Development Run Report
BMAA-5715 Black 25
Batches 6 and 7

Processing Conditions Used:

Roll Type	*Front	*Back
Charge	140 to 165°F.	50 to 80 psig steam
Finish	235 to 255°F.	Water to 230°F.
Squeeze	water	75 to 300°F.

*Note: The temperature ranges given represent the temperature variation extremes used during the run.

Miscellaneous:

Blending of raw mix - 15 minutes
Entoleted
Number of cuts - three (1/3 roll)
Rolling cycle - 40/40
Sheet weight - 27 to 32 pounds
Squeeze roll sheet thickness - 0.125 - 0.150
Cutter screen - ¼"
Rotex screen - 12M/OXX then 12M/1XX
Reel blended - continuous blending while loading plus 45 minutes

Problems Encountered:

1. Variation of apparent density. Limit 0.560 g/cc min. Batches varied from 0.508 g/cc to 0.592 g/cc.
2. Very poor appearance, especially extremely pronounced smear; molded disc waxy to the touch.
3. Low impact. Limit 0.370 ft.-lb./in. notch. Batches varied from a low of 0.364 to a high of 0.392 ft.-lb./in. notch.
4. Difficulty of stiffening the plasticity of material.

This material will be blended and released by Mr. Fishberg for evaluation by customer.

Original Signed By
Herve' E. Kipp

Herve' E. Kipp

HEK:vvb

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