

TENTATIVE CONDENSED MANUFACTURING INSTRUCTIONS
DEVELOPMENT DEPARTMENT

PRODUCT NO.	BMMA-5715 BK 25
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SUPERSEDES	

HAZARDS TO PERSONNEL, EQUIPMENT, OR MATERIAL: Usual for phenolic molding materials.

MANUFACTURING INSTRUCTIONS: In addition to the Formula and Manufacturing Instructions found on the previous pages, the following guides should be observed:

1. Resin specifications: BRN-5351 - 14.0-17.0 CST viscosity.
2. It is imperative that no more than 750 pounds of fines be re-circulated as rework in each 2000 pound mix. Do not put heat on back finish roll. Also the roll temperatures should be held to those specified. These steps will insure that material will have the maximum plunger molding latitude for which it was designed.
3. Change plasticity by varying resin/hexa with wood flour.
4. Insure that Izod impact does not drop below 0.37 minimum. If low, add 1% RM 134P, and subtract from RM 16C.
5. Be sure to blend each tank for 45 minutes to get highest apparent density. Slide on rotex should be pushed all the way in to get proper fines content.
6. Blend through CBS. Drums, bags or gaylords may be used for packing.
7. Special packing requirements for Cutler Hammer: "Caution" label on container must be blanked out. Each pallet should contain a maximum of 1500 pounds.

SIGNED

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Lewis D. Fikberg
ORIGINATOR