Date: **19-Jun-2019** Line No.: 21/22 Material: PP-T40 A5234T B12378L Manufacturing Setup Sheet: 739 - 3

		SET POINT HEAT ZONE °C	BARREL SECTION
RAW MATERIAL	POLYPRO	1. 180+-10	5. AD2014
ASH LEVEL	40+-2 (38 - 42)	2. 220+-10	6. CLOSED
MOISTURE CONTENT	.05	3. 220+-10	7. CLOSED
MELT TEMPERATURE C	180-235	4. 230+-10	8. CLOSED
SCREW RPM	800+-50 (750 - 850)	5. 235+-10	9. CLOSED
TORQUE	70+-5 (65 - 75)	6. 235+-10	10. VACUUM 27 IN.
VACUUM	27+-3 (24 - 30)	7. 235+-10	11. VACUUM 27 IN.
PELLET DIE NO.	21	8. 235+-10	
WATER TEMPERATURE	40-50C	9. 235+-10	SET POINT
CLASSIFIER SCREEN	UPSTR.10MESH DWNSTR.1/4	10. 235+-10	DRYERS °F
ADDITIVE MIXTURES	AD1007, AD2241A,	11. 235+-10	
	AD2511A, AD2014	12. 230+-10 DI	

	LBS PER HR	MIXTURES	%	+/- 4%	LBS PER MINUTE	BARREL SECTION	FEEDER POSITION
K-TRON #1 FEEDER	808	AD1007	57.70	12.92 - 14.00	13.463	1	4
K-TRON #2 FEEDER	18	AD2241A	1.30	132 - 144 g	138 g	1	2
ACRISON FEEDER	14	AD2511A	1.00	102 - 110 g	106 g	1	2
ACRISON FEEDER	560	AD2014	40.00	8.96 - 9.70	9.333	5	1
ACRISON FEEDER							
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ACRISON FEEDER							
ACRISON FEEDER							
ACRISON FEEDER							
ACRISON FEEDER							
TOTALS	1400		100.00		23.332		

ITEM	
AD1007	% in Item
PP MFR10 IPP HI MOD M1200HS 6012 HJ8012	57.700
Totals	57.700
AD2241A	% in Item
PP 20-1.3%	1.300
Totals	1.300
AD2511A	% in Item
PP0452 (SIMILAR TO BLACK MB 2019 PRET)	1.000
Totals	1.000
AD2014	% in Item
CIMBAR CIMTALC 3	40.000
Totals	40.000

COMMENTS: ADDITIVE FEEDERS CAN BE ADJUSTED TO COMPENSATE FOR VARIATION IN FEED RATE OR ASH IN RESIN.

SIGNATURE: