

S
C.V.
CG 85 CODE SF-85 PKG.
→ LOT 85345
EST. WGT. 5173 LBS.
STD. HRS. TIME M

PROCESSES		APPROVED BY	
(D)	SF-85	()	RFW 9-10-69
()		()	TEW 9-18-69
()		()	RBM 9-25-69
()		()	
re TYPED BY			
emw 1221/6			

NON-BLEEDING

EQUIPMENT		NAME: CRUDE CPC/AF BAKE	USE LBS.	N CODE	ACCT LBS.
Misc 1	A	Make bakes of 5-20# pans each consuming		N-8984-C	6122
	B	Record bake & RM info in attached table			
Trent 2	1	Install trent furnace temp controller charts			
	2	Turn on: exhaust fan, tower cooling water, furnace, and CO ₂ heat exchanger steam			
	3	Set: oven controller at 300°C, heater controller at 350°C			
	4	Weight & level 5 pans at 20# per pan	100	N-8984-C	0
	5	When oven reaches 285-290°C turn on CO ₂ supply at 15 psi/28% of Rota, slide in 5-20# pans, close and secure (dog) door			
		Record: Time in table, Page 2			
	6	When oven reaches 275°C on upswing start bake cycle			
		Record: Time in table, Page 2			
Prep 3	7	Bake 0.85 hrs (51 min) at 275-320°C			
		Record: Temp in table, Page 2			
Trent 4	8	Repeat Step 4			
	9	When S-7 bake completed remove 5 pans from oven and promptly place under cooling hood			
	10	Immediately repeat S-5 thru 9 as needed			
Misc 5		Note: Just before opening door loosen door clips & open damper above hood over oven door. Close damper & secure door clips as soon as pans in and door closed			
	11	Cool pans 30 min or longer; then crush & dump into clean relined 55 gal metal drums			
	12	Stencil SF-85, Lot, Gross, Tare, & Net Wgts			
	13	Repeat S-9 thru 12 until complete			
		Note: A. Calc: 6122 #N-8984 x .845 = # SF-85			
		B. Record # SF-85 under Est Wgt.			
		Note: At least twice (2) during each shift climb to first landing on cooling tower and record duct work			
NOTE: REPAIR VENTILATION DUCTWORK HOURLY TO PREVENT PLUGGAGE & FUMES IN BUILDING					

EQUIPMENT

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EST. WGT.

LBS.

BAKE No.	STEP 4 LOT	STEP 5 TIME IN OVEN	STEP 7 TIME START BAKE	STEP 8 5 MIN	10 MIN	TEMP - C 20 MIN	30 MIN	40 MIN
1	SF85-86	3:55	11:20	275	280	280	280	
2		12:20	1:20					
3		1:20	2:15					
4		2:15	3:10					
5		3:10	4:05					
6		4:05	5:05					
7		5:05	6:00					
8		6:00	7:05					
1	103113	9:15	9:45	300	275	275	280	
2	103113	11:40	12:10	300	275	280	280	
3	103114	1:15	1:45	300	280	280	280	
4	103114	2:45	3:15	300	280			
1	103114	4:20	4:25					
2	103114	5:30	5:40					
3	103116	7:10	7:20					
4	103111							
1	3-11 4-15-81	5:35	5:40	300				
2	SF85/8534	3:30	4:25	300	300	300	300	
3		4:25	5:20					
4		5:20	6:15					
5		6:15	7:10					
6		7:10	8:05					
7		8:05	9:00					
8		9:00	9:15					
1	SF85/8534	10:20	11:20					
2								
3								
4								
5								
6								
7								
8								
1	103-118	11:45	11:45	320	225	225		
2	103-118	12:50	12:50	310	220	260		
3	103-118	1:40	1:55	210	250	200		
4	103-010	2:00	2:55	225	210			
5	103-010	3:50	3:55	225	250			
6	103-010	5:00	5:00	215				
1	SF85/8534	4:20	5:15	300	320	320		
2		5:15	6:00					
3		6:00	6:55					
4		6:55	7:00					
5		7:00	7:55					
6		7:55	8:20					
7		8:20	9:00					
8		9:00	9:55					
1		10:00	10:00					
2		10:20	11:20					
3								
4								
5								
6								
7								
8								
1	103-118	11:35	11:35	290	300	300	280	210
2		12:35	12:35	290	295	200	220	220
3		1:35	1:35	290	295	300	280	230
4		2:35	2:35	290	295	300	280	210
5		3:35	3:35	290	295	300	280	220
6		4:40	4:40	295	300	300	280	230
7		5:40	5:40	285	300	300	280	220
8		6:40	6:40					

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BAKE No.	STEP 4	STEP 5	STEP 7	STEP 8		TEMP °C			
	LOT	TIME IN OVEN	TIME START	5 MIN	10 MIN	20 MIN	30 MIN	40 MIN	
	7-31	M	BAKE OUT						
1	102-095	8:00 AM	8:50 AM	320	325	325	325	325	
2	103-109	8:50 AM	9:40 AM	310	325	325	325	325	
3	103-109	9:55 AM	10:45 AM	320	325	325	325	325	
4		10:50	11:40 AM	300	315	325	325	325	
5		11:55	12:45 AM	310	320	325	325	325	
6	103-108	12:50	1:40 PM	310	325	340	325	325	
7	103-108	1:40	2:20 PM	315	320	320	325	325	
8	103-108	2:50	3:20 PM	310	320	320			
9	11	3:20	4:15						
10		4:20	5:15						
11		5:20	6:15						
12		6:20	7:15						
13		7:20	8:15						
14		8:25	9:20						
15		9:30	10:25						
16		10:35	11:30						
1	1365	11:35	12:20	325	320	325			
2	102-092	12:35	1:130	315	325				