MAKING INSTRUCTIONS: BATCH UNIT

S C.V. D.V.

CG 85 CODE SF-85 PKG. _____

→ 85339

EST. WGT. 5561 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	6581
	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: 5561 #N-8984 x .845 = # SF-85 B. Record # SF-85 under Est Wgt			
		Note: ~~At least twice (2) during each shift climb [illegible] landing on cooling tower and rod out duct work~~			
		NOTE: REAM VENTILATION DUCTWORK HOURLY TO PREVENT PLUGGAGE & FUMES IN BUILDING			

PUNCHED & CHECKED

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

	BAKE No.	STEP 4 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	008-336	7.45	7.45	275	320	320	320	320
	2	"	8.40	8.40	350	"	"	"	"
	3	"	9.35	9.35	"	"	"	"	"
	4	"	10.30	10.30	"	"	"	"	"
	5	008-323	11.25	11.25	"	"	"	"	"
	6		12.20	12.20	"	"	"	"	"
	7	008-340	1.15	1.15	"	"	"	"	"
	8	"	2.10	2.10	"	"	"	"	"
	9	"							
2-11	1	008-340	3:30	3:30	275	300	325	340	350
	2	008-340	4:30	4:30	325	325	350	350	350
	3	008-340	5:30	5:30	325	325	350	350	350
	4	008-340	6:30	6:30	325	325	350	350	350
	5	008-340	7:30	7:30	325	325	350	350	350
	6	008-340	8:30	8:30	325	325	350	350	350
	7	008-340	9:30	9:30	300	300	325	350	350
	8	008-340	10:30	10:30	300	300	325	325	325
	1	005-240	11:30	11:30	300	305	310	315	
	2	005-240	12:30	12:30	300	305	310	315	
	3	005-240	1:30	1:30	300	310	315	320	
	4	005-240	2:35	2:35	300	310	315	320	
	5	005-232	3:35	3:35	300	310	315	320	
	6	005-232	4:35	4:35	300	310	315	320	
	7	005-232	5:35	5:35	300	310	315	320	
	8	005-232	6:40	6:40	300				
	1		8.30	8.55					
	2		12.20	12.25					
	3		1.30	1.50					
	4		3.45	3.05					
3-11	1	005-232	4:05	4:05	300	300	300	320	325
	2	005-232	5:05	5:05	300	300	320	325	325
	3	005-232	6:05	6:05	300	305	325	350	350
	4	005-232	7:05	7:05	300	300	300	300	300
	5	005-232	8:05	8:05	300	300	300	300	300
	6	005-232	9:05	9:05	300	300	300	320	325
	7	005-232	10:05	10:05	300	300	300	320	320
	8	005-232	11:05	11:05	290	300	300	300	300
	1	005-233	12:00 AM	12:00 AM	300	305	305	310	11
	2	006-257	1:00	1:00	300	305	305	310	"
	3	006-257	2:00	2:00	300	305	305	310	
	4	006-257	3:00	3:00	300	305	305	310	
	5	006-257	4:00	3:10	300	305	305	310	
	6	006-252	6:20	6:25	300	300			
	7	006-252	7.45	7.45	"	"	"	"	"
	8	"	8.55	8.55	"	"	"	"	"
	9	008-310	12.00	12.00	"	"	"	"	"
	10	"	1.00	1.00	"	"	"	"	"
	11	"	2.00	1.50	"	"	"	"	"
	12	"	2.58	2.58	"	"	"	"	"
	1	"	3.50	4.10	280	300	300	320	
	2	008-311	4.50	"	300	300	320	320	
	3	008-311	5.40	5.50	300	300	"	"	
	4	" 311	6.45	6.50	300	300			
	5								

DUP050098427

EQUIPMENT PAGE 2 OF 85 CODE: SF-85 EST. WGT: LBS.

BAKE No.	STEP 4 N-86-84-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
5	008-218	7:50	7:50	300	300	300		
6	008-218	8:45	8:45	300	300	300		
7	008-318	9:40	9:40	300	300	300		
8	008-345	10:45	10:50	300				
1	008-345	11:45 PM	11:45	300	300	305	305	
2	008-345	1:45 AM	1:45	300	300	305	305	
3	008-310							
1	008-310	8:35	8:40	275	285	295	300	
2	008-310	11:05	11:05	275	285	295	300	
3	008-310	11:55	11:55	290	295	300	305	
4	008-314	1:30	1:30	290	295	300	305	
5	008-314	2:25	2:25	290	300			

DUP050098428

MD-3-A

PACKAGE TICKET (DRY AND PASTE ONLY)

CODE N-8985-C LOT 85339

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PO
	1	281		
	1	267		
	1	277	20	
	1	271		
	1	276		
	STUMP	1372	5379 #	

TOTAL NET WT. _____ PKG. N–CODE _____

PROD. SPVR.	DATE	WHSE. OPER.
KP	1/28/81	

DUP050098429

MD-3-A

PACKAGE TICKET (DRY AND PASTE ONLY)

CODE N-8985-C LOT 85339

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PQ
	1	301		
	1	282		
	1	283		
	1	292		
	1	322		
	STUMP	1480		

TOTAL NET WT. _____ PKG. N-CODE _____

PROD. SPVR.	DATE	WHSE. OPER.
KT	1 12 81	

DUP050098430

MD-3-A

PACKAGE TICKET (DRY AND PASTE ONLY)

CODE N-8985-C LOT 85339

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PO
	1	267		
	1	229		
	1	274		
	1	283		
	1	248		
	STUMP	1301		

TOTAL NET WT. _____ PKG. N–CODE _____

PROD. SPVR.	DATE	WHSE. OPER.
RP	1/24/81	

DUP050098431

MD-3-A

PACKAGE TICKET (DRY AND PASTE ONLY)

CODE N- 8985-C LOT 85339

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PQ
	1	292		
	1	269		
	1	282		
	1	148		
	1	235		
	STUMP 1	226		

TOTAL NET WT. _____ PKG. N–CODE _____

PROD. SPVR. DATE WHSE. OPER.

RP 1/28/81 _____

DUP050098432

CG 85 CODE SF-85 PKG.

→ [redacted] 85339

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

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

SAMPLES
DELIVER TO

SAMPLED BY RELEASED BY

-DRYING-

HOURS	L.V.	H.V.
TEMP.	°F	°F

LUMP: - OK - WET - SALTS - CONTAMINATE

ADDITIONAL DRYING HOURS REQUIRED

SAMPLES
DELIVER TO

NO. CARS PULLED LUMP WGT.
SAMPLED BY RELEASED BY

-GRINDING-

MILL 7 LSP 3/32"RP SCREEN 1785 RPM
MAX. TEMP. 200°F

Pack in clean 55 Gal Metal Drum Stencil N-8985-C Lot, Gross, Tare, Tet Wgts and EM-67 on top & side of each drum. Deliver card with completed Finished Product Stock Ticket and material to R.M. Supv
R.M. SUPV --> SHIP MATERIAL TO NEWPORT

SCREEN RPM
MAX. TEMP. °F

EXPLAIN LOSSES

DATE MIXED

SAMPLED BY RELEASED BY

DUP050098433