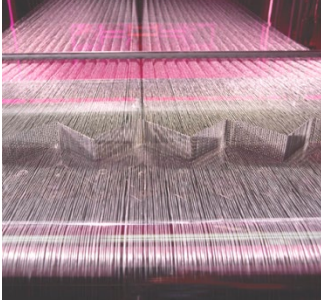


M-720 – Beaming Specifications



Fiberglass is a natural, lustrous, white fiber that AGY produces in either a yarn, roving or chop form. The filaments are smooth, non-cellular and generally cylindrical in form and, with the exception of the inorganic sizing, are non-combustible.

General Product Specifications

AGY beam workmanship is defined by:

- Splices:** Splicing in individual beams is permitted, and will be neat, clean and free from dirt, oil and grease. The splices will have an overlap not exceeding one half inch and will not stick to other ends. Splice free beams are also available, however must be specifically requested.
- Slack Ends:** Any slack ends that may occur will be identified with a round red tissue marker.
- Beam condition:** Beams shall be free of dents or nicks with sharp edges or burrs on the barrel or the inside surface of the flanges.
- Doffing:**
- At the end of the yardage, the total number of ends will be sandwiched together with masking tape so that the ends are properly spaced.
 - The end of the beam will be anchored firmly to the sandwiched tape by dividing the yarn sheet into V-shaped sections, knotted to prevent damage in transit.
- Flagging:** Five red circular discs shall be placed in each section beam at the point where measurement of the beam length commences.
- Yarn tension:** All ends must be wound with even tension across the entire width of the beam and for its total length.
- Beam length:** Beam length tolerance for all yarns in +50, – 0 yards.
- Beam taper:** Beam taper is defined as the difference between the circumferences of the two ends of the beam, with a maximum of 1/16 inch allowed.
- Crossed ends:** Not permitted.
- Lost ends:** The point of the last end break shall be flagged with a black tissue and a new end inserted.

M-720 – Beaming Specifications

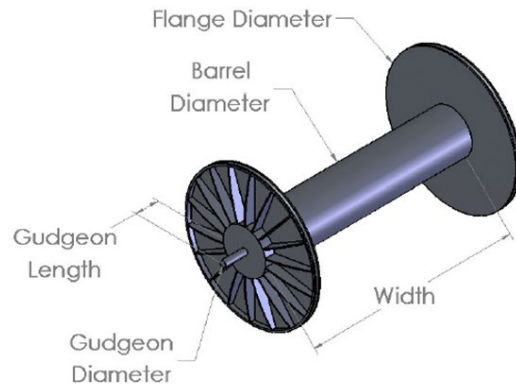
Nominal Packaging Dimensions

Beams Specifications - all measurements are in inches

	9002	9004	9020
Flange Diameter	36 +/- 0.30	36 +/- 0.30	40 +/- 0.30
Traverse	54.25 +0.20 - 0	64 +0.20 - 0	54.25 +0.20 - 0
Barrel Diameter	11.75 +0.10 - 0	11.75 +0.10 - 0	11.75 +0.10 - 0
Gudgeon Diameter	1.625	1.625	1.625
Gudgeon Length	5 or 6	5 or 6	6

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Beams shall be wrapped securely between the flanges with polyethylene sheeting and taped to create a plastic sleeve covering. A single-faced corrugated paper sheet is then wound around the polyethylene two or three times with the outside taped across its edge in at least three places. The tape shall not contact either the polyethylene or the flanges.



Storage, Shelf Life and Handling

Storage and Shelf Life:

AGY recommends storing the materials in accordance with appropriate safety considerations, away from exposure to the elements and at 65-80F (18-27C) and 50-70% humidity. If the materials are stored under these conditions, they are stable, non reactive and will not degrade or exhibit negative characteristics for at least 3 years from the date of manufacture. Unused, unopened product older than this is likely still in good condition, however careful evaluation is recommended. Prior to use, pallets should be placed in the production area and any plastic wrap removed for a minimum of 24 hours to allow the material to acclimate to the processing environment. Special care should be given to pallets being moved from a cold environment into a warm, humid area as condensation may occur and this additional moisture can negatively impact the runability of the material, however, once the material has acclimated, this will no longer be an issue.

For product traceability reasons, the pallet label should be recorded or retained.

Handling:

Fiberglass products process best if temperature and humidity are controlled, primarily because this will help to control the buildup of static electricity, fuzz and fly. AGY recommends that the material be run at 70 +/- 5 degrees F and 60 +/- 5% RH.

Test Methods and Certificates

A copy of test methods and or a certificate of conformity may be issued upon request.

Each beam shall be appropriately identified with not only the product identification, but also with the beam set information.

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