

**TENTATIVE CONDENSED MANUFACTURING INSTRUCTIONS**  
DEVELOPMENT DEPARTMENT

|             |                    |
|-------------|--------------------|
| PRODUCT NO. | BMMA-8450 Bk 25 DC |
| ISSUE NO.   | 1                  |
| DATE        | 9/9/65             |
| SUPERSEDES  |                    |

**HAZARDS TO PERSONNEL, EQUIPMENT, OR MATERIAL:**

Usual for phenolic molding material

**MANUFACTURING INSTRUCTIONS:**

In addition to the formula and manufacturing instructions found on the previous pages, the following guides should be observed:

1. Resin specifications: a. BRN-8019-Visc. 11-14 cst.  
b. BRN-7174-Visc. 12-14 cst.

2. For slight changes in plasticity, vary roll temperature or sheet weight. For greater changes, vary resin/hexa with woodflour. For a resin increase, the recommended increment for a 2000 pound mix is:

Add { 20# BRN-8019  
3# BRN-7174  
3# RM-4G

Subtract 26# woodflour

3. Where possible, limit the amount of fines recirculated as rework to 25%.

4. Be sure to blend for 45 minutes to get highest apparent density possible.

5. Material is to be processed through CBS. Drums, bags or gaylords may be used for packaging.

6. No-Vo screens are to be used for dust control of the product.

7. Special packaging instructions for Cutler Hammer: "Caution" label on containers must be blanked out. Each pallet should contain no more than 1500 pounds of material.

SIGNED



ORIGINATOR

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