

S. C.V.
 CG 85 CODE SF-85 PKG.
 → 85 340
 EST. WGT. 4332 LBS.
 STD. HRS. TIME M

D.V.		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	7231
	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			
Prep 3		Record: Time in table, Page 2			
	7	Bake 0.85 hrs (51 min) at 275-320°C			
Trent 4		Record: Temp in table, Page 2			
	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			
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 refined 55 gal metal drums			
	12	Stencil SF-85, Lot, Gross, Tare, & Net Wgts			
	13	Repeat S-9 thru 12 until complete			
		Note: A. Calc: 4332 # SF-85 x .845 = # SF-85 B. Record # SF-85 under Est Wgt.			
		Note: At least twice (2) during each shift climb to prevent landing on cooling tower and roof			
		NOTE: REPAIR VENTILATION DUCTWORK HOURLY TO PREVENT PLUGGAGE & FUMES IN BUILDING			

EQUIPMENT

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EST. WGT.

LBS.

BAKE NO.	STEP 4 TIME IN	STEP 5 TIME IN	STEP 7 TIME START	STEP 8 5 MIN	STEP 8 10 MIN	TEMP °C 20 MIN	TEMP °C 30 MIN	TEMP °C 40 MIN
1	008-315	9:45 PM	11:05					
1	008-315	11:45	11:45	300	300	320	320	320
2	008-315	12:45	12:45	325	325	350	350	350
3	008-315	1:40	1:40	320	320	350	350	350
4	008-315	2:40	2:40	325	325	350	325	375
5	008-315	3:40	3:40	275	275	300	300	320
6	008-315	4:40	4:40	300	325	325	325	350
7	008-315	5:40	5:40	275	300	320	325	350
1	009-358	7:40 AM	7:45 AM	275	275	300	300	310
2	009-358	8:40 AM	8:40 AM	285	295	300	305	310
3	009-358	9:35 AM	9:35 AM	300	300	310	310	
4	009-358	10:30 AM	10:30 AM	300	300	305	310	
5	009-358	11:30 AM	11:30	300	305	310	310	
6	011-392	12:40 PM	12:40 PM	300	305	310	310	
7	011-392	1:40	1:40	300	305	310	310	
8	011-392	2:40	2:40	300	305	310	310	
1		4:00	4:25					
2		5:30	5:55					
3		7:00	7:25					
4		8:30	8:55					
5		10:00	10:25					
1	011-392	11:30	11:30	300	300	320	320	320
2	011-392	12:30	12:30	300	300	320	325	325
3	011-392	1:30	1:30	300	300	320	320	320
4	011-392	2:30	2:30	300	300	320	320	320
5	011-392	3:30	3:30	300	300	320	320	320
1	009-371	8:15 AM	9:15	300				
2	009-371	1:30 PM	2:30	300				
3	009-371	2:30 PM						
1	009-378							
1		4:00	4:25					
2		5:30	5:55					
3		7:00	7:25					
4		8:30	8:55					
5		10:00	10:25					
1	009-382	11:30	11:35	300	300	320		
2	009-374	12:35	12:35	300	300	320		
3	009-374	2:00 AM	2:00 AM	300	300			
1	009-374	1:20 PM	1:30 PM	275	290	300	300	
2	009-374	2:45 PM	2:55 PM	280	29			
1		4:00	4:25					
2		5:30	5:55					
3		7:00	7:25					
4		8:30	8:55					
5		10:00	10:25					
1	009-374	11:35	11:35	300	300	320	320	320
2	009-374	12:35	12:35	300	300	320	320	320
3	009-374	1:35	1:35	300	300	320	320	320
4	009-374	2:35	2:35	300	300	320	320	320
5	009-374	3:35	3:35	300	300	320	320	320
6	009-374	4:35	4:35	300	300	320	320	320
7	009-374	5:35	5:35	300	300	320	320	320
8	009-374	6:35	6:35	300	300	320	320	320