

BA 441-442

PHENOLIC MOLDING MATERIAL DEPARTMENT - PRODUCT FORMULATION & CONDENSED MANUFACTURING INSTRUCTIONS

PRODUCT ID.	BMMA-5715 Brown 75	CREW SIZE	MEN	COSTING UNIT	NOTEBOOK	PAGE	4
ISSUE NO.	4	EQUIPMENT HOURS-			DATE	PROJECT ID.	
DATE	1/5/70	CLEAN & SET-UP MAN HOURS-			COST ESTIMATE REQUESTED	RETT REQUESTED	
SUPERSEDES	6/23/69	PROCESSING SIMILAR TO-			CUSTOMER AND YEARLY SALES:		
		LBS/EQUIPMENT HOUR-			Cutler Hammer: 30,000 pounds		
		PACKING HOURS/H POUNDS-					

CHARGE ROLLS					
UNIT	SHEET WT.	CYCLE TIME	STARTING TEMP.		SPRAY
			FRONT	BACK	
A					
B					
C					
R-1					
R-3	30	35	175	50	No

FINISH ROLLS			
UNIT	CYCLE TIME	STARTING TEMP.	
		FRONT	BACK
A			
B			
C			
R-1			
R-3	35	200	80

SQUEEZE ROLLS			
UNIT	STARTING TEMP.		SHEET THK.
	FRONT	BACK	
A			
B			
C			
R-1			
R-3	100	100	0.10

HAMMER MILL SCREENS	
R-1	
R-3	1/2

CUTTER SCREENS			
UNIT	BOTTOM	BOTTOM	TOP
A			
B			
C			

ROTEX	
A	/
B	/
C-PRIM.	/
C-SEC.	/
R-1	/
R-3	10 / 6XX

BLEND FOR	10 MINS.
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CENT. BLEND. STA.	
NOVO: YES ☐	NO ☐

FINAL PACKING	
CONTAINER #	NET WT.
DRUMS ☐	BAGS ☐ GAYLORDS ☐
STORAGE, SHIP & RETEST CODE	

SPECIAL COMMENTS:

DIFFERS FROM PREVIOUS ISSUE:

RM-17-L (17126) replaces RM-134-P.

MOLDING TECHNIQUE:

Compression and Plunger

EFFECT ON MANUFACTURING, YIELDS, LINE RATES, ETC.:

PRODUCT DESCRIPTION AND USE:

Two step impact, phenolic molding material.

SALES CLASS 6211

QUALITY CONTROL TESTS	
POWDER DENSITY 0.44 min.	OTHERS
GRANULATION	Plasticity by mobility.
+ 8 MESH 0.0	Appearance:
+ 12 MESH 0-5	2" cup
+ 16 MESH 5 min.	
+ 60 MESH 10 max.	
IZOD IMPACT ---	
SPEC. GRAVITY 1.38-1.41	
INITIATED BY: <i>G. Smith</i>	
PREPARED BY: <i>R. Marshall</i>	
APPV'D-G.C.: <i>A. C. Stranger</i>	
APPV'D-MFG.: <i>W. J. Morgan</i>	

100011 REV. 10/69

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