

J. Harden

MAKING INSTRUCTIONS: BATCH UN

C.V.
CG 85 CODE SF-85 PKG.
→ Lot 85336
EST. WGT. 1690 LBS.
STD. HRS. TIME M

D.V.		PROCESSES	APPROVED BY
(D)	SF-85	()	RFW 9-10-6
()		()	TEW 9-18-6
()		()	RBM 9-25-6
()		()	
		RE TYPED BY	
		emw 122176	

6 Drums.

PUNCHED & CHECKED
JAN 15 1961

NON-BLEEDING

COMPONENT	NAME	CRUDE CPC/AF BAKE	USE LBS.	N CODE	ACC LBS.
Misc. 1	A	Make bakes of 5-20# pans each consuming			
	B	Record bake & RM info in attached table		N-8984C	2000
Int 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	
	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			
Rep 3	8	Repeat Step 4			
Int 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: 2000 #N-8984 x .845 = # SF-85			
		B. Record # SF-85 under Est Wgt			
		Note: At least twice during each shift to first landing on cooling tower and red out duct work			
		REAM VENTILATION DUCT WORK HOURLY TO PREVENT PLUGGAGE & FILMS IN BUILDING			

389
MENT

PAGE 2 CG 85 CODE SF-85

EST. WGT.

LBS.

BAKE No.	STEP 4		STEP 5		STEP 7		STEP 8		TEMP - C		
	LOT	OVEN	TIME IN	TIME START	5 MIN	10 MIN	20 MIN	30 MIN	40 MIN		
1	005-226	4:45 PM	4:45 PM	275	280	280	300				
2	005-226	5:55 PM	5:55 PM	275	280	280	300				
3	005-226	6:55 PM	6:55 PM	275	280						
4	005-239	8:05	8:05	280							
1	005-239	7:45	7:45	290	295	300	300				
2	005-239	7:55	7:55	290	295	300	300				
3	005-239	12:00	12:00	285	295	300	300				
1	005-222	2:55 PM	2:55 PM	320	325	320					
2	008-317	4:00 AM	4:00	275	300						
3	008-317	4:45 AM	4:45	275	300	300					
4	008-317	5:40	5:40	275	295	300					
5	008-317	6:25	6:25	290	295						
1	008-334	7:35 AM	7:50 AM	275	285	295	300				
2	008-334	8:50 AM	8:50 AM	275	280	295	300				
3	008-341	9:40 AM	9:40 AM	275	285	295	300				
4	008-341	10:45 AM	10:45 AM	275	280	290	300				
5	008-341	11:45 AM	12:45 AM	275	280	290	300				
6											

DUP050292131

N 31803.01

LBS:

[illegible]

MD-3-A

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE N-8985-C

LOT 85336

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PQ
<u>210</u>	<u>42</u>	<u>168</u>		

STUMP

TOTAL NET WT. 168

PKG. N-CODE

PROD. SPVR. /

DATE

WHSE. OPER.

6

[Signature]

12-29-1

DUP050292133

N 31803.02

MD-3-A

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE N-8785-C

LOT 85336

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PQ
<u>210</u>	<u>42</u>	<u>168</u>		

STUMP

TOTAL NET WT. 168

PKG. N-CODE

PROD. SPVR.

DATE

WHSE. OPER.

[Signature]

12-29-1

6

MD-3-A 12/30/80

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE N-8985-C

LOT 85336

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PQ
<u>325</u>	<u>42</u>	<u>283</u>		
<u>315</u>	<u>42</u>	<u>273</u>		
<u>330</u>	<u>42</u>	<u>288</u>		
<u>315</u>	<u>42</u>	<u>273</u>		
<u>338</u>	<u>42</u>	<u>296</u>		

STUMP

TOTAL NET WT. 1413

PKG. N-CODE

PROD. SPVR.

DATE

WHSE. OPER.

[Signature]

12-29

MD-3-A 1 Apr 12/30/80

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE 11-8985-C

LOT 85336

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PQ
<u>325</u>	<u>42</u>	<u>283</u>		
<u>315</u>	<u>42</u>	<u>273</u>		
<u>330</u>	<u>42</u>	<u>288</u>		
<u>315</u>	<u>42</u>	<u>273</u>		
<u>338</u>	<u>42</u>	<u>296</u>		

STUMP

TOTAL NET WT. 1413

PKG. N-CODE

PROD. SPVR.

DATE

WHSE. OPER.

[Signature]

12-29

CG 85 CODE SF-85 PKG. _____

→ 85336

EST. WGT. _____ LBS.

PROCESSING INSTRUCTIONS: BATCH UNIT

PROCESSES	APPROVED BY
(D) SF-85	RFW 9-10-69
	TEW 9-18-69
	RBM 9-25-69

 reTYPED BY
 emw 122176

MAKING NOTES

REMARKS

NAME: _____

NON-BLEEDING

INSTRUCTIONS

-PRESSING-

RECORD

VAT						PRESSLOAD	1ST	2ND	3RD	4TH	5TH
DATE						STARTED					
TIME						CAKES USED					
RELEASED BY						WATER ON					
PRESS						HRS. WASHED					
NO. OF CAKES						OHMS					
PRESS						HRS. WASHED					
WASH TO						OHMS					
TEST AFTER						HRS. WASHED					
LOAD						OHMS					
						CAKE CONDITION					
						NO. CARS LOADED					
						EXPLAIN LOSSES					

 SAMPLES
 DELIVER TO

 SAMPLED BY
 RELEASED BY

-DRYING-

HOURS	L.V.	H.V.	LUMP: - OK - WET - SALTS - CONTAMINATED
TEMP.	°F	°F	

ADDITIONAL DRYING HOURS REQUIRED

 SAMPLES
 DELIVER TO

 NO. CARS PULLED
 SAMPLED BY
 LUMP WGT.
 RELEASED BY

-GRINDING-

MILL	7 LSP 3/32" RPScreen 1785 RPM	SCREEN	RPM
MAX. TEMP.	2000°F	MAX. TEMP.	°F
Pack in clean 55 Gal Metal Drum Stencil N-8985-C			
Lot, Gross, Tare, Tet Wats and EM-67 on			
top & side of each drum. Deliver card with		EXPLAIN LOSSES	
completed Finished Product Stock Ticket and			
material to R.M. Supv			
R.M. SUPV. SHIP MATERIAL TO NEWPORT		DATE MIXED	
		SAMPLED BY	
		RELEASED BY	

DUP050292137

N 31803.04