M. Stephens JAN 21 1981 MAKING INSTRUCTIONS: BATCH UNIT

S C.V. D.V.

CG 85 CODE SF-85 PKG. _____

→ 85338

EST. WGT. 5560 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 122176		

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	6568
	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			
	7	Bake 0.85 hrs (51 min) at 275-320°C Record: Temp in table, Page 2			
Prep 3	8	Repeat Step 4			
Trent 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 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			
Misc 5	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: 6568 #N8984 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 rod out duct work~~			
		NOTE: REAM VENTILATION DUCTWORK HOURLY TO PREVENT PLUGGAGE & FUMES IN BUILDING			

PUNCHED & CHECKED JAN 24 1981

QUIPMENT | PAGE 2 CG 85 CODE SF-85 EST. WGT. _____ LBS.

BAKE No.	STEP 4 N-SG84-C 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	009-357	11:45 PM	11:45 PM	300	305	310	315	
2	008-333	12:45	12:45	305	310	315	320	
3	008-333	1:45	1:45	305	310	315	320	
4	008-333	2:45	2:45	305	310	315	320	
5	008-333	3:45	3:45	300	305	310	310	
6	don't have lot No	4:45	4:45	300	305	310	315	
7		5:45	5:45	300	305	310	320	
8	" "	6:40	6:40	300				

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EQUIPMENT | PAGE 2 CG 85 CODE SF-85 EST. WGT. LBS.

	Bake No.	Step 4 N / C LOT	Step 5 Time In Oven	Step 7 Time Start Bake	Step 8 5 Min	10 Min	Temp - C 20 Min	30 Min	40 Mi
3-11		371	12:55	1:50	280	280	280	280	
		321	5:55	6:10	275	275	290	290	
		375	6:55	7:05	275	275	290	290	
		325	8:00	8:05	"	"	"	"	
		"	9:00	9:00					
			9:55	10:00					
			10:55	11:00					
	1	don't have	12:30 AM	12:30 AM	275	280	295	300	
	2	lot NO	1:30 AM	1:30	275	285	300	300	
	3	" "	2:30 AM	2:45	275	280	295	295	
	4	" "	3:45	3:45	275	285	295	300	
	5	008-325	4:45	4:45	280	290	300	300	
	6	008-325	5:45	5:45	275	285	295	300	
	7	"	9:45 AM	9:45	"	"	"	"	
	8								
3-11	1	008-325	3:50 PM	3:50	270	275	295	300	
	2	008 325	5:00	5:00	300	300	325	350	
	3	008 336	5:55	6:00	325	325	350	350	
	4	008 336	6:55	7:00	325	325	350	350	
	5	008 336	7:54	8:00	325	325	325	350	
	6	008 336	8:55	9:00	325	325	350	350	
	7	008 336	10:15	10:30	300	325	350	350	
	1	008 336	11:45 PM	11:45	295	320	325	325	
	2	007 383	12:45 AM	12:45 AM	300	310	310	315	
	3	007 383	1:45	1:45	300	310	310	320	
	4	009 383	2:45	2:45	300	305	310	310	
	5	009 376	3:45	3:45	300	305	310	310	
	6	009 376	4:45	4:45	305	310	310	310	
	7	009 376	6:30	6:30	310	310			
3-11	1	009 376	3:50	3:50	325	325	350	350	
	2	009 376	4:50	4:50	350	350	375	375	
	3	009 376	7:05	7:05	275	275	300	325	
	4	009 376	8:05	8:05	300	325	350	350	
	1	009 368	11:55 PM	11:55	300	300	315	320	
	2	009 368	12:55 AM	12:55	300	300	315	320	
	3	009 368	1:50	1:50	300	305	315	320	
	4	009 368	2:50	2:50	300	305	315	320	
	5	009-357	3:50	3:50	300	305	315	320	
	6	009-357	4:50	4:50	300	305	315	320	
	7	009-357	6:35	6:25	300	305			
	8	"	7:50	7:50	300	"	"	"	
	9	"	8:55	9:00	"	"	"	"	
	10	"	9:50	9:55	"	"	"	"	
	11	"	12:35	12:35	"	"	"	"	
	12	"	2:15	2:15	"	"	"	"	
3-11	1	009 357	3:30	3:30	300	325	325	325	
	2	009 357	4:30	4:30	325	325	350	350	
	3	009 357	5:30	5:30	325	325	350	350	
	4	009 357	6:30	6:30	350	350	350	350	
	5	009 357	7:30	7:30	325	350	350	350	
	6	009 357	8:30	8:30	350	350	350	350	
	7	009 357	9:30	9:30	325	350	350	350	
	8	009 357	10:45	10:45					

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