(1)

BA 441-442

PHENOLIC MOLDING MATERIAL DEPARTMENT - PRODUCT FORMULATION & CONDENSED MANUFACTURING INSTRUCTIONS

PRODUCT NO.	BMMC 5020 BK25 DC	CREW SIZE- MEN	COSTING UNIT
ISSUE NO.	[illegible]	EQUIPMENT HOURS-	
DATE	1/10/68	CLEAN & SET-UP MAN HOURS-	
SUPERSEDES		PROCESSING SIMILAR TO-	
		LBS/EQUIPMENT HOUR-	
		PACKING HOURS/M POUNDS-	

NOTEBOOK	PAGE
DATE	PROJECT NO.
COST ESTIMATE: REQUESTED	X NOT REQUESTED

CUSTOMER AND YEARLY SALES:
VARIOUS 2,964,100#

DIFFERS FROM PREVIOUS ISSUE:
Change Grade 12 From 45% To 46% Resin Content.
Change Grade 15 From 48% To 49% Resin Content.
Change Grade 18 From 51% To 52% Resin Content.

MOLDING TECHNIQUE:
Compression and Plunger

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

PRODUCT DESCRIPTION AND USE:
General Purpose

SALES CLASS

QUALITY CONTROL TESTS

POWDER DENSITY	0.60 MIN.	OTHERS: Plasticity, R.P. Flow Grades 15 & 18, MOB Grs. 6-9 & 12, Appearance Grades 6-9, 4" Disc. Grades 12 & UP, 2" Cup
GRANULATION		
+ 8 MESH	0 %	
+ 12 MESH	2-7 %	
+ 16 MESH	INFO %	
+ 60 MESH	2 MAX %	
IZOD IMPACT	—	
SPEC. GRAVITY	1.36-1.39	

INITIATED BY: [illegible]
PREPARED BY: [illegible]
APPV'D-Q.C.: [illegible]
APPV'D-MFG.: [illegible]

HAMMER MILL	
YES	X ON C
NO	X ON A

HAMMER MILL SCREENS	
R-1	
R-3	

CUTTER SCREENS			
UNIT	BOTTOM	BOTTOM	TOP
A	1/2	1/2	3/8
B			
C	1/2	3/8	3/8

CHARGE ROLLS					
UNIT	SHEET WT.	CYCLE TIME	STARTING TEMP. FRONT	STARTING TEMP. BACK	SPRAY
A	36	35	225	320	No
B					
C	72	35	190	80	No
R-1					
R-3					

ROTEX	
A	10-11 / OXX
B	/
C-PRIM.	10 / OXX
C-SEC.	11 / OXX
R-1	/
R-3	/

USE DIVERTING VALVE TO CONTROL AMOUNT OF COARSE.

FINISH ROLLS			
UNIT	CYCLE TIME	STARTING TEMP. FRONT	STARTING TEMP. BACK
A	35	235	300
B			
C	35	235	300
R-1			
R-3			

BLEND FOR 10 MINS.

CENT. BLEND. STA.
NOVO: YES ☒ NO ☐

SQUEEZE ROLLS			
UNIT	STARTING TEMP. FRONT	STARTING TEMP. BACK	SHEET THK.
A	WATER	300	0.110
B			
C	WATER	300	0.110
R-1			
R-3			

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

SPECIAL COMMENTS: RFCR

UCASB00951151