187	ASBESTOS, MONEL, GRAPHITE
0127	ACE-O-PAX 7	ASBESTOS, NICA
0128	ACE-O-PAX 4301	ASBESTOS, INCONEL, GRAPHITE
0129	CHERPHO 600	ASBESTOS, BLUE, TFE
0131	ACE-O-PAX 220A	ASBESTOS, ALUMINUM
0133	ACE-O-PAX 28	ASBESTOS, BLUE, GRAPHITE
0134	GARLOCK 256	ASBESTOS, GRAPHITE
0135	ACE-O-PAX 610	ASBESTOS, INCONEL, NICA
0136	CRANE 187-1	ASBESTOS, INCONEL, GRAPHITE
0137	ACE-O-PAX 3	ASBESTOS, LEAD, NICA
0138	ACE-O-PAX 30	ASBESTOS, BLUE, GRAPHITE
0140	CRANE 6-AM	ASBESTOS, MONEL, GRAPHITE
0141	CRANE C-98	ASBESTOS, TFE
0142	CRANE 177-A1	ASBESTOS, INCONEL, GRAPHITE
0145	GARLOCK 4300	DOB-SSE OISF-ASBESTOS, WHITE
0147	ACE-O-PAX 13	ASBESTOS, GRAPHITE
0148	ACE-O-PAX 14	ASBESTOS, GRAPHITE, LUBE
0149	CHERPHO 6008	ASBESTOS, WHITE, TFE
0150	JM OHERPAC 2011	ASBESTOS, WHITE
0151	JM 205	ASBESTOS, GRAPHITE
0152	JM 14	ASBESTOS, GRAPHITE, COPPER

89-12/2

The Fisher Controls Corp.

ROA_03831

Fisher Controls

Material Specification

FMS 30A4

THERMOPLASTIC POLYESTER

FISHER

CONFIDENTIAL

Rev: BC
By: DJW 2-5-81
Apvd: BR 2-6-81
Page 1 of 1

Fisher Controls 1981 1982 1992

Revised By: NHH 6-1-89

4-30-91

1. SCOPE

This is a basic description of thermoplastic polyester used for molded plastic parts.

2. MATERIAL REFERENCE NUMBER: 051Y

Valox 311-1001 dry colored in Fisher green is a polyester which consists of Valox 325 base resin with an ultraviolet-inhibitor.

3. MATERIAL DESCRIPTION

Valox 311-8051 is a polyester which consists of Valox 325 base resin with an ultraviolet-inhibitor in standard gray.

4. SOURCE

(a) General Electric Co. G.E. Plastics
Pittsfield, MA

DATE: JUN 3 1992

APPROVED BY: DOE 4-30-92
DATE: 4-30-92
BY: NHR
1. DOE 2. YH 3. SK
4. DOE 5. DOE 6. DOE
7. DOE 8. DOE 9. DOE
10. DOE 11. DOE 12. DOE

Deleted Fisher green colored Valox. It is no longer used.

CONFIDENTIAL

Fisher Controls

Material Specification

FMS 17N5

CORROSION INHIBITED FLEXIBLE
GRAPHITE FILLED SPIRAL WOUND GASKETS

Rev: **DE**
By: **BJP** 8-14-87
Appd: **NFR** 8-14-87
Page 1 of 1

FISHER

Fisher Controls 1990, 1994

Revised By: TDG 6-3-94

1. SCOPE

This specification lists the approved source for spiral wound gaskets constructed from metal windings with sheet gasket filler material, their general usage and product name. The sheet gasket filler cannot contain any form of asbestos.

2. MATERIAL COMPOSITION

The spiral wound gasket material as covered by this specification shall be metal windings with flexible graphite used as a filler. The flexible graphite filler shall contain a uniformly distributed non-metallic inorganic passivating corrosion inhibitor. The flexible graphite originates as Union Carbide's GTK Grafoil.

3. SURFACE RESISTANCE OF MATERIAL

The spiral wound gaskets shall be resistant to sticking to metals such as brass, aluminum and steel. They shall be required to provide an effective seal against surface finishes of 63-500 AARB/RMS.

4. GENERAL USAGE OF SPIRAL WOUND GASKETS

The spiral wound gaskets shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical and general process type industries.

5. QUALITY

The manufacturer of the spiral wound gaskets shall be required to guarantee (1) material composition, (2) dimensional compliance to appropriate Fisher drawings, (3) compliance to load/compression characteristics per Fisher drawings, and (4) compliance to this specification.

6. APPROVED SOURCE(S)

The following material has been approved for all spiral wound gaskets:

Metal windings with flexible graphite filler containing a uniformly distributed non-metallic inorganic passivating corrosion inhibitor

(a) Flexitallic Gasket Company, Inc.
8440 Remington Ave.
Parsippany, New Jersey 08110
(609) 931-2500

(b) Flexitallic, Inc.
6915 LaPorte Rd.
Deer Park, TX 77536
(713) 479-3491

MAJOR REVISION

ECRN No. **961358** Date **4-27-97**

By **HLH** Chkd **PLD** Appd **TDG**

1. **USE** 1. **SAFETY** 5. **STUDY**
2. **REWORK** 2. **ANAL.** 6. **COST**
3. **SCRAP/NEW** 3. **APPROVE** 7. **MKTG**
4. **SCRAP/NOV** 4. **OTHER**

Updated to new electronic format.
Any changes to appearance, paragraph numbering, etc., were made in the new document. The appearance of the document will be

ROA_03833

Fisher Controls

Material Specification

JAN 13 1993

FMS 17N5

CORROSION INHIBITED FLEXIBLE
GRAPHITE FILLED SPIRAL WOUND GASKETSRev: B/C
By: RJP 8-14-87
Appvd: MFR 8-14-87
Page 1 of 1**FISHER****CONFIDENTIAL**

Fisher Controls 1987, 1993

Revised By: WHH-11-26-90

TSC 12-4-92

1. SCOPE

This specification lists the approved source for spiral wound gaskets constructed from metal windings with sheet gasket filler material, their general usage and product name. The sheet gasket filler cannot contain any form of asbestos.

2. MATERIAL COMPOSITION

The spiral wound gasket material as covered by this specification shall be metal windings with flexible graphite used as a filler. The flexible graphite filler shall contain barium-molybdate as a corrosion inhibitor. *metallic largest positively corrosion inhibitor. The flexible graphite originates as from General Electric GSK Gasket.*

3. SURFACE RESISTANCE OF MATERIAL

The spiral wound gaskets shall be resistant to sticking to metals such as brass, aluminum and steel. They shall be required to provide an effective seal against surface finishes of 63-500 AARH/RMS.

4. GENERAL USAGE OF SPIRAL WOUND GASKETS

The spiral wound gaskets shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical and general process type industries.

5. QUALITY

The manufacturer of the spiral wound gaskets shall be required to guarantee, (1) material composition, (2) dimensional compliance to appropriate Fisher drawings, (3) compliance to load/compression characteristics per Fisher drawings, and (4) compliance to this specification.

6. APPROVED SOURCE(S)

The following material has been approved for all spiral wound gaskets:

- (a) Metal windings with flexible graphite filler containing barium-molybdate as a corrosion inhibitor. *metallic largest positively corrosion inhibitor.*

Flexitallic Gasket Company, Inc.
8440 Kensington Ave.
Pennsauken, New Jersey 08110
(609) 931-2500

NOTE: No change in material or vendor as stated in this specification is allowed without prior approval of General Electric. *SMIT SEE BACK OF THIS DRAWING*

REVISION

ECRIN NO. B4644 DATE 12-11-92
BY JAG CHED DLR APPD MFR
ENG DESIGNED BY JAG DESIGNED BY JAG
12-11-92 12-11-92 12-11-92
12-11-92 12-11-92 12-11-92

Flexitallic is causing to make its own flexible graphite. They will be buying from Union Carbide, who used a different corrosion inhibitor.

CONFIDENTIAL

Fisher Controls

Material Specification

EMS-17N4

PTFE FILLED SPIRAL WOUND GASKETS

Rev: **D**
By: RJP 2-10-87
Apvd: MFR 2-11-87
Page 1 of 1

FISHER

*Fisher Controls-1987, 1994

Revised By: 1DO 6-3-94

1. SCOPE

This specification lists the approved source(s) for spiral wound gaskets constructed from metal windings with PTFE (polytetrafluoroethylene) filler material, their general usage, and product name.

2. MATERIAL COMPOSITION

The spiral wound gasket material as covered by this specification shall be metal windings with virgin PTFE used as a filler.

3. SURFACE RESISTANCE OF MATERIAL

The spiral wound gaskets shall be resistant to sticking to metals such as brass, aluminum and steel. They shall be required to provide an effective seal against surface finishes of 63-500 AARI/RMS.

4. GENERAL USAGE OF SPIRAL WOUND GASKETS

The spiral wound gaskets shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical and general process type industries.

5. QUALITY

The manufacturer of the spiral wound gaskets shall be required to guarantee, (1) material composition, (2) dimensional compliance to appropriate Fisher drawings, and (3) compliance to load/compression characteristics per Fisher drawings.

6. APPROVED SOURCES

The following material has been approved for all spiral wound gaskets.

(a) Metal windings with PTFE filler
Flexitallic Gasket Company, Inc.
8440 Remington Ave.
Pennsauken, New Jersey 08110
(609) 932-2500

(b) Metal windings with PTFE filler
Flexitallic, Inc.
6915 LaPorte Rd.
Deer Park, TX 77936
(713) 479-3491

(c) Metal windings with PTFE filler
Furon Co.
Metallia Gasket Division
P. O. Box 15639
Houston, Texas 77220
(713) 458-5830

APR 27 1998

MAJOR REVISION

ECRN No. 961398 Date: 4-24-98

By: H.H. Chkd: P.M.D. Apvd: T.D.S.

844 Old Stock
1. USE
2. NEWWORK
3. SCRAP NEW
4. SCRAP NOW
100. Filler
1. SAFETY
2. MAIL
3. APPROVE
4. ERROR
8. STUDY
9. COST
7. MKTG
SALES

Updated to the new electronic format.
Any changes to appearance, paragraph numbering, etc., were to accommodate the new document format style. The appearance of the document will not be the same as before. NO CHANGES TO CONTENT.

ROA_03835

Fisher Controls

Material Specification

CONFIDENTIAL

FMS 17N4

PTFE FILLED SPIRAL WOUND GASKETS

Rev: **DB**

By: RJP 2-16-87

Apvd: NFR 2-11-87

Page 1 of 1

FISHER

Fisher Controls 1987, 1990

Revised By: WWH 11-28-90

1. SCOPE

This specification lists the approved source(s) for spiral wound gaskets constructed from metal windings with PTFE (polytetrafluoroethylene) filler material, their general usage, and product name.

2. MATERIAL COMPOSITION

The spiral wound gasket material as covered by this specification shall be metal windings with virgin PTFE used as a filler.

3. SURFACE RESISTANCE OF MATERIAL

The spiral wound gaskets shall be resistant to sticking to metals such as brass, aluminum and steel. They shall be required to provide an effective seal against surface finishes of 63-800 AAR/RMS.

4. GENERAL USAGE OF SPIRAL WOUND GASKETS

The spiral wound gaskets shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical and general process type industries.

5. QUALITY

The manufacturer of the spiral wound gaskets shall be required to guarantee, (1) material composition, (2) dimensional compliance to appropriate Fisher drawings, and (3) compliance to load/compression characteristics per Fisher drawings.

6. APPROVED SOURCES

The following material has been approved for all spiral wound gaskets.

(a) Metal windings with PTFE filler

Flexitallic Gasket Company, Inc.
P. O. Box 880 2440 Remington Ave
Baltimore, MD 21203 Pennsauken, N.J. 08110
(800) 931-2500

(b) Metal windings with PTFE filler

Fluorocarbon Furn Co.
Metallic Gasket Division
P. O. Box 15639
Houston, TX 77220
(713) 458-5830

FMS4-6

MAJOR REVISION

ECN/NO.	DATE
BY: WWH	APVD: NFR
1. 015112	1. 015112
2. 015112	2. 015112
3. 015112	3. 015112
4. 015112	4. 015112

Update address of

CONFIDENTIAL

Fisher Controls

Material Specification

FMS 17N3

SPIRAL WOUND FLEXIBLE
GRAPHITE FILLED GASKETS

Rev: 00
By: RJF 7-24-86
Apvd: NFR 7-24-86
Page 1 of 1

FISHER

*Fisher Controls 1986, 1990

Revised By: WHH 11-20-90

TAG 6-3-91

1. SCOPE

This specification lists the approved source(s) for spiral wound gaskets constructed from metal windings with sheet gasket filler material, their general usage, and product name. The sheet gasket filler cannot contain any form of asbestos.

2. MATERIAL COMPOSITION

The spiral wound gasket material as covered by this specification shall be metal windings with flexible graphite used as a filler.

3. SURFACE RESISTANCE OF MATERIAL

The spiral wound gaskets shall be resistant to sticking to metals such as brass, aluminum and steel. They shall be required to provide an effective seal against surface finishes of 63-500 AARE/RMS.

4. GENERAL USAGE OF SPIRAL WOUND GASKETS

The spiral wound gaskets shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical and general process type industries.

5. QUALITY

The manufacturer of the spiral wound gaskets shall be required to guarantee (1) material composition, (2) dimensional compliance to appropriate Fisher drawings, and (3) compliance to load/compression characteristics per Fisher drawings.

6. APPROVED SOURCE(S)

The following material has been approved:

(a) Metal windings with Flexicarb™ Filler

Flexitallic Gasket Company, Inc.
8440 Remington Ave.
Pennsauken, New Jersey 08110
(609) 931-2500

(b) Metal windings with Grafoil™ Filler

Puron Co.
Metallic Gasket Division
P. O. Box 15639
Houston, TX 77220
(713) 450-5830

(c) Flexitallic, Inc.

6015 L. Ave., Rd.

MAJOR REVISION JUN 14 1991
ECN/NO. 740912 DATE 6-3-91
BY JDS CHKD JLG APVD NFR
DAG DUD STOCK
1. SAFETY 5. KIDN
2. HAZ/HAZ 6. COSI
3. IMPROVE 7. ERTD
4. EPECO
Added new vendor location

Fisher Controls	Material Specification	No. FMS 17N3	15
FISHER	SPIRAL WOUND FLEXIBLE GRAPHITE FILLED GASKETS	By <u>EG</u>	<u>7-24-86</u>
		Appr <u>NFR</u>	<u>7-24-86</u>
		Page	1 of 1
		Rev	
©Fisher Controls	9-2-1988		

CONFIDENTIAL

1. SCOPE

This specification lists the approved source(s) for spiral wound gaskets constructed from metal windings with sheet-gasket filler material, their general usage, and product name. The sheet gasket filler cannot contain any form of asbestos.

2. MATERIAL COMPOSITION

The spiral wound gasket material as covered by this specification shall be metal windings with flexible graphite used as a filler.

3. SURFACE RESISTANCE OF MATERIAL

The spiral wound gaskets shall be resistant to sticking to metals such as brass, aluminum and steel. They shall be required to provide an effective seal against surface finishes of 63-600 AARH/RMS.

4. GENERAL USAGE OF SPIRAL WOUND GASKETS

The spiral wound gaskets shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical and general process type industries.

5. QUALITY

The manufacturer of the spiral wound gaskets shall be required to guarantee, (1) material composition, (2) dimensional compliance to appropriate Fisher drawings, and (3) compliance to load/compression characteristics per Fisher drawings.

6. APPROVED SOURCE(S)

The following material has been approved:

- (a) Metal windings with TMFlexicarbTM Filler

FlexitallTM Gasket Company, Inc.
P.O. Box 848
Bellamy, NJ 08031
(609) 931-2500

- FMS-13/1 (S) Metal windings with TMGraphallTM filler

Fluorocarbon
Metallic Gasket Division
P.O. Box 15634
Houston, TX 77220
(713) 458-5830

MAJOR REVISION SEP 26 198

REVISION NO.	DATE	BY	APP'D
1	7-24-86	EG	NFR
2	7-24-86	EG	NFR
3	7-24-86	EG	NFR
4	7-24-86	EG	NFR

Fisher Controls

Material Specification

~~CONFIDENTIAL~~

FMS 17N2

SPIRAL WOUND COMPOSITION GASKETS

Rev: ~~00~~
 By: RJP 3-27-85
 App'd: NFR 3-27-85
 Page: 1 of 1

FISHER

*Fisher Controls 1985, 1990

Revised By: WHH 11-20-90

TAG 6-2-94

1. SCOPE

This specification lists the approved source(s) for spiral wound gaskets constructed from metal windings with sheet gasket filler material, their general usage, and product name. The sheet gasket filler cannot contain any form of asbestos.

2. MATERIAL COMPOSITION

The spiral wound gasket material as covered by this specification shall be metal windings with chlorite mineral paper with 30% graphite and acrylic binder, or equivalent materials, used as a filler.

3. SURFACE RESISTANCE OF MATERIAL

The spiral wound gaskets shall be resistant to sticking to metals such as brass, aluminum and steel. They shall be required to provide an effective seal against surface finishes of 63-900 AARH/RMS.

4. GENERAL USAGE OF SPIRAL WOUND GASKETS

The spiral wound gaskets shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical and general process type industries.

5. QUALITY

The manufacturer of the spiral wound gaskets shall be required to guarantee (1) material composition, (2) dimensional compliance to appropriate Fisher drawings, and (3) compliance to load/compression characteristics per Fisher drawings.

6. APPROVED SOURCE(S)

The following material has been approved:

JUN 14 1994

- (a) Metal windings with Flexite™ Super Filler

Flexitallic Gasket Company, Inc.
 2440 Remington Ave.
 Pennsauken, New Jersey 08110
 (609) 931-2500

- (b) Metal windings with Verdicarb™ filler

Furon Co.
 Metallic Gasket Division
 P. O. Box 15638
 Houston, Texas 77220
 (713) 458-5830

- (c) Flexitallic, Inc.
 1405 S. State St.

MAJOR REVISION

ECR# NO. 940912 DATE
 BY TGS CRD JLC RVD NFR
 1. ☒ NEW STOCK 2. ☒ SAFETY 3. ☒ STRIP
 4. ☒ ECR# 5. ☒ DATE 6. ☒ COST
 7. ☒ NEW/OLD
 8. ☒ ECR#

Add new vendor location

CONFIDENTIAL

Fisher Controls

Material Specification

No. FHS 17 N2

(A) B

FISHER

SPIRAL WOUND COMPOSITION GASKETS

By R.F. 3/27/80
 Date 3/27/85
 Page 1 of 1

@Fisher Controls 1985, 1988

Rev

1. SCOPE

This specification lists the approved source(s) for spiral wound gaskets constructed from metal windings with sheet gasket filler material, their general usage, and product name. The sheet gasket filler cannot contain any form of asbestos.

2. MATERIAL COMPOSITION

The spiral wound gasket material as covered by this specification shall be metal windings with chlorite mineral paper with 30% graphite and acrylic binder, or equivalent materials, used as a filler.

3. SURFACE RESISTANCE OF MATERIAL

The spiral wound gaskets shall be resistant to sticking to metals such as brass, aluminum and steel. They shall be required to provide an effective seal against surface finishes of 63-600 AARH/RMS.

4. GENERAL USAGE OF SPIRAL WOUND GASKETS

The spiral wound gaskets shall be suitable for general purpose gasket usage in the petroleum, power generation, chemical and general process type industries.

5. QUALITY

The manufacturer of the spiral wound gaskets shall be required to guarantee, (1) material composition, (2) dimensional compliance to appropriate Fisher drawings, and (3) compliance to load/compression characteristics per Fisher drawings.

6. APPROVED SOURCE(S)

The following material has been approved:

(a) Metal Windings with Flexite™ Super Filler

Flexitallic Gasket Company, Inc.
 P.O. Box 848
 Bellmore, NJ 08031
 (609) 931-2500

(b) Metal Windings with Verdicarb™ filler

FHS2-36/1

Fluorocarbon
 Metallic Gasket Division
 P.O. Box 15639
 Houston, Texas 77220
 (713) 458-5030

MAJOR REVISION SEP 9 89

ECR/M NO. CHV 288 DATE APR 1989
 BY WHL CHV 288 APR 1989
 1 - CHECKED BY WHL 2 - EX. FILED 3 - ENTERED
 4 - SCRAPED BY WHL 5 - REWORKED 6 - REWORKED
 7 - REWORKED 8 - REWORKED

TAYLOR V. 2 M. COMPANY ET AL

ROA_03840

 FISHER Controls MARSHALLTOWN, IOWA	MATERIAL SPECIFICATION		NO. FMS 17L1
	METAL GASKETS		ISSUED 2/28/73 JWB
			REV. 2-8-82 1-5-B2
		PAGE 1	OF 1

CONFIDENTIAL

1. Scope.

← This specification is for soft, annealed sheet or strip for flange metal gaskets and for gaskets made from these materials.

2. Materials

Material Description Specification	Max Hardness	Material Ref. Number
Low Carbon Steel	85BHN	2104
AISI Type 302	165BHN	3628
AISI Type 304L	165BHN	3631
AISI Type 304	165BHN	3629
AISI Type 316L	165BHN	3632
AISI Type 316	165BHN	3630
AISI Type 347	165BHN	3633
Stainless Steel B	217BHN	4124
Stainless Steel C	217BHN	4123
Nickel ASTM B162	120BHN	4127
Alloy 20	180BHN	4126
Cu ASTM B152-110	105BHN	1504
Inconel (See FMS 19B3)	100BHN	4112
Nickel ASTM B162	120BHN	4142

BY ORDER OF
 FISCAL CONTROL
 DATE 10/10/84
 APR 10 1984
 Change with reference for Nickel ASTM B162.
 Revised from 1973.

3. Finish

← The surface must be 63RMS or better and must be free of nicks and scratches.

4. Gasket Edges

← Shearing burrs must be removed.

5. Packaging

← Gaskets must be suitably packaged and handled to prevent scratching, bending or other damage.

Fisher Controls

Document Cover Sheet

FMS 17G44

NITRILE RUBBER O-RING MATERIAL
60-70 DUROMETER A HARDNESSRev: 1 (E)
By: WEN 4-10-91
Apvd: NFR 4-10-91
Page 1**FISHER**

*Fisher Controls 1992, 1996

Revised By: TDG 1-15-96

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PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL
1	D						
2	C						
2.1	DELETED	A					
2.2	A						
3	C						
4	C						
5	C						

MAJOR REVISION

ECRN No. 961398 Date 11/24/97By DML Chkd FMD Apvd TDG

DML, ON Otoki

1. USE	1. SAFETY	8. STDZN
2. NEWORK	2. MATL	9. COST
3. SCRAP/NEW	3. APPROVE	7. MKTG
4. SCRAP NOW	4. ERROR	SALES

Updated to the new electronic format.
Any changes to appearance, paragraph
numbering, etc., were to accommodate
the new document format only. The
appearance of the document will not
be the same as before. NO CHANGES
TO CONTENT.

MAY 18 1998

ROA_03842

TAYLOR V. 3.M. COMPANY ET AL.

Fisher Controls

Document Cover Sheet

FMS 17Q44

NITRILE RUBBER O-RING MATERIAL
60-70 DUREOMETER A HARDNESS**FISHER**Rev: CD
By: WHH 4-10-91
Apvd: NFR 4-10-91
Page 1

1-15-96

*Fisher Controls 1991, 1994

Revised By: TDG (1-10-94)

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PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL
1	<u>CD</u>						
2	C						
2.1	Defected						
2.2	A						
3	C						
4	C						
5	C						

JAN 25 1996

MAJOR REVISION
ECRN No. 96050
By: TDG Chkd: DRB
BAG, Chd Stock
1. SUBE
2. REWORK
3. SCRAP/NEW
4. SCRAP NOW
590 Reason
1. SAFETY
2. MATL
3. IMPROVE
4. ERROR
5. STDZN
6. COST
7. MKTNG
8. SALES
DATE: 1-18-96
Apvd: [Signature]

Reason Confidential formulation.

Fisher Controls

Material Specification

FORM 17 EMS 17G44

NITRILE RUBBER O-RING MATERIAL
60-70 DUREOMETER A HARDNESSRev: B
By: WEN 4-10-91
Apvd: NFR 4-10-91
Page 4**FISHER**

Fisher Controls

Revised By: WEN 4-30-92

TOS 1-10-99

TABLE 1
QUALITY CONTROL & QUALIFICATION TESTS

Property	Test Method	Units of Measurement	Criteria (1)
Hardness	FGS 11A1	Shore Dureometer A	65±5
Resilience	FGS 11A2	Bashore	30±10
Surface and General Quality	FGS 11A9	—	See Section 4
Fluid Resistance	FGS 11A5		
(a) Hexane 96 hrs. at R.T. + air dry to equilibrium		Volume Swell	+16% max.
		Volume Shrink	-6% max.
(b) Liquid Propane 120 hrs. at R.T. + air dry to equilibrium		Volume Swell	+8% max.
		Volume Shrink	-8% max.

Notes:

RT =

(1) All properties measured at 70° ± 5°F

REVISION 1-10-99
 APPROVED FOR SIGNATURE
 INFORMATION SEE COVER SHEET
 REVISION 1-10-99

Fisher Controls

Material Specification JAN 17 1994 FMS 17G44

NITRILE RUBBER O-RING MATERIAL
60-70 DUROMETER A HARDNESS

Rev: A
By: EDG 1-10-94
Apvd: NFR 1-10-94
Page 2.2

FISHER

Inserted Page

*Fisher Controls

Revised By:

4. BONDING

When bonding of elastomeric parts to metal parts is specified, the following apply:

- a) The strength of the adhesive bond must be greater than the elastomer in tension so that when a test sample is destructively tested, the break occurs in the elastomer.
- b) The adhesive must be chemically compatible with the elastomer being bonded and resistant to the same classes of chemicals, e.g., hydrocarbons.
- c) The adhesive must have the same or better temperature resistance as specified in section 6 of this specification.
- d) Any changes in the adhesives or bonding process must be resubmitted to the Materials Research Department of Fisher Controls for testing and re-approval.
- e) The vendor must perform quality control testing or process control or both to assure 100% compliance of bonded parts.

5. SURFACE AND GENERAL QUALITY

The finished surfaces of the molded parts shall be smooth and free of imperfections such as holes or embedments of foreign particles. The material shall contain no flaws, voids, or inclusions and any cross-section shall be dense, and free from porosity and other imperfections when a cut edge is viewed under 10x to 20x magnification. When ground with a suitable grinding wheel the resulting ground surface shall be a smooth, non-porous surface. Molded undercuts such as "snap-on discs" must not have any cracks or tears resulting from stripping the disc from the mold.

REVISION 10/10/94
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Fisher Controls

Material Specification JAN 17 1994 FMS 17Q44

NITRILE RUBBER O-RING MATERIAL
60-70 DUROMETER A HARDNESS

Rev: ⑤
By: WHH 4-10-91
Apvd: NFR 4-10-91
Page 2

FISHER

706 1-10-94

Fisher Controls

Revised By: WHH 4-30-92

1. SCOPE

1.1 This specification applies to rubber materials to be used primarily as O-rings which will be in contact with commercial Propane and Butane vapors and liquid, natural gas, and all impurities normally contained in these fluids. Molded parts made from materials approved under this specification are used as O-rings in pressure regulators and valves which control the flow of various fluids. The part serves to form a tight shutoff seal. The assembly is normally used in a system where the parts may be subjected to a maximum of 1000 psig gas pressure. The normal service life of the assembly may be as much as 15 years or more without inspection or repair.

1.2 This standard includes references to the following documents:

- (a) FGS 11A1, Determination of Durometer Hardness of Rubber and Plastic Materials.
- (b) FGS 11A2, Determination of Resilience of Rubber Materials.
- (c) FGS 11A3, Determination of Low Temperature Characteristics of Elastomer Materials.
- (d) FGS 11A4, Determination of Compression Set Characteristics of Elastomer and Plastic Materials.
- (e) FGS 11A5, Determination of Immersion Resistance of Rubber and Plastic Materials.
- (f) FGS 11A8, Determination of Tensile Strength Elongation and Heat Aging Resistance of Rubber.
- (g) FGS 11A9, Microscope Examination of Elastomers.

2. MATERIAL REFERENCE NO. 0353

3. BASIC MATERIAL

Synthetic rubber molded parts may be required to have manufacturer's identification markings as may be designated on detail drawings or at the end of this specification. Bond strength requirements where rubber is bonded to metal, shall be as noted on the part drawing and/or the inspection specification for the particular part involved.

3.1, 3.2, 4. see related sheets

MAJOR REVISION DATE 7-11-94
FOR MAJOR REVISION STAMP
INFORMATION SEE COVER SHEET
REVISION 5 TO 6

Fisher Controls

Material Specification

FMS 17Q44

NITRILE RUBBER ~~612~~ MATERIAL
60-70 DUROMETER A HARDNESS

Rev: ~~A~~ B
By: WHH 4-10-91
Apvd: NFR 4-10-91
Page 5

FISHER

*Fisher Controls

Revised By: WHH 4-30-92

TABLE 2
ADDITIONAL QUALIFICATION TESTS

Property	Test Method	Units of Measurement	Criteria(3)
Tensile Strength	FGS 11A8	PSI	1600 min.
Tensile Elongation	FGS 11A8	%	150 min.
Cold Resistance	FGS 11A3		
(a) Hardness incr. RT to -40°F		Shore Duro	45 pts. max.
(b) Hardness at -40°F		Shore Duro	89B max.
(c) 180° Bend at -60°F, after 8 hrs.		pass/fail	pass
Compression Set 400 PSI, RT, 24 h.	FGS 11A4 (Type A)	%	2.0% max.
Oven Aging, 7 days, 212°F	FGS 11A8	change in tens. str.	±20% (1)
Anti-Sticking Quality			See Note (2)

Notes:

- (1) The material shall show no visual evidence of cracking or other deterioration.
- (2) The material shall be compounded to provide maximum resistance against sticking to brass, die cast materials and other metals, when the material is pressed against these metals for long periods of time at loads up to 500 PSI.
- (3) All properties except cold resistance measured at 70°±5°F.

Rev: 4-30-92
By: WHH
Apvd: NFR
Page 5

change in
hardness +10 pts. max.

Fisher Controls

Material Specification

FMS 17Q44

~~O-RING~~
NITRILE RUBBER MATERIAL
60-70 DUREOMETER A HARDNESS

Rev: ~~A~~ B
By: WHH 4-10-91
Apvd: NFR 4-10-91
Page 3

FISHER

Fisher Controls

Revised By: WHH 4-30-92

7. QUALITY CONTROL TESTING

The tests listed in Table 1 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of a production material approved under this specification. On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.

8. PARTS IDENTIFICATION

Unless exception is noted on part drawing, the letter "G-14" shall be printed on a non-critical surface of the part. When parts are too small to allow this, a color dot shall be applied. The identification color for this specification shall be yellow.

Note: If the material specified is the standard for a particular part, then the color code requirement may be waived by Engineering.

9. APPROVED MATERIALS

The following materials are considered as approved for production use under this specification.

- (a) Felmor Laboratories, Inc. AF81-F(5)AC.

MAJOR REVISION DATE 4-30-92
FOR MAJOR REVISION STAMP
INFORMATION SEE COVER SHEET
REVISION A TO B

Fisher Controls

Document Cover Sheet

FMS 17G44

~~D-RING~~
NITRILE RUBBER MATERIAL
60-70 DURETOMETER A HARDNESS

Rev: A B
By: WHH 4-10-91
Apvd: NFR 4-10-91
Page 1

FISHER

*Fisher Controls 1991, 1992

Revised By: WHH 4-30-92

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PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL
1	<u>A</u> B						
2	<u>A</u> B						
3	<u>A</u> B						
4	<u>A</u> B						
5	<u>A</u> B						

JUN 16 1992

QUALITY REVISION

ICR/N NO. _____ DATE 7-30-92

BY WHH CHKD TDB APVD DRB

QAD, QLD STOCK	QSD, QSDN
1 X USE	1 SAFETY
2 REWORK	2 MATL
3 SCRAP/NEW	3 IMPROVE
4 SCRAP/NEW	4 ERROR
	5 SIGHT
	6 COST
	7 MATH
	SALES

Changed heat aging criterion to hardness
rather than tensile strength.

Add referenced specifications section

CONFIDENTIAL

Fisher Controls

Material Specification

FMS 17033

HIGH TEMPERATURE ELASTOMER
GASKET SPECIFICATION
(17-87 DISCONNECT "A" GASKETS)Rev: 0
Rev: 10-6-66
Appl: ELO 9-22-76
Page 1

FISHER

Fisher Controls

Revised By: TMS 1-11-64

1. SCOPE

1.1 This specification applies to rubber materials to be used as gaskets in contact with air, commercial propane and butane vapors and liquids, natural gases, light oils and all impurities contained in these gases and liquids. Synthetic rubber parts under this specification are used as gaskets in various types of gas or liquid control instruments. The gaskets may be of several shapes and sizes and will normally be used to seal pressures not in excess of 100 psig. The gaskets are generally used in specialized applications, and the normal service life of the assembly may be as much as 15 years or more without inspection or repair.

1.2 This standard includes references to the following documents:

- (a) FMS 11A1, Determination of Permeator Thickness of Rubber and Plastic Materials.
- (b) FMS 11A2, Determination of Resilience of Rubber Materials.
- (c) FMS 11A3, Determination of Low Temperature Characteristics of Elastomer Materials.
- (d) FMS 11A4, Determination of Compression Set Characteristics of Elastomer and Plastic Materials.
- (e) FMS 11A5, Determination of Tensile Resistance of Rubber and Plastic Materials.
- (f) FMS 11A6, Determination of Tensile Strength Elongation and Aging Resistance of Rubber.
- (g) FMS 11A7, Microscope Examination of Elastomers.

2. MATERIAL REFERENCE NO. 0420

3. BASIC MATERIAL

Solid synthetic rubber sheet cut into gaskets of various thicknesses, shapes, and sizes. The sheet or parts may be required to have manufacturer's identification marking as may be designated on detail drawings or at the end of this specification.

3.1 COMPOSED FORMULATION

Ingredient	Parts per 100
Viton B-20	100.00
Neoprene B	1.00
6742 Carbon Black	1.00
8850 Carbon Black	30.00
Coated Calcium Hydroxide	4.00
Viton Oxidative 20	1.55
Viton Oxidative 30	1.00
Total	147.55

FISHER

GASKET MATERIAL
(17-87 DISCONNECT "A" GASKETS)Rev: 10-6-66
Appl: ELO 9-22-76
Page 2

Fisher Controls

Revised By: TMS 1-11-64

1. SCOPE

1.1 This specification applies to rubber materials to be used as gaskets in contact with air, with commercial propane and butane vapors and liquids, with natural gases, and with light oils and all impurities contained in these gases and liquids. Synthetic rubber parts under this specification are used as gaskets in various types of gas or liquid control instruments. The gaskets may be of several shapes and sizes and will normally be used to seal air (or gas) pressures not in excess of 100 psig. The gaskets are generally used in specialized applications, and the normal service life of the assembly may be as much as 15 years or more without inspection or repair.

1.2 This standard includes references to the following documents:

- (a) FMS 11A1, Determination of Permeator Thickness of Rubber and Plastic Materials.
- (b) FMS 11A2, Determination of Resilience of Rubber Materials.
- (c) FMS 11A3, Determination of Low Temperature Characteristics of Elastomer Materials.
- (d) FMS 11A4, Determination of Compression Set Characteristics of Elastomer and Plastic Materials.
- (e) FMS 11A5, Determination of Tensile Resistance of Rubber and Plastic Materials.
- (f) FMS 11A6, Determination of Tensile Strength Elongation and Aging Resistance of Rubber.
- (g) FMS 11A7, Microscope Examination of Elastomers.

2. MATERIAL REFERENCE NO. 0420

3. BASIC MATERIAL

Solid synthetic rubber sheet cut into gaskets of various thicknesses, shapes, and sizes. The sheet or parts may be required to have manufacturer's identification marking as may be designated on detail drawings or at the end of this specification.

MAJOR REVISION DATE
FOR MAJOR REVISION STAMP
INFORMATION SEE COVER SHEET
REVISION F TO G

CONFIDENTIAL

Fisher Controls

Material Specification

FMS 17033

HIGH TEMPERATURE FLUOROELASTOMER
GASKET MATERIAL
(77-87 DUROMETER "A" HARDNESS)

Rev: CH
By: BGR 10-6-55
App'd: RLD 9-22-58
Page 2

FISHER

Fisher Controls

Revised By: TDG 1-13-94

1. SCOPE

1.1 This specification applies to rubber materials to be used as gaskets in contact with air, commercial propane and butane vapors and liquids, natural gases, light oils and all impurities contained in these gases and liquids. Synthetic rubber parts under this specification are used as gaskets in various types of gas or liquid control instruments. The gaskets may be of several shapes and sizes and will normally be used to seal pressures not in excess of 100 psig. The gaskets are generally used in specialized applications, and the normal service life of the assembly may be as much as 15 years or more without inspection or repair.

1.2 This standard includes references to the following documents:

- (a) FGS 11A1, Determination of Durometer Hardness of Rubber and Plastic Materials.
- (b) FGS 11A2, Determination of Resilience of Rubber Materials.
- (c) FGS 11A3, Determination of Low Temperature Characteristics of Elastomer Materials.
- (d) FGS 11A4, Determination of Compression Set Characteristics of Elastomer and Plastic Materials.
- (e) FGS 11A5, Determination of Immersion Resistance of Rubber and Plastic Materials.
- (f) FGS 11A6, Determination of Tensile Strength Elongation and Heat Aging Resistance of Rubber.
- (g) FGS 11A9, Microscope Examination of Elastomers.

2. MATERIAL REFERENCE NO. 04203. BASIC MATERIAL

Solid synthetic rubber sheet cut into gaskets of various thicknesses, shapes, and sizes. The sheet or parts may be required to have manufacturer's identification marking as may be designated on detail drawings or at the end of this specification.

3.1 COMPOUND FORMULATION

Ingredient	Parts/Hundred
Viton B-70	100.00
Maglite D	3.00
N762 Carbon Black	4.00
NB90 Carbon Black	30.00
Codex Calcium Hydroxide	6.00
Viton Curative 20	2.55
Waxes (Dibutyltin 20)	4.00

MAJOR REVISION Date: 1-18-94

See Cover Sheet Revision
5 to 4
for change information

JAN 25 1994

CONFIDENTIAL

FMS 19E 24

Insert

1.2 This standard includes references to the following documents:

- (a) FGS 11A1, Determination of Durometer Hardness of Rubber and Plastic Materials
- (b) FGS 11A2, Determination of Resilience of Rubber Materials
- (c) FGS 11A3, Determination of Low Temperature Characteristics of Elastomer Materials
- (d) FGS 11A4, Determination of Compression Set Characteristics of Elastomer and Plastic Materials
- (e) FGS 11A5, Determination of Immersion Resistance of Rubber and Plastic Materials
- (f) FGS 11A6, Determination of Tensile Strength, Elongation and Heat Aging Resistance of Rubber
- (g) FGS 11A9, Microscope Examination of Elastomers

Fisher Controls

Document Cover Sheet

CONFIDENTIAL

FMS 17G33

HIGH TEMPERATURE FLUOROELASTOMER
GASKET MATERIAL
(77-87 DUREOMETER "A" HARDNESS)

Rev: E =
By: HOR 10-6-66
Apvd: LED 9-22-76
Page: 1 ELD

FISHER*Fisher Controls 1983 1990 1992

Revised By: WNH 1-6-90
4-20-92

This page is the cover sheet of all documents containing 3 or more pages of specifications. The table below shows the revision level for each page of this document. A revision of this page will be made when any page of this document is revised. When referring to this document specify the revision level of this page.

PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL	PAGE NUMBER	REVISION LEVEL
1	<u>E</u> F						
2	<u>E</u> F						
3	<u>B</u> C						
4	<u>B</u> C						
5	<u>A</u> B						
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JUN 16 1992

MAJOR REVISION

RCH/N NO. _____ DATE: 1-30-92

BY: WNH 106 APVD: DRF
 FOR: REVISION
 1. DESIGN 2. SAFETY 3. STRAIN
 4. TEST 5. ENVIRONMENT 6. OTHER

Changed oil seal to standard ASTM grade.
Add returned specifications section.

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Fisher Controls

Material Specification

FISHER

HIGH TEMPERATURE FLUOROELASTOMER
GASKET MATERIAL
(77-87 DUROMETER "A" HARDNESS)

No.	FMS 17633
By	HG-R 10-6-66
Apd	BLD 9-22-71
Page	2 of
Rev	W 171 12-12-66

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1. SCOPE

This specification applies to rubber materials to be used as gaskets in contact with air, with commercial Propane and Butane vapors and liquids, with natural gases, and with light oils and all impurities contained in these gases and liquids. Synthetic rubber parts under this specification are used as gaskets in various types of gas or liquid control instruments. The gaskets may be of several shapes and sizes and will normally be used to seal air (or gas) pressures not in excess of 100 psig. The gaskets are generally used in specialized applications, and the normal service life of the assembly may be as much as 15 years or more without inspection or repair.

2. MATERIAL REFERENCE NO. 0420

3. BASIC MATERIAL AND PARTS

Solid synthetic rubber sheet cut into gaskets of various thicknesses, shapes, and sizes. The sheet or parts may be required to have manufacturer's identification marking as may be designated on detail drawings or at the end of this specification.

4. HARDNESS

82 ± 5 Durometer A at 75° F.

5. RESILIENCE

10 ± 10 Bashore at 75° F.

6. SURFACE AND GENERAL QUALITY

The finished surfaces of the sheet or cut gaskets shall be smooth and free of imperfections such as holes or emboldments of foreign particles. The material shall contain no flaws, voids, or inclusions and any cross section shall be dense, and free from porosity and other imperfections when a cut edge is viewed under 18 x to 20 x magnification. (See special note under approved materials - Section 18.)

7. ANTI-STICKING QUALITY

The materials shall be compounded to provide maximum resistance against sticking to brass, steel, die castings, or other metals when the gaskets are compressed against these metals for long periods of time.

JAN 16 1990

MAJOR REVISION DATE
FOR MAJOR REVISION STAMP
INFORMATION SEE COVER SHEET
REVISION D TO

CONFIDENTIAL

 FISHER Controls MARSHALLTOWN, IOWA	- MATERIAL SPECIFICATION		NO. FMS 17633
	FLUOROELASTOMER		BY HGR 10-6-66
	HIGH TEMPERATURE GASKET MATERIAL (17-27 Durometer "A" Hardness)		APVD HLD 9-22-76
			PAGE 2 OF 2
			REV NRS 10-26-66

MOVE TO NEW
PAGE 3

MOVE TO NEW
PAGE 4

12. Dimensional Tolerances - The thickness tolerance of the sheet or cut gaskets shall be as follows: (NOTE - Standard thickness for all gaskets under this specification shall be 1/32" unless specified otherwise on the part drawing.)
 STANDARD 1/32" thick - 0.031" $\pm$.004"
 3/64" thick - 0.047" $\pm$.006"
 1/16" thick - 0.062" $\pm$.008"
13. Cold Temperature Resistance - Material must not be brittle after 5 hours at -40°F. The hardness increase between 75°F and -40°F shall not be greater than 30 points Durometer A on any given sample.
14. Compression and Recovery - After loading a 1/2" thickness of the material to 400 psi at 75°F for 24 hours and allowing it to recover without load for 24 hours, the thickness shall return to within 12% of the original.
15. Aging Qualities - The material must have excellent aging qualities. After oven aging for 168 hours at 450°F, the material shall show no visual evidence of cracking or other deterioration and the material hardness shall not have increased by more than 9 points Durometer "A". The material shall not be subject to surface cracking or checking under stressed static loading for long periods of time at ambient temperatures.
16. Qualification Testing - Items 3 through 15 as given above shall be considered as qualification tests which will be performed by Fisher Controls prior to approval of any material to be used under this specification. Following qualification approval of a material by Fisher Controls, the vendor of such material shall make no changes in the product without notifying Fisher of said changes and the possible need for re-qualification testing.
17. Quality Control - Items 3, 4, 5, 6, 11 and 12 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of a production material approved under this specification.

 On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.
18. Approved Materials - The following materials are considered as approved for production use under this specification:
 - (a) Radprrene
 - (b) E. I. DuPont VS-0080 (Fluoroclastomer)

(b) Palmer Laboratories
 PLV - 10096 (i)

MAJOR REVISION

ECN/NO.	DATE
BY WNN	CHD DRS APVD NFR
1. USE	2. CHG
2. SUPPLY	3. CHG
3. SUPPLY	4. CHG
4. SUPPLY	5. CHG

ALL new mat'l. + int'l. ref. no.
 Add cover sheet + one additional

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Fisher Controls

Material Specification

FMS 17G33

HIGH TEMPERATURE FLUOROELASTOMER
GASKET MATERIAL
(77-87 DUREOMETER "A" HARDNESS)

Rev: B/C
By: NER 12-12-86
Apvd: NER 11-18-86
Page 4

FISHER

*Fisher Controls

Revised By: WWH 1-2-90

4-30-92

TABLE 1
QUALITY CONTROL & QUALIFICATION TESTS

Property	Test Method	Units of Measurements	Criteria ⁽¹⁾
Hardness	FGS 11A1	Shore "A" Durometer	82±5 ⁽²⁾
Resilience	FGS 11A2	Boshore	10±10 -5
Surface and General Quality	FGS 11A9	—	See Section 4
Fluid Resistance (a) Hexane 4d, RT	FGS 11A5	Volume Swell	+3% max.
+ air dry		Volume Shrink	-3% max.
ASTM D-3 (b) ~~COMPRESSION~~ Oil 4d, RT		Volume Swell	+3% max.
+ air dry		Volume Shrink	-3% max.

Notes:

⁽¹⁾ All properties measured at 70±5°F

⁽²⁾ or 60±5 Durometer "D"

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to Page 5

MAJOR REVISION DATE 4-30-92
FOR MAJOR REVISION STAMP
INFORMATION SEE COVER SHEET
REVISION 6 TO 6



MATERIAL SPECIFICATION

CONFIDENTIAL

FMS 17031

10

HIGH TEMPERATURE GASKET MATERIAL.

BY INK	10-6-66
APVD H.D.	9-22-76
PAGE	2 OF 2
REV	1,MS 9-22-76

1-27-76

PERFECT NEW DU PONT DESIGNATION &
PUBLISHED TENSILE STRENGTH

12. Dimensional Tolerances - The thickness tolerance of the sheet or cut gaskets shall be as follows: (NOTE - Standard thickness for all gaskets under this specification shall be 1/32" unless specified otherwise on the part drawing.)
STANDARD 1/32" thick - 0.031" $\pm$.004"
3/64" thick - 0.047" $\pm$.006"
1/16" thick - 0.062" $\pm$.008"
13. Cold Temperature Resistance - Material must not be brittle after 5 hours at -40°F. The hardness increase between 75°F and -40°F shall not be greater than 30 points Durometer A on any given sample.
14. Compression and Recovery - After loading a 1/2" thickness of the material to 400 psi at 75°F for 24 hours and allowing it to recover without load for 24 hours, the thickness shall return to within 12% of the original.
15. Aging Qualities - The material must have excellent aging qualities. After oven aging for 168 hours at 450°F, the material shall show no visual evidence of cracking or other deterioration and the material hardness shall not have increased by more than 8 points Durometer "A". The material shall not be subject to surface cracking or checking under stressed static loading for long periods of time at ambient temperatures.
16. Qualification Testing - Items 3 through 15 as given above shall be considered as qualification tests which will be performed by Fisher Controls prior to approval of any material to be used under this specification. Following qualification approval of a material by Fisher Controls, the vendor of such material shall make no changes in the product without notifying Fisher of said changes and the possible need for re-qualification testing.

Quality Control - Items 3, 4, 5, 6, 11 and 12 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of a production material approved under this specification.

On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.

Approved Materials - The following materials are considered as approved for production use under this specification.

A. E. I. DuPont ~~66-100~~ (Fluorocelastomer)
VS-6080

MAJOR REVISION

BY NRO

CHKD

APVD

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10-6-66

1-27-76

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Fisher Controls	Material Specification	No. FMS 17833	Q/A
FISHER	HIGH TEMPERATURE FLUOROELASTOMER	By WHH	12-12-86
	GASKET MATERIAL	Appd NFA	12-18-86
	(77-87 DURETOMETER "A" HARDNESS)	Page 4	of
Fisher Controls		Rev	

15. AGING QUALITIES

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The material must have excellent aging qualities. After oven aging for 168 hours at 450° F. the material shall show no visual evidence of cracking or other deterioration and the material hardness shall not have increased by more than 8 points Duremeter "A". The material shall not be subject to surface cracking or checking under stressed static loading for long periods of time at ambient temperatures.

16. QUALIFICATION TESTING

Items 3 through 15 as given above shall be considered as qualification tests which will be performed by Fisher Controls prior to approval of any material to be used under this specification. Following qualification approval of a material by Fisher Controls, the vendor of such material shall make no changes in the product without notifying Fisher of said changes and the possible need for re-qualification testing.

17. QUALITY CONTROL

Items 3, 4, 5, 6, 11 and 12 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of a production material approved under this specification.

On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.

18. APPROVED MATERIALS

The following materials are considered as approved for production use under this specification.

- A. Fairprene VS-0080 (Fluoroelastomer)
- B. Palmer Laboratories
PLV-10085 (1)

JAN 16 1990

2 TABLES
ADDED

MAJOR REVISION DATE >
FOR MAJOR REVISION STAMP
INFORMATION SEE COVERSHEET
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CONFIDENTIAL

FISHER® GOVERNOR CO. MARSHALLTOWN, IOWA USA	MATERIAL SPECIFICATION	NO. FMS 17633	(A)
		ISSUED <i>Mar 10-6-60</i>	
		REV.	
		PAGE 1 OF 1	

Fluoroclastomer

Thickness .031" $\pm$.003"

Temperature Range 0 - 400°F

Hardness 90 $\pm$ 5 Durometer A

Supplier

DuPont No. 80-080

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ENGINEERING DEPT. DATE *2-27-76*
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BY *LMS CHKD* APPD *EJA*
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ADDED A PAGE

Fisher Controls

Document Cover Sheet

PMS 17G26

NEOPRENE RUBBER GASKET MATERIAL
(50 TO 60 DUNLOPETER "A" HARDNESS)

Rev: J K
By: GA 9-15-58
Apvd: NFR 10-15-65
Page 0.1

FISHER**CONFIDENTIAL**Fisher Controls 1985, 1990 10/9/Revised By: WH 11-26-908-23-91

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MAJOR REVISION

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BY: 10/11/ CHKD: 206 APVD: NFR
R/O OLD STOCK _____ NO. REASON _____
1. 2-USE 1. SAFETY 5. STUDY
2. REWORK 2. DATA 6. TEST
3. REPAIR/REW. 3. IMPROVE 7. OTHER
4. SOUP NEW 4. OTHER 8. SALES

Add hardness change
requirements to oven age
test. Also reference to note
added.

Fisher Controls

Document Cover Sheet

FMS 17G25

NEOPRENE RUBBER GASKET MATERIAL
(52 TO 60 DUREOMETER "A" HARDNESS)Rev: CH
By: DZ 9-15-50
Apvd: NFR 10-16-85
Page 0.1**FISHER**

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Fisher Controls 1985, 1989 1990Revised By: WHH 10-20-89

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ECR/R NO. _____ DATE _____
 BY WHH CHH DCB APVD NFR SEP 07 1990
 1. DESIGN 2. DETAIL 3. IMPROVE 4. CHANGE 5. STUDY 6. TEST 7. VERIFY 8. END

Change dimensional tolerances
on 3/4" thick sheet.

File	...
NRP	11-19-25

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Times

NEOPRENE RUBBER GASKET MATERIAL
(52 TO 60 DUROMETER "A" HARDNESS)

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Fisher Controls

Material Specification

FMS 37625

CONFIDENTIAL

FISHER

NEOPRENE RUBBER GASKET MATERIAL
(52 TO 60 DUROMETER "A" HARDNESS)

By DZ 9-15-68

App'd NFR 10-15-85

Page 1 of 1

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Rev'd WRP 10-10-85

With 11-26-90

1. SCOPE

This specification applies to rubber materials to be used as gaskets in contact with air, with commercial Propane and Butane vapors and liquids, with natural gases, and with light oils and all impurities contained in these gases and liquids. Rubber parts under this specification are used as gaskets in various types of gas or liquid control instruments. The gaskets may be of several shapes and sizes and will normally be used to seal air (or gas) pressure not in excess of 100 psig. The gaskets are generally used in specialized applications, and the normal service life of the assembly may be as much as 15 years or more without inspection or repair.

2. MATERIALS REFERENCE NOS. - 04083. BASIC MATERIAL AND PARTS

Solid synthetic rubber sheet cut into gaskets of various thicknesses, shapes, and sizes. The sheet or parts may be required to have manufacturer's identification marking as may be designated on detail drawings or in Section 8 of this specification.

4. SURFACE AND GENERAL QUALITY

The finished surfaces of the sheet or cut gaskets shall be smooth and free of imperfections such as cracks, holes, or embeddings of foreign particles. The material shall contain no flaws, voids, or inclusions and any cross-section shall be dense, and free from porosity and other imperfections when a cut edge is viewed under 10x to 20x magnification.

5. SERVICE TEMPERATURE

The material shall not deteriorate and shall function properly in the designated service at temperatures of -40°F to +150°F.

6. QUALIFICATION TESTING

Fisher Controls shall perform the qualification tests listed in Tables 1 & 2 prior to approval under this specification. Following approval, the vendor of such material shall make no changes in the product without notifying Fisher Controls of said changes and the possible need for re-qualification.

DEC 10 1990

MAJOR REVISION DATE
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INFORMATION SEE COVER SHEET
REVISION 11-26-90

FMS3-18/1

ROA_03864

TAYLOR & FRANCIS COMPANY ET AL

CONFIDENTIAL

Fisher Controls

Material Specification

FMS 17G25

NEOPRENE RUBBER GASKET MATERIAL
(52) TO 50 DIAMETER "A" HARDNESS
50

Rev: 01 E
By: NRP 10-10-85
Apvd: NRP 10-15-85
Page 3

FISHER

Fisher Controls

Revised By: WPH

11-26-90

TABLE 1
QUALITY CONTROL & QUALIFICATION TESTS

Property	Test Method	Units of Measurement	Criteria
Hardness	FGS 11A1	Shore "A" Durometer	55±5
Resilience	FGS 11A2	Bashore	35±10
Basic Material	—	—	See Section 3
Surface and General Quality	FGS 11A9	—	See Section 4
Fluid Resistance (a) Hexane 4d, RT	FGS 11A5	Volume Swell	+27% max.
+ air dry to equilibrium		Volume Shrink	-22% max.
(b) Liquid Propane 5d, RT		Volume Swell	+8% max.
+ air dry to equilibrium		Volume Shrink	-16% max.
(c) ASTM #3 oil 4d, RT		Volume Swell	+6% max.
+ air dry to equilibrium		Volume Shrink	-3% max.
Dimensional Tolerances (2)	—	Inches 1/64" THK-0.035±0.050" 1/16" THK-0.062±0.080" 1/8" THK-0.125±0.020"	

Notes:

- (1) All properties measured at 70° ±5° F
- (2) Unless otherwise specified standard thickness is 1/64" DEC 10 1990

RECEIVED
FISHER CONTROLS
11-26-90

CONFIDENTIAL

FISHER GOVERNOR CO. MARSHALLTOWN, IOWA USA	MATERIAL SPECIFICATION		NO. FMS 17625	①
	SYNTHETIC RUBBER GASKET MATERIAL		ISSUED IIZ 9-15-58	
			AFV LMB 8-12-76	
			PAGE 1 OF 2	

1. General - This specification applies to rubber materials to be used as gaskets in contact with air, with commercial Propane and Butane vapors and liquids, with natural gases, and with light oils and all impurities contained in these gases and liquids.
 2. Scope of Application(s) - Synthetic rubber parts under this specification are used as gaskets in various types of gas or liquid control instruments. The gaskets may be of several shapes and sizes and will normally be used to seal air (or gas) pressures not in excess of 100 psig. The gaskets are generally used in specialized applications, and the normal service life of the assembly may be as much as 15 years or more without inspection or repair.
 3. Basic Material and Parts - Solid synthetic rubber sheet cut into gaskets of various thicknesses, shapes, and sizes. The sheet or parts may be required to have manufacturer's identification marking as may be designated on detail drawings or at the end of this specification.
 4. Hardness - 52 to 60 Durometer A at 75°F.
 5. Resiliency - 40 ± 10 Bashore at 75°F.
 6. Surface and General Quality - The finished surfaces of the sheet or cut gaskets shall be smooth and free of imperfections such as holes or embedments of foreign particles. The material shall contain no flaws, voids, or inclusions and any cross section shall be dense, and free from porosity and other imperfections when a cut edge is viewed under 10 x to 20 x magnification. (See special note under approved materials - Section 18)
 7. Anti-Sticking Quality - The material shall be compounded to provide maximum resistance against sticking to brass, steel, die castings, or other metals when the gaskets are compressed against these metals for long periods of time.
 8. Service Temperature - The material shall not deteriorate and shall function properly in the designated service at temperatures of -40°F to +160°F.
 9. Tensile Strength - Minimum of 1500 psi at 75°F.
 10. Elongation - Minimum of 250% at 75°F.
- Fluid Resistance -
- A. Swelling - During immersion for 96 hours at 75°F with dimensional checks being made every 24 hrs., the linear swell in Hexane shall not exceed 12%. After immersion for 120 hrs. at 75°F in liquid Propane, the linear swell shall not exceed 4%. During immersion for 96 hrs. at 75°F with dimensional checks being made every 24 hrs., the linear swell in compressor oil shall not exceed 3%.
 - B. Shrinkage - The maximum linear shrinkage after removal from the soaking fluids and air dried at 75°F until no further change shall not exceed: Hexane, -7%, liquid Propane, -4%, compressor oil, -3%.

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 FROM NO. A248A
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 BY NRP
 CHECKED BY KMH AND NRP
 APPROVED BY [Signature]
 DATE [Date]
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FISHER GOVERNOR CO. MARSHALLTOWN, IOWA USA	MATERIAL SPECIFICATION	NO. FMS 17G25
	SYNTHETIC RUBBER GASKET MATERIAL	ISSUED DZ 9-15-58
		REVISED 5-26-71
		PAGE 2 OF 2

12. Dimensional Tolerances - The thickness tolerance of the sheet or cut gaskets shall be as follows: (NOTE - Standard thickness for all gaskets under this specification shall be 3/64" unless specified otherwise on the part drawing.)
- STANDARD 1/32" thick - 0.031" ± .004"
STANDARD 3/64" thick - 0.047" ± .006"
1/16" thick - 0.062" ± .008"
13. Cold Temperature Resistance - Material must not be brittle after 5 hours at -50°F. The hardness increase between 75°F and -40°F shall not be greater than 30 points Durometer A on any given sample.
14. Compression and Recovery - After loading a 1/2" thickness of the material to 400 psi at 75°F for 24 hours and allowing it to recover without load for 24 hours, the thickness shall return to within 3.5% of the original.
15. Aging Qualities - The material must have excellent aging qualities. After oven aging for 168 hrs. at 212°F, the material shall show no visual evidence of cracking or other deterioration and the tensile strength shall not have changed by more than 20%. The material shall not be subject to surface cracking or checking under stressed static loading for long periods of time at ambient temperatures.
16. Qualification Testing - Items 3 through 15 as given above shall be considered as qualification tests which will be performed by Fisher Controls prior to approval of any material to be used under this specification. Following qualification approval of a material by Fisher Controls, the vendor of such material shall make no changes in the product without notifying Fisher of said changes and the possible need for re-qualification testing.
17. Quality Control - Items 3, 4, 5, 6, 11, and 12 shall be considered quality control tests which may be performed by Fisher Controls on any incoming shipment of a production material approved under this specification.
- On each production batch of an approved material, the vendor shall conduct tests and maintain records of same as he deems necessary to insure that the required quality and properties are maintained. Any production batch of material or parts which fails to meet quality control procedures at Fisher Controls shall be replaced by the vendor.
18. Approved Materials - The following materials are considered as approved for production use under this specification.

A. U.S. Rubber Company M3854 (Neoprene)

B. Carlock, Inc. 8312 (Neoprene) - NOTE: Surface of this material may be satin (fine fabric) finish

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Fisher Controls

Material Specification

FMS 17G26

NEOPRENE RUBBER GASKET MATERIAL
(50 TO 60 DUNLOP "A" HARDNESS)

Rev: C.C.
By: NRP 10-10-85
Apvd: NVR 10-15-85
Page 4

FISHER

Fisher Controls

Revised By: WH 11-28-90

8-21-91

TABLE 2
ADDITIONAL QUALIFICATION TESTS

Property	Test Method	Units of Measurement	Criteria (b)
Tensile Strength	FGS 11A5	PSI	1500 min.
Tensile Elongation	FGS 11A5	%	250 min.
Cold Resistance (a) Hardness incr. RT to -40°F	FGS 11A3	Shore Duro	30 Pts. max.
(b) Hardness at -40°F		Shore Duro	32A max.
(c) 150° Bend at -60°F, after 5 hrs.		pass/fail	pass
Compression Set 400 PSI, RT, 24 hrs.	FGS 11A4 (Type A)	%	3.5% max.
Oven Aging, 7 days @ 212°F	FGS 11A5	change in tens. str.	20% (1)
Anti-Sticking Quality	---	---	See note (2) below

Notes:

- (1) The material shall show no visual evidence of cracking or other deterioration. Also, the hardness change shall not exceed ± 10 points.
- (2) The material shall be compounded to provide maximum resistance against sticking to brass, to die cast materials, and to other metals, when the material is pressed against these metals for long periods of time.
- (3) All properties except cold resistance measured at $70^{\circ} \pm 5^{\circ}\text{F}$.

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Fisher Controls	Material Specification	No. FMS 17025	12
	NEOPRENE RUBBER GASKET MATERIAL 50 TO 60 DUREMETER "A" HARDNESS	By NRP	10-10-85
		Appd. NFR	10-10-85
		Page	4 of
Fisher Controls		Rev. 1/1/84	11-24-90

TABLE 2
ADDITIONAL QUALIFICATION TESTS

Property	Test Method	Units of Measurement	Criteria (3)
Tensile Strength	FGS 11A0	PSI	1500 min.
Tensile Elongation	FGS 11A8	%	250 min.
Cold Resistance	FGS 11A3		
(a) Hardness incr. RT to -40°F		Shore Duro	30 Pts. max.
(b) Hardness at -40°F		Shore Duro	82A max.
(c) 180° Bend at -60°F, after 5 hrs.		pass/fail	pass
Compression Set 400 PSI, RT, 24 h.	FGS 11A4 (Type A)	%	3.5% max.
Oven Aging, 7 days, @ 212°F	FGS 11A8	change in tens. str.	20% (1)
Anti-Sticking Quality	---	---	See note (2) below

Notes:

- (1) The material shall show no visual evidence of cracking or other deterioration.
- (2) The material shall be compounded to provide maximum resistance against sticking to brass, to die cast materials, and to other metals, when the material is pressed against these metals for long periods of time.
- (3) All properties except cold resistance measured at 70° ±5°F.

DEC 10 1990

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DUKE POWER COMPANY

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9-03-92

FISHER CONTROLS COMPANY
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P O BOX 33424
CHARLOTTE NC 28233

S DUKE POWER CO.
H OCONEE NUCLEAR STATION C32108-K2
P C/O H.A. HEDDEN
T HIGHWAY 183
O

SENECA, SC 29678
UPS BROWN

HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 56-020550			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER* BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.		
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
1	1	EA	***** * * EDI ORDER * * * THIS ORDER HAS BEEN TRANSMITTED * * ELECTRONICALLY TO THE VENDOR. * * PLEASE SEND ORIGINAL COPY TO THE * * EDI COORDINATOR FOR VERIFICATION. * *****	115502121	126.00 EA
2	2	EA	ASSEMBLY, , RELAY, MFR SPECIFIC INFO: HORIZONTAL MFR: FISHER CONTROLS CO. PART #: AJ6206000A2	115502602	101.00 EA
3	1	EA	GASKET, , TYPE: BELLOWS FRAME MFR: FISHER CONTROLS CO. PART #: 1D396803012	115502586	

(CONT. ON PAGE 2)

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THREE COPIES OF INVOICE, WITH FREIGHT BILL
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PO BOX 1002
CHARLOTTE NC 28201-1002

ADDRESS
REPLY TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

J.L. ROSEMAN

(803) 885-3551

(803) 885-3558

RDA 03870

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ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
4	1	EA	GASKET, MFR: FISHER CONTROLS CO. PART #: 1N4991-99202	115502605	
5	1	EA	ADAPTER, , CONNECTION: MALE MFR: FISHER CONTROLS CO. PART #: 1H784201012	115502621	
6	5	EA	ADAPTER, MFR: FISHER CONTROLS CO. PART #: 1H784401012	115502555	
7	4	EA	GASKET, , TYPE: SWITCH PLATE MFR: FISHER CONTROLS CO. PART #: 1N8741	115500395	
(CONT. ON PAGE 3)					
SHIPPING TERMS			CASH TERMS		

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ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
8	2	EA	GASKET, , TYPE: RELAY APPLICATION: FOR FISHER 3570 POSITIONER FURNISHED TO DP CO SPEC CNS-1205.06-3 MFR: FISHER CONTROLS CO. PART #: 1H855903012	115502617	
9	9	EA	SPRING, MFR: FISHER CONTROLS CO. PART #: 1H8917000A2	115000001	
10	2	EA	PIN, , TYPE: TRAVEL MFR: FISHER CONTROLS CO. PART #: 1U909646332	115502785	
			GASKET, , SIZE: 1/4" THK, MATERIAL: ASBESTOS APPLICATION: FOR FISHER CONTROL PRESSURE RELIEF VALVE MFR: FISHER CONTROLS CO. (CONT. ON PAGE 4)		
SHIPPING TERMS			CASH TERMS		

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R.F. SMITH
General Manager, Purchases

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CHARLOTTE NC 28233

S DUKE POWER CO.
H OCONEE NUCLEAR STATION E14357-K2
P C/O H.A. HEDDEN
T HIGHWAY 183
O

SENECA, SC 29678

VIA DELIVER

HEREIN DESIGNATED SELLER

TAX CERTIFICATE NUMBER:

NC26 SC1002-19

EIN NUMBER: 56-020550

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ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			***** * * EDI ORDER * * * THIS ORDER HAS BEEN TRANSMITTED * * ELECTRONICALLY TO THE VENDOR. * * PLEASE SEND ORIGINAL COPY TO THE * * EDI COORDINATOR FOR VERIFICATION. * ***** PLEASE RUSH - ITEMS 1 AND 2 NEEDED FOR UPCOMING OUTAGE.		
1	1	EA	GASKET, , TYPE: BONNET APPLICATION: FOR FISHER GLOBE VALVE MODEL 475-DBQ 2.0 INCH MFR: FISHER GOVERNOR CO. PART #: 1L120899442	244401187	16.45 EA
2	5	EA	O-RING, MER: FISHER CONTROLS CO. PART #: 1H849804992 (CONT. ON PAGE 2)	254101840	.60 EA

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OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 248
SENECA SC 29678

ADDRESS
REPLY TO:

J.L. ROSEMAN

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R.F. SMITH
General Manager, Purchases

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VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 56-020550			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
			BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
3	1	EA	ASSEMBLY, , SHAFT AND DISC, TYPE: BUTTERFLY VALVE APPLICATION: BUTTERFLY VALVE 8 INCH TYPE 9110 MFR: FISHER CONTROLS CO. PART #: H11780X0032	1,493.10 EA
4	2	EA	PACKING, RING, MATERIAL: TEFLON APPLICATION: FOR 24 INCH TYPE 7640 BUTTERFLY VALVE MFR: FISHER CONTROLS CO. PART #: G1860401302	25.20 EA
5	5	EA	PACKING, , MATERIAL: TEFLON APPLICATION: FOR VEE-BALL VALVE SIZE 6 INCH 657-8-U MFR: FISHER CONTROLS CO. PART #: 1R516001012	19.53 EA
6	1	EA		54.81 EA

(CONT. ON PAGE 3)

SHIPPING
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OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 219

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PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

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FISHER CONTROLS COMPANY
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VIA

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ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
7	1	EA	SEAL, , TYPE: BALL APPLICATION: FOR 6 INCH TYPE 657-8-U CONTROL VALVE MFR: FISHER CONTROLS CO. PART #: 1R9703-36142 DWG #: CU5686 254200671	308.70 EA
8	2	ST	RING, BACK-UP APPLICATION: FOR FISHER 6 INCH BALL VALVE MFR: FISHER CONTROLS CO. PART #: 1P5698-36042 DWG #: CU5686 254600596	25.83 ST
9	3	EA	PACKING SET, APPLICATION: FOR FISHER VALVE 6 INCH TYPE EHT AND SIZE 16 INCH VALVE MFR: FISHER CONTROLS CO. PART #: 1R290801012 244400529	44.10 EA
			GASKET, FLANGED FITTING, TYPE: SPIRAL WOUND, MATERIAL: 316 SS WITH ASBESTOS, (CONT. ON PAGE 4)	

SHIPPING TERMS	CASH TERMS

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TAX CERTIFICATE NUMBER:			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
NC26 SC1002-19			BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.	
EIN NUMBER: 56-020550				
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
10	2	EA	SIZE: 1-13/16" ID X 1-15/16" OD X .175" THK APPLICATION: FOR GLOBE VALVE TYPE DBQ SIZE 1 INCH MFR: FISHER CONTROLS CO. PART #: 1N297999102 254101906 LINER, , TYPE: VALVE APPLICATION: FOR TYPE 9110 VALVE MFR: FISHER CONTROLS CO. PART #: F2622806782 DWG #: F11733 IT. 197 DELIVERY COMMITMENT: ITEMS 1 & 2 - STOCK PER S. MIRANDA ITEMS 3 & 4 - 2-3 WEEKS (04/15/93) BALANCE - 4-6 WEEKS (05/06/93) NEED DATE: ITEMS 1 & 2 - 03/31/93 BALANCE - ON OR BEFORE 05/30/93 PRICE AND DELIVERY PER PRICE LIST DATED 03/03/93. PRICED BY B. PARKER (CONT. ON PAGE 5)	166.95 EA

SHIPPING TERMS	CASH TERMS

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OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
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TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 56-020550			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
			03/22/93. ***** * * CONFIRMATION-DO NOT DUPLICATE (01) * * ***** PURCHASE ORDER NUMBER, ID NUMBER, AND PART(S) NUMBER (AS APPLICABLE) MUST BE SHOWN ON ALL PACKING LISTS, BOXES, CARTONS, REELS, PART(S) TAGS, AND INVOICES. (05) "SHIPMENTS WILL BE ACCEPTED MONDAY THRU THURSDAY, 8:00 AM TILL 11:30 AM AND 12:30 PM TILL 4:30 PM, EXCEPT HOLIDAYS (INCLUDING EASTER MONDAY, DAY AFTER THANKSGIVING AND CHRISTMAS EVE). IN INSTANCES WHERE SHIPMENTS ARE NOT SO ENDORSED, ALL EXCESS CHARGES FOR DETENT ION OR REDELIVERY WILL BE REBILLED TO TH SUPPLIER." (82) ***** * * PLEASE CONFIRM SHIP DATE UPON * * * RECEIPT OF THIS ORDER * (CONT. ON PAGE 6)	

**SHIPPING
TERMS**

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EIN NUMBER: 56-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*

BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			* (4G) * *****		
SHIPPING TERMS			CASH TERMS		

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
3. If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents.
4. Show ID numbers on boxes and invoices if shown on this order.

5. TWO COPIES OF INVOICE, WITH FREIGHT BILL OR OTHER SHIPPING DOCUMENTS ATTACHED, ARE TO BE MAILED TO:

6. ALL OCONEE NUCLEAR STATION PURCHASING DEPARTMENT CORRESPONDENCE IS TO BE MAILED TO:

DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 245

ADDRESS
REPLY TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

FILE COPY

731087587

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EU76 STK JLR/TLC/

GC2444 PCC9370
DUKE POWER COMPANY

FILE

18617.30

PURCHASING DEPARTMENT
PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES.

E21111-K2 **EDI**

ORDER DATE
5-19-93

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE NC 28233

S DUKE POWER CO.
H OCONEE NUCLEAR STATION E21111-K2
I C/O H.A. HEDDEN
P HIGHWAY 183
O

SENECA, SC 29678
VIA DELIVER

HEREIN DESIGNATED SELLER

TAX CERTIFICATE NUMBER:
NC26 SC1002-19
EIN NUMBER: 56-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER

BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			***** * EDI ORDER * * THIS ORDER HAS BEEN TRANSMITTED * * ELECTRONICALLY TO THE VENDOR. * * PLEASE SEND ORIGINAL COPY TO THE * * EDI COORDINATOR FOR VERIFICATION. * ***** ORDER PLACED BY PHONE, BILL PARKER TO S. MERANDA 05/18/93. 2444372756 CAGE, VALVE, VALVE STYLE: GLOBE, VALVE SIZE: 16" APPLICATION: TYPE 476L-16-5-ENA "PISTON" MFR: FISHER CONTROLS CO. PART #: 4U7660X00A2 254102505 PACKING, RING, MATERIAL: TEFLON APPLICATION: FOR 24 INCH BUTTERFLY VALVE (CONT. ON PAGE 2)		
1	1	EA			12,070.80 EA
2	10	EA			25.20 EA

SHIPPING TERMS FOB: DESTINATION

CASH NET 30 DAYS
TERMS

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6. ALL OCONEE NUCLEAR STATION PURCHASING DEPARTMENT CORRESPONDENCE IS TO BE MAILED TO:

DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

ADDRESS
REPLY TO:

J.L. ROSEMAN

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases



(803) 885-3551

731087587

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EU76 STK JLR/TLC/

CC2444 PCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES.

E21111-K2

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ORDER DATE

PAGE 2

FISHER CONTROLS COMPANY
 % ROBERT E MASON & CO
 P O BOX 33424
 CHARLOTTE N C 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 56-020550			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
3	1	EA	TYPE 7640 MFR: FISHER CONTROLS CO. PART #: G1860301302 ID NUMBER: 244404368	299.25 EA
4	14	EA	CAGE, VALVE, VALVE STYLE: DIAPHRAGM CONTROL, VALVE SIZE: 8" X 10" APPLICATION: FOR 8X10 INCH FISHER DIAPHRAGM CONTROL VALVE MFR: FISHER CONTROLS CO. PART #: 2U228233272 ID NUMBER: 254200730	28.35 EA
5	2	EA	SEAL, , TYPE: SHIM APPLICATION: FOR 16 INCH FISHER V-BALL VALVE, TYPE U MFR: FISHER CONTROLS CO. PART #: 1R23764112 ID NUMBER: 244406939	926.10 EA
			ASSEMBLY, , PLUG STEM, TYPE: GLOBE VALVE APPLICATION: FOR 3 INCH GLOBE VALVE PART NUMBER 11A5229X042 FISHER CONTROL (CONT. ON PAGE 3)	

SHIPPING
TERMSCASH
TERMS

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DUKE POWER COMPANY
 INVOICE OPERATIONS - PB02G
 PO BOX 1015
 CHARLOTTE NC 28201-1015

DUKE POWER COMPANY
 OCONEE NUCLEAR STATION
 PURCHASING DEPARTMENT
 BOX 03882
 SENECA, SC 29679

ADDRESS
REPLY TO:

DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 R.F. SMITH
 General Manager, Purchases

FILE COPY

731087587

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EU76 STK JLR/TLC/

EC2444-PEC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

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E21111-K2 **EDI**

ORDER DATE

PAGE 3

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 56-020550			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
6	1	EA	MFR: FISHER CONTROLS CO. PART #: 11A5229X042 SEAL, , TYPE: BALL APPLICATION: FOR FISHER CONTROLS BALL VALVE 16 INCH MFR: FISHER CONTROLS CO. PART #: 1V629805302	254200210 469.35 EA
7	6	ST	PACKING SET, APPLICATION: FOR BALL VALVE 16 INCH MFR: FISHER CONTROLS CO. PART #: 1R516201012	254201609 51.66 ST
8	6	EA	GASKET, FLANGED FITTING, TYPE: SPIRAL WOUND, MATERIAL: 316 SS WITH ASBESTOS, SIZE: 3-9/16" ID X 4-5/16" OD X .125" THK APPLICATION: FOR FISHER VEE-BALL VALVE U TYPE 10 INCH (CONT. ON PAGE 4)	254202253 9.14 EA

SHIPPING
TERMSCASH
TERMS

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DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 20883
SENECA, SC 29579

ADDRESS
REPLY TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

FILE COPY

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ENC

V490520801 0T02

EU76 STK JLR/TLE/

002444 PCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

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E21111-K2

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ORDER DATE

PAGE 4

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 55-020550			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
9	2	EA	MFR: FISHER CONTROLS CO. PART #: 1F927299102 ADAPTER, , TYPE: SEAT RING APPLICATION: FOR A 2 1/2" X 4" X 10" FISHER MODEL ES CONTROL VALVE SERIAL NUMBERS 4831796 & 4831797 MFR: FISHER CONTROLS CO. PART #: 1U2396X0022 DELIVERY COMMITMENT: ITEM 9 - BY 05/20/93 BALANCE - BY 07/01/93 (PER S. MIRANDA) PRICE AND DELIVERY PER PRICE LIST DATED 03/03/93. DELIVERY REQUIRED: 7-01-93 PURCHASE ORDER NUMBER, ID NUMBER, AND PART(S) NUMBER (AS APPLICABLE) MUST BE SHOWN ON ALL PACKING LISTS, BOXES, CARTONS, REELS, PART(S) TAGS, AND INVOICES. (05) (CONT. ON PAGE 5)	2546320575 1,456.00 EA

SHIPPING
TERMSCASH
TERMS

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6. ALL OCONEE NUCLEAR STATION PURCHASING
DEPARTMENT CORRESPONDENCE IS TO BE
MAILED TO:

DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 219

ADDRESS
REPLY TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

731987587

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ENC

V#90520801 0T02

EU76 STK JLR/TLC/

CC2444 PCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDERTHIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL
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E21111-K2 **EDI**

ORDER DATE

PAGE 5

FISHER CONTROLS COMPANY

% ROBERT E MASON & CO

P O BOX 33424

CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER:

NC26 SC1002-19

EIN NUMBER: 56-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*

BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			"ALL INSIDE PACKAGING AND/OR PACKING MATERIAL MUST BE BIODEGRADABLE, I.E., NO PLASTICS OR STYROFOAM." (2F) "SHIPMENTS WILL BE ACCEPTED MONDAY THRU THURSDAY, 8:00 AM TILL 11:30 AM AND 12:30 PM TILL 4:30 PM, EXCEPT HOLIDAYS (INCLUDING EASTER MONDAY, DAY AFTER THANKSGIVING AND CHRISTMAS EVE). IN INSTANCES WHERE SHIPMENTS ARE NOT SO ENDORSED, ALL EXCESS CHARGES FOR DETENTION OR REDELIVERY WILL BE REBILLED TO THE SUPPLIER." (82) ***** * * CONFIRMATION-DO NOT DUPLICATE (01) * * ***** ***** * * PLEASE CONFIRM SHIP DATE UPON * * RECEIPT OF THIS ORDER * * (4G) * *****		

**SHIPPING
TERMS****CASH
TERMS**

- NOTICE TO SELLER
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DUKE POWER COMPANY
INVOICE OPERATIONS - PB02G
PO BOX 1015
CHARLOTTE NC 28201-1015

ADDRESS
REPLY TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

6. ALL OCONEE NUCLEAR STATION PURCHASING DEPARTMENT CORRESPONDENCE IS TO BE MAILED TO:

DUKE POWER COMPANY
OCONEE NUCLEAR STATION
PURCHASING DEPARTMENT
PO BOX 33885
REDA 03885
SENFCA SC 29679

FILE COPY

363558 OCO

REV. 9/92

7310820570

PS JS DMG

V#90520801 OT00 CC

EU STK EAL/CDH

PURCHASE ORDER

Mill-Power Supply Co.

5-24-82

IMPORTANT

No. H23395-73

THIS ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES

FISHER CONTROLS COMPANY
 X ROBERTT MASON & CO
 P O BOX 99424
 CHARLOTTE N C 28233

MMIS

DUKE POWER CO.
 C/O J. ED SMITH, MGR.
 OCONEE NUCLEAR STATION
 HIGHWAY 130
 T.P.O. BOX 1439
 O SENECA, SC 29678

CNS #001
 033-73307

CNS #002

HEREIN DESIGNATED SHIPPER

VIA UPS INSURED

MAKE ☒ DUKE POWER CO.
 INVOICE TO: ☐ MILL-POWER SUPPLY CO.
 MAIL INVOICE AS DIRECTED BELOW UNDER NOTICE TO SELLER

BUYER WHOSE ADDRESS AND SIGNATURE APPEAR BELOW AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED, AT THE LOCATION, AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED, THE FOLLOWING GOODS AND/OR SERVICES

ITEM NO	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
1	2	EA	DIAPHRAGM FOR FISHER CONTROLS DIAPHRAGM ACTUATOR MODEL 657 SIZE 45&50 CLASS B FURNISHED TO D.P.CO. SPEC. CNS-1205.06-3 P.O. A-98519	25510087N	54.40 EA
2	2	EA	GASKET GAGE 3 1/2 X 4 3/32 X 1/32 ASBESTOS SPEC FMS-17A2 P/N-1R384604022 FOR A FISHER 4 IN. GLOBE VALVE	244401862N	1.02 EA
3	2	EA	GASKET, BONNET 5 X 6 3/32 X 1/32 ASBESTOS SPEC FMS-17A2 PART NO. 1R372404022 FOR A FISHER 4 IN GLOBE VALVE	244401863N	1.53 EA
4	2	EA	PIN, GROOVE TYPE C FOR FISHER CONTROLS DIAPHRAGM ACTUATED CONTROL VALVE TYPE EC, GSS&YD SIZE .75, 1, 2&3 INCH BODY SCREWED, SOCKET WELD&FLANGED RATING ANSI 600 CLASS B FURNISHED TO D.P.CO. SPEC. CNS-1205.06-3	243900042N	.31 EA
5	2	EA	STEM PLUG FOR FISHER CONTROLS DIAPHRAGM ACTUATED CONTROL VALVE TYPE ED, ES, ET, EAT&WT SIZE 2.5, 3, 4, 6, 8, 10, 8X10, (CONT. ON PAGE 2)	244400468N	44.20 EA

SHIPPING TERMS

FOB MARSHALLTOWN, IOWA

CASH NET 30 DAYS

*NOTICE TO SELLER

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4. Show ID numbers on boxes and invoices if shown on this order.
5. THREE COPIES OF INVOICE, WITH SHIPPING PAPERS ATTACHED, ARE TO BE MAILED TO:

MILL-POWER SUPPLY CO.
 CHARLOTTE, N.C. 28232-2307
 P.O. BOX 32307 - TELEX 57-2346

ADDRESS REPLY TO:

E.A. LAIL

(704) 773

FILE COPY

PLAINTIFF'S EXHIBIT

1012.5

ROA_03886

PURCHASE ORDER

IMPORTANT

Mill-Power Supply Co.

No. H23395-70

THIS ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES.

PAGE 2

FISHER CONTROLS COMPANY
% ROBERT E. MASON & CO
P.O. BOX 33424
CHARLOTTE N.C. 28233

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VIA

HEREIN DESIGNATED SHIPPER

MAKE: ☐ DUKE POWER CO.
INVOICE TO: ☐ MILL-POWER-SUPPLY CO.
MAIL INVOICE AS DIRECTED BELOW UNDER NOTICE TO SELLER*

BUYER WHOSE ADDRESS AND SIGNATURE APPEAR BELOW AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
6	2	EA	10X16&14X16 INCH BODY BUTT WELD SCHEDULE 40&80&FLANGED RATING ANSI 600 CLASS F FURNISHED TO D.P.CO. SPEC. CNS-1205.06-3	244400463N	268.60 EA
7	2	EA	PLUG VALVE FOR FISHER CONTROLS DIAPHRAGM ACTUATED CONTROL VALVE TYPE ES SIZE 4&6 INCH BODY BUTT WELD SCHEDULE 40&FLANGED CLASS F FURNISHED TO D.P.CO. SPEC. CNS-1205.06-3	244401864N	18.36 EA
8	1	EA	GASKET SPIRAL WOUND 3 9/16 X 4 1/16 X 0.175 INCONEL GRAPHITE PART NO. 1R384599442 FOR A FISHER 4 IN GLOBE VALVE	244401865N	1.53 EA
9	2	EA	GASKET ADAPTOR 5 X 5 15/32 X 1/32 ASBESTOS SPEC. FMS-17A2 PART NO. 1J504704022 FOR A FISHER 4 IN GLOBE VALVE	244400489N	67.32 EA
			RING SEAT FOR FISHER CONTROLS DIAPHRAGM ACTUATED CONTROL VALVE TYPE ED, ES&ET SIZE 2.5, 4&6 INCH BODY BUTT WELD (CONT. ON PAGE 3)		
SHIPPING TERMS			CASH TERMS		

* NOTICE TO SELLER

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5. THREE COPIES OF INVOICE, WITH SHIPPING PAPERS ATTACHED, ARE TO BE MAILED TO:

MILL-POWER SUPPLY COMPANY ("BUYER")

W. T. ROBERTSON, JR., PRES.

MILL-POWER-SUPPLY CO.
CHARLOTTE, N.C. 28232-2307
P.O. BOX 32307 TELEEX 57-2346

ADDRESS
REPLY TO:

(704)

REV 2/82

FILE COPY

ROA_03887

7310820570

V#90520801 0T00 CC

EU

EAL/CDH

PURCHASE ORDER

Mill-Power Supply Co.

IMPORTANT

No. H23395-73

THIS ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES

PAGE 3

FISHER CONTROLS COMPANY
 7 ROBERT E MASON & CO
 P O BOX 33424
 CHARLOTTE N C 28233

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VIA

HEREIN DESIGNATED SHIPPER

MAKE

DUKE POWER CO.

INVOICE TO:

MILL-POWER SUPPLY CO.

MAIL INVOICE AS DIRECTED BELOW UNDER NOTICE TO SELLER*

BUYER WHOSE ADDRESS AND SIGNATURE APPEAR BELOW AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER, OR TO PERSON HEREIN DESIGNATED, AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
10	✓ 2	EA	SCHEDULE 40 FLANGED DESIGN PRESSURE 380 PSIG DESIGN TEMPERATURE 300 DEGREES F. CLASS C FURNISHED TO D.P.CO. SPEC. CNS-1205.06-3	244401866N	.85 EA
11	✓ 2	EA	GASKET, SEAT RING 3 1/2 X 3 29/32 X 1/32 ASBESTOS SPEC. FMS-17A2 P/N-1R384404022 FOR A FISHER 4 IN GLOBE VALVE	244401867N	.31 EA
12	✓ 2	EA	O-RING, 7/8 X 1/8 X 1/8 NITRILE PART NUMBER 1B885506992 FOR A FISHER 4 IN GLOBE VALVE	243900044N	.31 EA
13	✓ 2	EA	PIN, GROOVE TYPE C FOR FISHER CONTROLS DIAPHRAGM ACTUATED CONTROL VALVE TYPE ES, ET, END&U SIZE 2, 4, 6 & 8 INCH BODY FLANGED RATING ANSI 300 FURNISHED TO D. P.CO. SPEC. CNS-1205.06-3	244401868N	3.40 EA

(CONT. ON PAGE 4)

SHIPPING
TERMSCASH
TERMS

* NOTICE TO SELLER

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W. T. ROBERTSON, JR., PRES.

MILL-POWER SUPPLY CO.
 CHARLOTTE, N.C. 28232-2307
 P.O. BOX 32307 TELEEX 57-2346

ADDRESS
REPLY TO:

(704)

REV. 2/82

FILE COPY

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7310820570

V#90520801 DT00 CC

EU

EAL/CDH

PURCHASE ORDER

Mill-Power Supply Co.

IMPORTANT

No. H23395-73

THIS ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES

PAGE 4

FISHER CONTROLS COMPANY
 % ROBERT E MASON & CO
 P O BOX 33424
 CHARLOTTE N C 28239

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HEREIN DESIGNATED SHIPPER

MAKE	DUKE POWER CO.	BUYER WHOSE ADDRESS AND SIGNATURE APPEAR BELOW AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES	
INVOICE TO:	MILL-POWER SUPPLY CO.		
MAIL INVOICE AS DIRECTED BELOW UNDER NOTICE TO SELLER			
ITEM NO	QUANTITY	UNIT	DESCRIPTION
			THIS MATERIAL AND/OR SERVICE SHALL BE FURNISHED UNDER THE QUALITY ASSURANCE PROGRAM OF THE FISHER CONTROLS FACILITY AT GOVERNOR RD. & OLIVE STREET, MARSHALLTOWN, IOWA. PRICE AND DELIVERY PER YOUR QUOTATION DATED 5-17-82. COMMITTED DELIVERY 8-27-82. FORMS ATTACHED: QA-505B 7310820570. DELIVERY REQUIRED: 9-01-82 ID NUMBER AND PURCHASE ORDER NUMBER MUST BE SHOWN ON ALL PACKING LISTS, BOXES, CARTONS, REELS, PARTS TAGS, AND INVOICES. (05) THE PROVISIONS OF TITLE 10, CODE OF FEDERAL REGULATIONS, PART 21 APPLY TO THIS PURCHASE. THE SIGNER OF THIS PURCHASE ORDER SHALL BE NOTIFIED IF THIS REGULATION IS INVOKED. (CONT. ON PAGE 5)
		ID NUMBER	PRICE
			SPECIAL CLEANING, PACKAGING, AND DUKE FORM 930.1A - 79.40 EACH. DUKE FINAL INSPECTION IF REQUIRED - 25.00 EACH.
SHIPPING TERMS		CASH TERMS	

* NOTICE TO SELLER

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
3. If freight is prepaid and added to invoice attach expense bill.
4. Show ID numbers on boxes and invoices if shown on this order.
5. THREE COPIES OF INVOICE, WITH SHIPPING PAPERS ATTACHED, ARE TO BE MAILED TO:

MILL-POWER SUPPLY COMPANY ("BUYER")

W. T. ROBERTSON, JR., PRES.

MILL-POWER SUPPLY CO.
 CHARLOTTE, N.C. 28232-2307
 P.O. BOX 32307 TELEX 57-2346

ADDRESS
 REPLY TO:

(704)

FILE COPY

ROA_03889

7310820570

CCT HCS AEB

V#90520801 0T00 CC

EU STK EAL/CDH

PURCHASE ORDER

Mill-Power Supply Co.

IMPORTANT

No. H23395-73

THIS ORDER NUMBER MUST APPEAR ON ALL COPIES
OF THE INVOICE AND ON ALL PACKAGES

PAGE 5

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 39424
CHARLOTTE N.C. 28233

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HEREIN DESIGNATED SHIPPER

VIA

MAKE	DUKE POWER CO.	BUYER WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION, AT THE TIME OR TIMES, AND BY THE MEANS HEREIN SPECIFIED, THE FOLLOWING GOODS AND/OR SERVICES.			
INVOICE TO:	MILL-POWER SUPPLY CO.				
MAIL INVOICE AS DIRECTED BELOW UNDER NOTICE TO SELLER*					
ITEM NO	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			QUALITY ASSURANCE REQUIRED CONTROL LEVEL: 2 PROTECTION LEVEL: B CONDITION LEVEL: #		
SHIPPING TERMS			CASH TERMS		

* NOTICE TO SELLER

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MILL-POWER SUPPLY COMPANY ("BUYER")

W. T. ROBERTSON, JR., PRES.

MILL-POWER SUPPLY CO.
CHARLOTTE, N.C. 28232-2307
P.O. BOX 32307 TELEX 57-2346

ADDRESS
REPLY TO:

REV. 2/82

(70A)

FILE COPY

ROA_03890

PREPARED BY

DATE

4-23-82

DUKE POWER COMPANY
QUALITY ASSURANCE DEPARTMENT
FORM QA-505B

NUMBER 7310820570

PAGE 1 OF 1

QUALITY ASSURANCE REQUIREMENTS TO BE MET BY VENDORS OF ITEMS AND SERVICES

Items of services on this order must be manufactured or performed under a Duke-approved quality program. In accepting this order the designated vendor commits to the above as well as the performance and documentation of the tests or certifications checked below.

This documentation to be forwarded no later than date of shipment to: Quality Assurance Manager, Technical Services
Duke Power Company Post Office Box 33189 Charlotte, North Carolina 28242

IMPORTANT NOTICE TO VENDORS:

The documentation specified on this form constitutes an integral part of the purchase order requirements. Failure to supply it as specified will result in the items being quarantined upon receipt.

REMARKS:

*SUPPLY DOCUMENTATION IN ACCORD WITH DUKE SPEC. CNS
1205.06-3 LATEST REVISION.

The following documentation shall be forwarded as indicated above:

☒	1. Results of all tests, inspections or certifications checked above.
☒	2. Results of all tests, inspections or certifications required by referenced specifications.
☒	3. Results of all tests, inspections or certifications required by referenced codes or standards.
☒	4. Duke 930.1a Form
☒	5. Duke 930.1c Form
☐	6. _____

NOTIFICATION POINTS:

Vendor shall notify Duke QA Department at telephone number (704)373-4299 5 days prior to the following tests or inspections to allow in plant surveillance by Duke Personnel as deemed necessary.

☐ 1. None	☐ 2. Hydro Test	☒ 3. Final Inspection
☐ 4. NDE		
☐ 5. Other		

PACKAGING AND SHIPPING REQUIREMENTS:

All items to be packaged and shipped per ANSI N45.2.2-1972

Protection B

Rev. 5

Detailed codes, standards and other requirements
for tests, inspections or certifications

Line Item Number	From Purchase Order	1. Cert. of Compliance	2. Functional Test	3. Phys & Chem. Anal.	4. PT	5. MT	6. UT	7. RT	8. Hydro	9	10	11	12. ANSI N45.2.1
1	X												
2	X												
3	X												
4	X												
5	X												
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FISHER

FISHER SERVICE COMPANY - COLUMBIA, SOUTH CAROLINA

Customer Order Number

A06650-77

Fisher Agent Order Number

033 -004C98985

Invoice Date

03/06/91

Invoice Number

K022828

Sold To

DUKE POWER COMPANY
P O BOX 1002
CHARLOTTE N.C.

28201

REMIT TO:
FISHER CONTROLS INTL INC
P.O. BOX 459F
ST. LOUIS, MO. 63150

PAGE

20/21

Ship To

(Same as "Sold To" Unless Otherwise Indicated)
DUKE POWER CO/H B BARRON
OCONEE NUCLEAR STATION
7812 ROCHESTER HWY
SENECA, SC

19679

TERMS:

NET 030 DAYS IN U.S. FUNDS
F.O.B. COLUMBIA, SOUTH CAROLINA

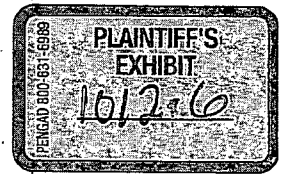
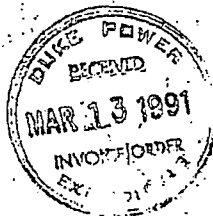
Date Shipped		
Mo.	Day	Year
3	5	91

Via

UPS NEXT DAY AIR

Item No.	Description	Quantity	Unit Price	Net Amount
00010	1P927299102 - GASKET, SPIRAL WOUND TAG: 254202253	3	9.45	28.35
00011	1B885506992 - O-RING TAG: 254202407	13	0.39	5.07
00012	1U222739102 - SEAT RING TAG: 254601358	3	385.00	1155.00
00013	24A1135X012 - SEAT RING TAG: 2546263121	2	770.00	1540.00
00014	38A1025X012 - CAGE, CAVITY, 1 STAGE TAG: 2546263124	1	1582.00	1582.00
00015	OVERTIME CHARGE - WEEKEND WORK	1	750.00	750.00
00800	FREIGHT OUT - VIA	1	122.75	122.75
	SUBTOTAL			10491.74
	INVOICE TOTAL			10491.74

RATE OK
S.H.N.



All will be allowed for material returned without our permission. This material was carefully packed and delivered to the transportation company in good condition. All claims for loss or damage in transit should be made to the transportation company at once. Seller represents that the articles or services covered by this invoice were produced in compliance with the Fair Labor Standards Act of 1938, as amended. If items covered by this invoice are for ultimate export an export license may be required.

COPROAN03892

Form FG 7165

7310904403

WA

JES

V#90520801 OT50

EU76 STK JLR/GGC/P

CC2444 PCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDERTHIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL
COPIES OF THE INVOICE AND ON ALL PACKAGES.

A06650-77

EDI

ORDER DATE

PAGE 7

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER:

NC26 SC1002-19

EIN NUMBER: 56-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*

BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			***** ***** ***** * PLEASE CONFIRM SHIP DATE UPON * * RECEIPT OF THIS ORDER * ***** (4G) ***** *****		
SHIPPING TERMS			CASH TERMS		

NOTICE TO SELLER

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4. Show ID numbers on boxes and invoices if shown on this order.
5. THREE COPIES OF INVOICE, WITH FREIGHT BILL OR OTHER SHIPPING DOCUMENTS ATTACHED, ARE TO BE MAILED TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
PO BOX 1002
CHARLOTTE NC 28201-1002

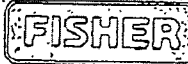
DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

ADDRESS
REPLY TO:

REV. 09/90

TELEX 57-2346 TELECOPIER: CUSTOMER GROUP (704) 373-3336
POWER GROUP (704) 382-2298

ROA03893



FISHER SERVICE COMPANY, COLUMBIA, SOUTH CAROLINA

Customer Order Number	Fisher / Agent Order Number	Invoice Date	Invoice Number
A06650-77	033 -G04C93985	03/06/91	K022828

Old To
DUKE POWER COMPANY
P O BOX 1002
CHARLOTTE N.C.
28201

REMIT TO:
FISHER CONTROLS INTL INC
P.O. BOX 459F
ST. LOUIS, MO. 63150

PAGE 1

Ship To
(Same as Sold To Unless Otherwise Indicated)
DUKE POWER CO/H B BARRON
OCONEE NUCLEAR STATION
7812 ROCHESTER HWY
SENECA, SC
19679

TERMS:
NET 030 DAYS IN U.S. FUNDS
F.O.B. COLUMBIA, SOUTH CAROLINA

Date Shipped		
Mo.	Day	Year
3	5	91

Via UPS NEXT DAY AIR

Item No.	Description	Quantity	Unit Price	Net Amount
JOB NO: T15811				
0001	10A4223X012 - SEAL RING/SPR,RADIAL TAG: 244400452	2	80.50	161.00
0002	10A4225X012 - RING,RETAINING,EXT TAG: 244402414	1	25.20	25.20
0003	RPACKX00032 - KIT,REPAIR TAG: 244406359	3	29.40	88.20
0004	11A5229X042 - PLUG/STEM,HI-TEMP TAG: 244406939	2	980.00	1960.00
0005	2BA1010X022 - PLUG/STEM,CAV III TAG: 2444261242	4	661.50	2646.00
0006	1H849806992 - O-RING TAG: 254101840	3	0.39	1.17
0007	81860301302 - PACKING,V-RING TAG: 254102505	12	26.60	319.20
0008	81860401302 - PACKING ADAPTOR,MALE TAG: 254102508	2	26.60	53.20
0009	1R516201012 - PACKING,SET TAG: 254201609	1	54.60	54.60

INVOICE CONTINUED



It will be allowed for material returned without our permission. This material was carefully packed and delivered to the transportation company in good condition. All claims for loss or damage in transit should be made to the transportation company at once. Seller represents that the articles or services covered by this invoice were produced in compliance with the Fair Labor Standards Act of 1938, as amended. If items covered by this invoice are for ultimate export an export license may be required.

COROA 03854

Form FG 7165

7310904483

WA

JES

V#90520801 DT50

EU76 STK JLR/GGC/P

CC2444 FCC9370

12424.99

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDER

THIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES.

A06650-77 **EDI**

ORDER DATE

2-28-91

FISHER CONTROLS COMPANY
 % ROBERT E MASON & CO
 P O BOX 33424
 CHARLOTTE N C 28233

S. DUKE POWER CO.
 H. C/O H.B. BARRON
 P. OCONEE NUCLEAR STATION
 T. 7812 ROCHESTER HIGHWAY
 O. SENECA, S.C. 29678
 P.O. BOX 1439, SENECA S.C. 29679
 VIA YOUR TRUCK

HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER:

NC26 SC1002-19

EIN NUMBER: 56-020550

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*

BUYER, WHOSE ADDRESS AND SIGNATURE APPEAR BELOW, AGREES TO PURCHASE FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			***** * * EDI PARALLEL TEST ORDER * * * THIS ORDER PRINTED FOR VERIFICATION * * PURPOSES ONLY. * * * PLEASE SEND ORIGINAL TO EDI * * COORDINATOR. * * ***** ORDER PLACED BY PHONE 2-27-91 B. PARKER TO A. STEHLEY 10A4223X012 244400452 RING, , TYPE: SPRING LOADED SEAL, APPLICATION: FOR GLOBE VALVE SIZE 4 INCH TYPE ET, 6 INCH TYPE EWT, 6 INCH X 10 INCH TYPE ET, 8 INCH TYPE EWT, 10 INCH X 16 INCH TYPE EWT, 14 INCH X 16 INCH TYPE EWT MANUFACTURER: FISHER PRODUCTS INC., PART NUMBER: 10A4223X012 (CONT. ON PAGE 2) 2 EA 80.50 EA		
SHIPPING TERMS FOR JOBSITE CASH NET 30 DAYS					

***NOTICE TO SELLER**

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DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 PO BOX 1002
 CHARLOTTE NC 28201-1002

ADDRESS
 REPLY TO:

DUKE POWER COMPANY
 PURCHASING DEPARTMENT
 R.F. SMITH
 General Manager, Purchases

J.L. ROSEMAN

REV. 09/90

TELEX 57-2346 TELECOPIER: CUSTOMER GROUP (704) 373-3336
 POWER GROUP (704) 382-2298

RQA-03895

(704) 373-6059

[illegible]

7310904483

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JES

V#90520801 DT50

EU76 STK JLR/GGC/P

CC2444 FCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

PURCHASE ORDERTHIS PURCHASE ORDER NUMBER MUST APPEAR ON ALL
COPIES OF THE INVOICE AND ON ALL PACKAGES.

A06650-77 **EDI**

ORDER DATE

PAGE 2

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 56-020550			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
2	✓ 1	EA	10A4225X012 244402414 RING, RETAINING, APPLICATION: FOR GLOBE VALVE SIZE 4 INCH TYPE ET, 6 INCH TYPE EWT, 6 INCH X 10 INCH TYPE ET AND EWT, 10 INCH X 16 INCH TYPE EWT, 14 INCH X 16 INCH TYPE EWT MANUFACTURER: FISHER PRODUCTS INC., PART NUMBER: 10A4225X012	25.20 EA
3	✓ 3	EA	RPACKX00032 244406359 KIT, , MODIFIER: REPAIR, TYPE: GLOBE VALVE, APPLICATION: FOR FISHER GLOBE VALVE TYPE 657-AR SIZE 3 INCH DESIGN PRESSURE 300 PSI DESIGN TEMPERATURE 300 DEGREES FAHRENHEIT SOCKET WELD AIR OPERATED CAST STEEL MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: RPACKX00032	29.40 EA
4	✓ 2	EA	11A5229X042 244406939 ASSEMBLY, , MODIFIER: PLUG STEM, TYPE: GLOBE VALVE, APPLICATION: FOR 3 INCH (CONT. ON PAGE 3)	980.00 EA

SHIPPING TERMS	CASH TERMS

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PURCHASING DEPARTMENT
PO BOX 1002
CHARLOTTE NC 28201-1002

ADDRESS
REPLY TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.E. SMITH
General Manager, Purchases

REV. 09/90

TELEX 57-2946 TELECOPIER: CUSTOMER GROUP (704) 373-3336
POWER GROUP (704) 382-2298

ROA 00897

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V590520801 DT50

EU76 STK JLR/GGC/P

CC2444 PCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

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A06650-77 **EDI**

ORDER DATE

PAGE 3

FISHER CONTROLS COMPANY
% ROBERT E. MASON & CO
P O BOX 33424
CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 56-020550			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*		
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
5	4	EA	GLOBE VALVE PART NUMBER 11A5229X042 FISHER CONTROL MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: 11A5229X042 28A1010X022 2444261242 STEM, TYPE: FLOW CONTROL, SIZE: 4", APPLICATION: FOR FISHER VALVE 600 POUND WELD NECK SERIAL NUMBER 8980427		661.00 EA
6	3	EA	MANUFACTURER: ROBERT E. MASON CO., PART NUMBER: 28A1010X022 1H849806992 254101840 O-RING,		.39 EA
7	12	EA	MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: 1H849806992 G1860301302 254102505 PACKING, RING, MATERIAL: TEFLON, APPLICATION: FOR 24 INCH BUTTERFLY VALVE TYPE 7640		260.60 EA
(CONT. ON PAGE 4)					
SHIPPING TERMS			CASH TERMS		

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DUKE POWER COMPANY
PURCHASING DEPARTMENT
PO BOX 1002
CHARLOTTE NC 28201-1002

ADDRESS
REPLY TO:

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

REV. 03/90

TELEX 57-2346 TELECOPIER: CUSTOMER GROUP (704) 373-3336
POWER GROUP (704) 382-2298

ROA-00898

7310904483

WA

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V#90520801 DT50

EU76 STK JLR/GGC/P

CC2444 PCC9370

DUKE POWER COMPANY

PURCHASING DEPARTMENT

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A06650-77 **EDI**

ORDER DATE

PAGE 4

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE NC 28233

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HEREIN DESIGNATED SELLER

VIA

TAX CERTIFICATE NUMBER: NC26 SC1002-19 EIN NUMBER: 56-020550			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
8	✓ 2 EA		MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: G1860301302 G1860401302 254102508 PACKING, RING, MATERIAL: TEFLON, APPLICATION: FOR 24 INCH TYPE 7640 BUTTERFLY VALVE	26.60 EA
9	✓ 1 ST		MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: G1860401302 1R516201012 254201609 PACKING SET, APPLICATION: FOR BALL VALVE 16 INCH	54.60 ST
10	✓ 3 EA		MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: 1R516201012 1P927299102 254202253 GASKET, FLANGED FITTING, TYPE: SPIRAL WOUND, MATERIAL: 316 SS WITH ASBESTOS, SIZE: 3-9/16" ID X 4-5/16" OD X .125" THK, APPLICATION: FOR FISHER VEE-BALL VALVE U TYPE 10 INCH	9.45 EA
			MANUFACTURER: FISHER CONTROLS CO., PART NUMBER: 1P92729910 (CONT. ON PAGE 5)	
SHIPPING TERMS			CASH TERMS	

***NOTICE TO SELLER**

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DUKE POWER COMPANY
PURCHASING DEPARTMENT
PO BOX 1002
CHARLOTTE NC 28201-1002

DUKE POWER COMPANY
PURCHASING DEPARTMENT
R.F. SMITH
General Manager, Purchases

ADDRESS
REPLY TO:

REV. 09/90

TELEX 57-2346 TELECOPIER: CUSTOMER GROUP (704) 373-3336
POWER GROUP (704) 382-2298

ROA 03899

7310853281

KK JS MLR V490520801 OT00

EU76 STK EAL/CJC/C

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CC1155 PCC1330

PURCHASE ORDER

MILL-POWER SUPPLY CO.

9-10-85

FISHER CONTROLS COMPANY
Z ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE NC 28233

S DUKE POWER CO. C02027986
H C/O M.S. TUCKMAN M49884-73
I OCONEE NUCLEAR STATION
P HIGHWAY 130
T P.O. BOX 1439
O SENECA, SC 29679
VIA UPS INSURED

HEREIN DESIGNATED SELLER

MAKE INVOICE TO: DUKE POWER COMPANY
TAX CERTIFICATE NUMBER
NC 26 SC 1002-19

MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER
BUYER WHOSE ADDRESS AND SIGNATURE APPEAR BELOW AGREES TO PURCHASE
FROM SELLER THE GOODS AND/OR SERVICES DESCRIBED BELOW UPON THE TERMS
AND CONDITIONS SET FORTH ON BOTH THE FRONT AND REVERSE SIDES OF THIS
PURCHASE ORDER. SELLER SHALL TRANSFER AND DELIVER TO BUYER OR TO PERSON
HEREIN DESIGNATED AT THE LOCATION AT THE TIME OR TIMES AND BY THE MEANS
HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			NOTE: SPARE PARTS FOR MODEL NO 621 PRESSURE REGULATOR W/1" PARTS, ON PURGE METER RACK REF ON DWG NO AECC 1192471, EQUIPMENT NO CP-S		
	4	EA	1A8328000A2 DISC HOLDER, SST FOR MODEL NO 621 PRESSURE REGULATOR WITH 1 INCH PARTS	115502378	4.62 EA
	4	EA	FISHER CONTROL PART NO. 1A8328000A2 GASKET, BODY ASBESTOS FOR MODEL NO 621 PRESSURE REGULATOR WITH 1 INCH PARTS ON PURGE METER RACK ON DWG NO AECC 1192471 RADWASTE AEROJET EQUIPMENT FISHER CONTROL PART NO 1A832504032	115500444	.36 EA
3	4	EA	DIAPHRAGM, NITRILE FOR MODEL NO. 621 PRESSURE REGULATOR WITH 1 INCH PARTS ON PURGE METER RACK ON DWG NO AEVV 1192471 RADWASTE AEROJET EQUIPMENT FISHER CONTROL PART NO 1E606602052 (CONT. ON PAGE 2)	115502379	1.95 EA

MMIS

SHIPPING
TERMS

FOR MARSHALLTOWN, IDWA

CASH
TERMS

NET 30 DAYS

*NOTICE TO SELLER

MILL-POWER SUPPLY COMPANY ("BUYER")

1. ACKNOWLEDGE ORDER BY PROMPT ACCEPTANCE AND GIVE DATE ORDER WILL BE SHIPPED.
2. Acceptance is expressly limited to terms and conditions set forth herein and on reverse side.
3. If freight is prepaid and added to invoice, attach freight bill or other appropriate shipping documents.
4. Show ID numbers on boxes and invoices if shown on this order.
5. THREE COPIES OF INVOICE, WITH FREIGHT BILL OR OTHER SHIPPING DOCUMENTS ATTACHED, ARE TO BE MAILED TO:

W. T. ROBERTSON, JR., PRES.

MILL-POWER SUPPLY CO.
P.O. BOX 32307
CHARLOTTE, N.C. 28232-2307

ADDRESS
REPLY TO:

E.A. LAIL

(704) 5773

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REV. 9-84

FILE COPY

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7310853281

KK JS MLE V490520801 OT00

EU76 STK EAL/CJC/C

CC1155 PCC1330

PURCHASE ORDER

MILL-POWER SUPPLY CO.

IMPORTANT

No. M49884-73
THIS ORDER NUMBER MUST APPEAR ON ALL COPIES
OF THE INVOICE AND ON ALL PACKAGES.

PAGE 2

FISHER CONTROLS COMPANY
% ROBERT E MASON & CO
P O BOX 33424
CHARLOTTE N C 28233

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HEREIN DESIGNATED SELLER

VIA

MAKE INVOICE TO:			MAIL INVOICE AS DIRECTED UNDER NOTICE TO SELLER*	
ITEM NO.	QUANTITY	UNIT	DESCRIPTION	PRICE
4	✓ 4	EA	O-RING, NITRILE FOR MODEL NO 621 PRESSURE REGULATOR WITH 1 INCH PARTS ON PURGE METER RACK ON DWG NO AECC 1192471 RADWASTE AEROJET EQUIPMENT FISHER CONTROL PART NO 1E472706992	115500515 .36 EA
5	✓ 4	EA	1E543520012 GASKET, IRON FOR MODEL NO 621 PRESSURE REGULATOR WITH 1 INCH PARTS ON PURGE METER RACK ON DWG NO AECC 1192471 RADWASTE AEROJET EQUIPMENT FISHER CONTROL PART NO 1E543520012	115502380 .36 EA
6	✓ 1	EA	621-141 REGULATOR, PRESSURE 1 INCH SPRING FOR MODEL NO 621 PRESSURE REGULATOR WITH 1 INCH PARTS ON PURGE METER RACK ON DWG NO AECC 1192471 RADWASTE AEROJET EQUIPMENT FISHER CONTROL PART NO 621 20-35 PSIG OUTLET NO 621-141.	115502381 80.64 EA
7	✓ 1	EA	621 REGULATOR, PRESSURE 1 INCH SPRING FOR MODEL NO. 621 PRESSURE REGULATOR WITH 1 INCH PARTS ON PURGE METER RACK ON DWG NO AECC 1192471 RADWASTE AEROJET EQUIPMENT FISHER CONTROL PART NO. 621 25-60 PSIG (CONT. ON PAGE 3)	115502382 80.64 EA
SHIPPING TERMS			CASH TERMS	

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MILL-POWER SUPPLY CO.
P.O. BOX 32307
CHARLOTTE, N.C. 28232-2307

ADDRESS
REPLY TO:

W. T. ROBERTSON, JR., PRES.

REV. 9-84

FILE COPY

(704)

TELEX

ROA_03902

7310853281

KK JS MLR VP90520801 DT00

EU76 STK EAL/CJC/C

CC1155 PCD1330

PURCHASE ORDER

MILL-POWER SUPPLY CO.

IMPORTANT

No.

N49884-73

THIS ORDER NUMBER MUST APPEAR ON ALL COPIES OF THE INVOICE AND ON ALL PACKAGES

PAGE 3

FISHER CONTROLS COMPANY
 Z ROBERT E MASON & CO
 P O BOX 33424
 CHARLOTTE N C 28233

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HEREIN DESIGNATED SELLER

VIA

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 HEREIN SPECIFIED THE FOLLOWING GOODS AND/OR SERVICES.

ITEM NO.	QUANTITY	UNIT	DESCRIPTION	ID NUMBER	PRICE
			OUTLET NO. 621-168.		
			DELIVERY COMMITMENT: BY 11-17-85 (10 WKS.)		
			ABOVE ITEMS 1-5 PER R3000X DATED 6/29/85.		
			ITEMS 6&7 PRICE & DELIVERY PER GEORGE CHANG VERBAL QUOTE TO D. LITTLE 9/5/85.		
			DELIVERY REQUIRED: 11-17-85		
			ID NUMBER AND PURCHASE ORDER NUMBER MUST BE SHOWN ON ALL PACKING LISTS, BOXES, CARTONS, REELS, PARTS TAGS, AND INVOICES. (05)		
			THIS PURCHASE IS BEING MADE BY MILL-POWER SUPPLY COMPANY ACTING SOLELY IN ITS CAPACITY AS AGENT FOR DUKE POWER COMPANY.		
SHIPPING TERMS			CASH TERMS		

NOTICE TO SELLER

MILL-POWER SUPPLY COMPANY ("BUYER")

W. T. ROBERTSON, JR., PRES.

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MILL-POWER SUPPLY CO.
 P.O. BOX 32307
 CHARLOTTE, N.C. 28232-2307

ADDRESS
 REPLY TO:

REV. 9-84

(704)

FILE COPY

TELEX 5

ROA_03903

INACTIVE

Packing To Be Square Braided Blue African
Asbestos Impregnated With IFE And Furnished
In Ring Form With Bevel Joint. Packing must
be free of excessive graphite and dirt.

The Following Materials Have Been Approved:

Johns-Manville Style No. 2014

Garlock, Inc. No. 5561

INACTIVE

FC_01975

© FISHER CONTROLS, 1982

				TITLE Blue African Asbestos- IFE Packing.				TYPE	
				FISHER ® GOVERNOR CO. MARSHALLTOWN, IOWA				DESIGN NO. DRAWER NO. SUPERSEDES DWG. NO.	
DWN. <u>WHP 2-8-56</u> TRCD. CHKD. <u>HGR 2-17-56</u> APPR.				DATE BY CHKD. 9-15-65 <u>ERB</u> 6-29-61 <u>IRB</u>				SIZE INACTIVE DWG. NO. <u>EMS17D10</u> REV. <u>D</u>	
REVISIONS				SCALE					

ALL DIMENSIONS ARE IN INCHES.

ROA_03904

Duimstra 2006-0037