			E	500 U	. Ba	,5		
с. . р. т.	<b>T</b> O <b>B</b> OOD <b>B</b> O					7		· · · · · · · · · · · · · · · · · · ·
PART	NO: $790050$	10 (7900480)	<u>µ 1013947</u>			Appi	oval Signature:	
(chreie	(011e) <u>/90001</u>	10 /900020	<u>u</u>				Malben Nh	- 2/19/2010
		. <i>•</i>						//
Form R	Levision: V					000000000		·
			]	FIRST PIE	CE INSPI	CTION		·
Manu	facturing Cell	Description	:		Cell Design	ator:		Date: 4-27-10
NA-25	Dual Stage and	I ADI Pellets			CGO(H	Bay 3) or GI	(Bay 5)	
NA-10:	3B Tab Pellets				(0	Circle the	Cell)	Shift: $1^{st}$ $2^{nd}$ $3^{rd}$
PROC	TESS SETTIP	CRITERI	Δ	Start Wt ·	4195			INITIALS
1.	Verify that the	Scrubber Wat	er Level is ac	centable	11.10			
2.	Press Bay Scru	bber Inlet pres	Sure: 3	.D	(inches of	water)*		2. 000
3.	Verify the gran	ule part numb	er is correct f	or the pellets	to be pressed	according to	o the following	3. Cm
	list, and check	configuration/	dimensional l	imits.				
Check		Formul D/N	Pellet	Pellet	Pellet	Pellet	Crush.	
one	Fellet P/N		Height ±0.1	Weight	Diameter	Density	Strength	
	79005000	79005100	2.5mm	103-113mg	5mm	2.12-2.18	5kp min	
	79005000	79005100	2.2mm	88-98mg	5mm	2.12-2.18	5kp min	
	79006110	79006100	2.4mm	159-169mg	6.35mm	2.12-2.18	15kp min	
	79006200	79006100	2.5mm	103-113mg	5mm	2.12-2.18	5kp min	
	79004800	79004600	2.4mm	159-169mg	6.35mm	2.12-2.18	5kp min	
	1013947	79006100	2.95mm	195-221 mg	6.35mm	2.12-2.18	15kp min	0
	1013947	79006100	3.1mm	202-221 mg	6.35mm	2.12-2.18	15kp min	4. <u>Crr</u>
L	1013947	79006100	3.2mm	208-228 mg	6.35mm	2.12-2.18	15kp min	S. <u>Crn</u>
4.	Record Granule	e lot number.	Lot # Cor	VAD3H.	<u>ð</u> .			
5.	Remove rejecte	d material from	m last press r	III.	12.	1		8
0. 7	Verify granule	moisture is no	t greater than	0.3%. Moistu		<u> </u>		9 Cm
7. 8	Verify deduster	s have bolts n	uts screws a	nd washers in	nlace and se	cure		
9.	Verify that rece	iving final pro	duct containe	ers are placed	on the rolling	cart and un	derneath the	10. Cm
51	deduster on both	h sides.		is are placed				
10.	Verify that all the	he socks and p	owder chutes	are aligned fo	or a proper pe	ellet and gram	nule flow. ( <i>for</i>	
	example: Sock	and Chute con	nected from t	he press to the	e deduster, th	e sock that i	s on the	
	discharge end of	f the deduster	to the receivi	ng container, t	the sock that	connects the	press hopper to	11. <u>Cm</u>
	the chute)							12. <u>MA</u>
11.	Verify that bin-	docking station	n on the secor	nd level is clea	an and free of	debris.	1>	14
12. 12	Kemove the doc	King Station C	over and verif	ty that the coll	ar is inflated	(Ior Bay 5	ошу)	15 m
15. 14	Remove the door	king station of	ooking statio over (for Boy	$\frac{1}{2} \frac{1}{2} \frac{1}$	uciaill.			
15.	Inspect conducti	ive cover for d	leterioration of	or holes. If four	nd please not	ify your cel	l lead or	16. <u>Con</u>
/	supervisor.				rieuse no			
16.	Remove the met	tal lid bin seal	from the bin	that is ready to	o be process a	and replace	it with the	17. <u>C</u>
	conductive cove	er.		•	-	-		18. <u>(m</u> )
17.	Verify that oiler	is on/open be	fore starting o	of blend and th	hat the correct	t amount is t	lowing.	19
18.	Verify that VCR	L's are recordin	ig before star	ting process				20. $(7)$
19.	Record Press Sta	art lime:	301	IVI .	- <b>- -</b>			22
20. l	Set up press for	required pellet	aimension p	er operator ins	suructions.			
21. 2	Anter press has r Verify Relative	Humidity (RH	) in press have	, oblam ten pe	met samples.	Record the	reading	23.00
<i>. ک. ک.</i> ,			, m press bay	13 001000011 40	ло анц 0070.	TCOOLD THE	Joaung	24. 60
23. I	Record Press sto	p time: 7.	Otha					25.
24.	Verify that press	is vacuumed	after the run.	01-1				
25. 1	Rate = Start wt (	kg)/ Press Tin	ne (hrs) =	31.54				
	NOTE: If rat	e in Bay 5 (G	T) is $> 22.73$	kg/hr notify	supervisor ir	nmediately		•
	If rat	e in Bay 3 (G	<b>O) is &gt; 45 kg</b>	/hr notify sup	ervisor imn	ediately	۰. ۲	
	Total	Press Time (l	hrs) = minute	es / 60 / 2	33			

\* The Press Bay Scrubbers' pressure drop should be between 4.5 and 8.5 inches of water.

FIRST PIECE INSPECTION         Manufacturing Cell Description:         NA-251 Dual Stage and ADI Pellets       Cell Designator:         Cell Designator:         OCMEW 30 or GT (Bay 5)         NA-371 Pellet         PROCESS SETUP CRITERIA         Start Wt: 24/1 25 50         INITIALS         1.       MrC         2.       Press Bay Scrubber Inlet pressure:       1         2.       Press Bay Scrubber Inlet pressure:       1         3.       Verify that the Senubber Water Level is acceptable.       (inches of water)*         3.       Verify the granule part number is correct for the pellets to be pressed according to the following is first, and check configuration/dimensional limits.       1         Check Pollet PN Granual PN Height 40.1       Weight Diameter Density Strength       2         1.       Process 22 22 and 6.35mm 2.122.218       5kp min         79006400       2.4mm 159-166mg 6.35mm 2.122.218       5kp min         79004400       2.9006100       2.4mm 169-221 mg 6.35mm 2.122.218       5kp min         1.       1013947       79006100       3.4mm 202-221 mg 6.35mm 2.122.218       5kp min         79004400       79006100       3.4mm 202-221 mg 6.35mm 2.122.218		· · ·		-				Mollew Nh	- 7/19/2010
FIRST PIECE INSPECTIONManufacturing Cell Desciption: MA-311 Dual Stage and ADI PelletsCell Desciption: (Circle the Cell)Date: $\{ \baselinesistical content of the cell of the$	Form Re	evision: V						·	·
Manufacturing Cell Description:       Cell Description:       Could synthmatrix       Date: $\frac{8}{5} - \frac{1}{7} - \frac{7}{6}$ NA-251 Dual Strap EdBex.       Could synthmatrix       Could synthmatrix       Shift: $\frac{6}{6} - \frac{2^{nd}}{3}$ NA-371 Pellet       Current Strap Strubber Hart Eversite:       Could synthmatrix       Shift: $\frac{6}{6} - \frac{2^{nd}}{3}$ PROCESS SETUP CRITERIA       Start Wt.:       Current Strup Cription:       INTITALS         1. Verify that the Scrubber Water Level is acceptable.       Inter Strup Cription:       Inter Strup Cription:       Inter Strup Cription:         2. Press Bay Scrubber Interpretering       0       (inches of water)*       Inter Strup Cription:       Inter Strup Cription:         3. Verify the granule part number is correct for the pellet interpretering Strup Cription:       Pellet interpretering Strup Cription:       Interpretering Strup Cription:       Interpretering Strup Cription:         79005000       79005100       2.5mm       103-113mg       Smm       2.12-2.18       Skp min         1013947       79006100       3.2mm       20.3221 mg       6.35mm       2.12-2.18       Skp min         1013947       79006100       3.2mm       20.3221 mg       6.35mm       2.12-2.18       Skp min         1013947       79006100       3.2mm       20.221 mg       6.35mm       2.12-				]	FIRST PIE	CE INSPI	ECTION		
Sector Data Single and ADJ Pellets       City Delty 3) or GP (Eay 5)         NA-133B Tab Pellets       (Greate the Cell)       Shift: $\mathcal{O}$ 2 <sup>nd</sup> 3 <sup>rd</sup> NA-317 Pellet       PROCESS SETUP CRITERIA       Start Wt: $\mathcal{U}$ $\mathcal{O}$ $\mathcal{O}$ INITIALS         1. Verify that the Scrubber Mater Level is acceptable.       (inches of water)*       INITIALS         2. Press Bay Scrubber Interpressor: $\mathcal{O}$ (inches of water)*       1. $\mathcal{M} \subset$ 3. Werify the granule part number is correct for the pellets to be pressed according to the following list, and check configuration/dimensional limits.       (inches of water)*       1. $\mathcal{M} \subset$ Check Pellet PN Granuel PN Height 20.1       Pellet Pellet Planting Simm 2.122.218 [5kp min]       3. $\mathcal{M} \subset$ 2. $\mathcal{M} \subset$ 79005000       79006100       2.5mm 103-113mg Simm 2.122.218 [5kp min]       7.222.218 [5kp min]       3. $\mathcal{M} \subset$ 79004200       79006100       2.4mm 169-168mg (5.35mm 2.122.218 [5kp min]       5. $\mathcal{M} \subset$ 7. $\mathcal{M} \subset$ 1013947       79006100       3.1mm 202-221 mg (5.35mm 2.122.218 [5kp min]       5. $\mathcal{M} \subset$ 7. $\mathcal{M} \subset$ Nerify dust the socks and powder chutes are aligned for a proper pollet and granule flow. (for example: Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to not the okcing station is fore of granet.       1. $\mathcal{M} \subset$ Nerify that the sock and powde	Manuf	acturing Ce	ll Description	:	0	Cell Design	ator:		Date: 8 - // - 10
Sinf: $d^2 2^a 3^a$ Shif: $d^2 2^a 3^a$ PROCESS SETUP CRITERIA       Start W:: $d^a 3^a$ PROCESS SETUP CRITERIA       Start W:: $d^a 3^a$ PROCESS SETUP CRITERIA       Start W:: $d^a 3^a$ I. Verify that the Scrubber Water Level is acceptable.       Introduction of the peasure is correct for the pellets to be pressed according to the following list, and check configuration/dimensional limits.       Introduction of the peak of the	NA-251	Dual Stage an	nd ADI Pellets			GOU	3ay 3) or GI	(Bay 5)	
PROCESS SETUP CRITERIA       Start Wt: $\mathcal{U}$ $\mathcal{D}$ INITIALS         1.       Verify that the Scrubber Water Level is acceptable.       (inches of water)*       1. $\mathcal{M}$ 2.       Press Bay Scrubber Intel pressure:       3. $\mathcal{M}$ 2. $\mathcal{M}$ 3.       Verify the granule part number is correct for the pellets to be pressed according to the following list, and check configuration/dimensional limits.       1. $\mathcal{M}$ Check       Pellet PN       Granual PN       Pellet 1       Pellet       Dellet       Dellet       Strength         780005000       79005100       2.smm       103-113mg       Smm       2.12-2.18       Skp min         79006200       79006100       2.smm       103-113mg       Smm       2.12-2.18       Skp min         79004000       79006100       2.smm       103-143mg       Smm       2.12-2.18       Skp min         1013947       79006100       2.smm       103-143mg       Sismm       2.12-2.18       Skp min         1       1013947       79006100       2.smm       103-143mg       Sismm       2.12-2.18       Skp min         1       MC       Sism       2.12-2.18       Iskp min       1.12-2.16       MC       MC <td>NA-103</td> <td>Pellet</td> <td>2</td> <td></td> <td></td> <td>(0</td> <td>Circle the</td> <td>Cell)</td> <td>Shift: <math>(1^{st} 2^{nd} 3^{rd})</math></td>	NA-103	Pellet	2			(0	Circle the	Cell)	Shift: $(1^{st} 2^{nd} 3^{rd})$
I.       Verify that the Scrubber Water Level is acceptable.       (inches of water)*       (inches of water)*         2.       Press Bay Scrubber Inlet pressure:       (inches of water)*       (inches of water)*         2.       Press Bay Scrubber Inlet person:       (inches of water)*       (inches of water)*         3.       ////////////////////////////////////	PROC	ESS SETU	P CRITERI	A	Start Wt.:	41.00	\$50		INITIALS
<ol> <li>Press Bay Sembber Inlet pressure:</li></ol>	l <b>.</b>	Verify that th	e Scrubber Wat	er Level is ac	ceptable.				1. MC
<ul> <li>3. We fight the granule part number is correct for the pellets to be pressed according to the following list, and check configuration/dimensional limits.</li> <li>3. We fight and check configuration/dimensional limits.</li> <li>Check Pellet P/N Granul P/N Pollet Height 20.1 Weight Diameter Density Strength 79005100 2.5mm 103-113mg 5mm 2.12-2.18 5kp min 79006110 79006100 2.5mm 103-113mg 5mm 2.12-2.18 5kp min 79006100 79006100 2.5mm 103-113mg 5mm 2.12-2.18 5kp min 79006100 79006100 2.5mm 103-113mg 5mm 2.12-2.18 5kp min 1013947 79006100 3.5mm 103-21 mg 6.35mm 2.12-2.18 15kp min 1013947 79006100 3.2mm 202-221 mg 6.35mm 2.12-2.18 15kp min 10.2mm 200-20 mm 200-20 m</li></ul>	2.	Press Bay Sci	rubber Inlet pres	ssure:	. 0	(inches of	water)*		2. <u>MC</u>
list, and check configuration/dimensional limits.OnePellet P/NGranul P/NPelletPelletPelletDiameterDensityStrengthV79005000790051002.5mm103-113mg5mm2.12-2.185kp min179006101790061002.4mm159-169mg6.35mm2.12-2.185kp min179006200790061002.4mm159-169mg6.35mm2.12-2.185kp min11013947790061002.4mm195-221 mg6.35mm2.12-2.1815kp min11013947790061003.1mm202-221 mg6.35mm2.12-2.1815kp min11013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp min11013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp min11013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp min1Nericy granule moisture is not greater than 0.3%. Moisture:5Mic51Werify that receiving orbits, nus, screws, and washers in place and secure.9Mic1Werify that bin-docking station over cociving orbits, excews, and washers in place and free of debris.102Remove the docking station over cociving continer, the sock that connects the press hopper to the cocking station over cociving continer, the sock that is only111Mic11Mic2Remove the docking station over cociving before starting process16 <t< td=""><td>8.</td><td>Verify the gra</td><td>inule part numb</td><td>er is correct f</td><td>or the pellets t</td><td>o be pressed</td><td>according t</td><td>o the following</td><td>3</td></t<>	8.	Verify the gra	inule part numb	er is correct f	or the pellets t	o be pressed	according t	o the following	3
Check Pellet PPellet Pellet Pellet Pellet Crush Strength79005000790051002.5mm103-113mg5mm2.12-2.185kp min79005000790061002.4mm185-169mg6.35mm2.12-2.185kp min79006200790061002.4mm155-169mg6.35mm2.12-2.185kp min79006400790061002.5mm103-113mg5mm2.12-2.185kp min1013947790061002.95mm195-221 mg6.35mm2.12-2.1815kp min1013947790061003.1mm202-221 mg6.35mm2.12-2.1815kp min1013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp min.1013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp min.1013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp minVerify tooling to be used is present in all stationsVerify that all the socks and powder chutes are aligned for a proper pellet and granule flow. (for example: Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to the receiving container, the sock that is on berg1Verify that blin-docking station or heles. If found please notify your cell lead or supervisor.1Record Press Stort Time, Cro Bay 3 only)<	01	list, and check	configuration/	dimensional I	imits.				
OtherTrengin 2.0Weight Diamed DurisityDuring Strength79005000790051002.2mm1313mgSimm2.12-2.18Skp min79005000790061002.4mm159-169mg6.35mm2.12-2.18Skp min79006000790061002.4mm159-169mg6.35mm2.12-2.18Skp min1013947790061002.95mm195-221 mg6.35mm2.12-2.18Iskp min1013947790061002.95mm195-221 mg6.35mm2.12-2.18Iskp min1013947790061003.1mm202-221 mg6.35mm2.12-2.18Iskp min11013947790061003.2mm208-228 mg6.35mm2.12-2.18Iskp min.Record Granule lot number. Lot # $GPU/16/TAn006$ Verify tooling to be used is present in all stationsVerify that receiving final product containers are placed on the rolling cart and underneath the deduster on both sidesVerify that bin-docking station on the second level is clean and free of debrisRemove the docking station cover and verify that the cortex starting of blend and that the correct amount is flowing </td <td>Спеск</td> <td>Pellet P/N</td> <td>Granual P/N</td> <td>Pellet</td> <td>Pellet</td> <td>Pellet</td> <td>Pellet</td> <td>Crush</td> <td></td>	Спеск	Pellet P/N	Granual P/N	Pellet	Pellet	Pellet	Pellet	Crush	
$\mathcal{V}$ revolution2.12-1.18 [Skp min]790061002.2mm88-98mg5mm2.12-2.18 [Skp min]79006100790061002.4mm159-169mg6.35mm2.12-2.18 [Skp min]79006100790061002.95mm195-221 mg6.35mm2.12-2.18 [Skp min]1013947790061003.1mm202-221 mg6.35mm2.12-2.18 [Skp min]1013947790061003.1mm202-221 mg6.35mm2.12-2.18 [Skp min]1013947790061003.1mm202-221 mg6.35mm2.12-2.18 [Skp min].Record Granule lot number. Lot # <b>C V</b> 16 <b>T</b> Ap006. <b>MC</b> .Remove rejected material from last press run. <b>S MC</b> .Verify tranule moisture is not greater than 0.3%. Moisture: <b>D MS M</b> .Verify that let esols: and powder chutes are aligned for a proper pellet and granule flow. (for <b>S M</b> example:Sock and Chute connected from the press to the deduster, the sock that is on the <b>B M</b> discharge end of the deduster to the receiving container, the sock that is on the <b>B M</b> discharge end of the deduster to the receiving container, the sock that connects the press hopper to <b>B M</b> Memove the docking station order and verify that the collar is inflated. (for Bay 5 only) <b>B M</b> Verify that be serce on the docking stating or blend and that the correct amount is flowing. <b>B M</b> Werify that ider is on/open before starting of blend and that the correct amount is flowing. <b>B M</b> Werify that UCR's are recording before starting of blend and 60		70005000	70005400			Frame			
$\begin{array}{c c c c c c c c c c c c c c c c c c c $	V	70005000	79005100	2.5mm	103-113mg	iomm Emm	2.12-2.18	5kp min	
120001101200011002.4mm139-105mm2.12-2.185kp min179004800790048002.95mm103-113mg5mm2.12-2.185kp min1013947790061002.95mm195-221 mg6.35mm2.12-2.1815kp min1013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp min1013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp min1013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp min1013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp min1013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp min1013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp min111Wcrify granule moisture is not greater than 0.3%. Moisture:70 Mc8. $\mu_{12}$ 111Wcrify that all the socks and powder chutes are aligned for a proper pellet and granule flow. (for8. $\mu_{12}$ 111Wcrify that all the socks and powder chutes are aligned for a proper pellet and granule flow. (for112Wrify that all the socks and powder chutes are aligned for a proper pellet and granule flow. (for113Wcrify that ble docking station on the second level is clean and free of debris.114Mc115 $\mu_{12}$ 115 $\mu_{12}$ 116MC117Mc118Mc119Mc119Mc120Mc </td <td></td> <td>70006140</td> <td>70006400</td> <td>2.2mm</td> <td>00-98mg</td> <td>0111M</td> <td>2.12-2.18</td> <td>15kp min</td> <td></td>		70006140	70006400	2.2mm	00-98mg	0111M	2.12-2.18	15kp min	
Production		70000110	70006400	2.4mm	103-109mg	5mm	2.12-2.18	5kp min	
1020 roots1020 roots		7900200	79000100	2.011111 2.4mm	159_160mg	6 35mm	2.12-2.10	5kn min	
10103011013347100061003.1mm202-221 mg6.35mm2.12-2.1815kp min1013947790061003.1mm202-221 mg6.35mm2.12-2.1815kp min1013947790061003.2mm208-228 mg6.35mm2.12-2.1815kp minRemove rejected material from last press run.Verify granule moisture is not greater than 0.3%. Moisture: $5 \ MC$ 6. $MC$ Verify dedusters have bolts, nuck, screws, and washers in place and secure. $9 \ MC$ $MC$ Verify that receiving final product containers are placed on the rolling cart and underneath the deduster on both sides. $9 \ MC$ .Verify that all the socks and powder chutes are aligned for a proper pellet and granule flow. (for example: Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to the receiving container, the sock that connects the press hopper to the chute)10. $MC$ .Verify that bin-docking station cover and verify that the collar is inflated. (for Bay 5 only)11. $MC$ .Remove the docking station cover. (for Bay 3 only)15. $k$ .Remove the metal lid bin seal from the bin that is ready to be process and replace it with the conductive cover.16. $MC$ .Verify that OLC's are recording before starting process.Record Press Start Time: $2 \ MC$ .Ket of Press Start time. $2 \ MC$ .NOTE:If runs bay 5 (GT) is > 22.73 kg/hr notify supervisor immediately.		1013947	79004000	2.4mm	105-221 mg	6.35mm	2.12-2.10	15kp min	
1013947790061003.7mm208-228 mg6.38mm2.12-2.1815kp min1013947790061003.7mm208-228 mg6.38mm2.12-2.1815kp minRemove rejected material from last press run.Werify granule moisture is not greater than 0.3%. Moisture:5. $MC$ 6. $MC$ Verify ubar receiving final product containers are placed on the rolling cart and underneath the deduster on both sides.9. $MLC$ 9. $MLC$ Verify that receiving final product containers are placed on the rolling cart and underneath the deduster on both sides.10. $MC$ Verify that receiving final product containers are placed on the rolling cart and underneath the deduster on both sides.10. $MC$ Verify that receiving final product containers are placed on the rolling cart and underneath the deduster on both sides.10. $MC$ Verify that neceving final product containers are placed on the rolling cart and underneath the deduster on both sides.10. $MC$ Verify that the socks and powder chutes are aligned for a proper pellet and granule flow. (for example: Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to the receiving contains in free of debris.11. $MC$ Remove the docking station cover and verify that the collar is inflated. (for Bay 5 only)13. $MC$ Verify that the screen on the docking station is free of generant.16. $MC$ Remove the docking station cover and verify that the correct amount is flowing.16. $MC$ Verify that view ervire pollet dimension per operator instructions.16. $MC$ Remove the docking statin on per operator instructions.22. $Lc$		1013947	79006100	3.1mm	202-221 mg	6 35mm	2.12-2.10	15kp min	1 mc
Record Granule lot number. Lot # GP U 18 74.000Price 2:10 [10:0] [10:0]Remove rejected material from last press run.Verify torling to be used is pressent in all stations.Noisture: $5 \cdot 4$ .Verify tooling to be used is pressent in all stations.Verify tooling to be used is pressent in all stations.Noisture: $5 \cdot 4$ .Verify tooling to be used is pressent in all stations.Verify that precedent and underneath the deduster on both sides.Noisture: $5 \cdot 4$ .Nore the deduster on both sides.Verify that all the socks and powder chutes are aligned for a proper pellet and granule flow. (for example: Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to the receiving container, the sock that connects the press hopper to the chute)Note: 10. $MC$ Verify that bin-docking station on the second level is clean and free of debris.Note: 11. $MC$ Remove the docking station cover and verify that the collar is inflated. (for Bay 5 only)Note: 11. $MC$ Noterify that the screen on the docking station is free of generant.MCRemove the docking station cover. (for Bay 3 only)Is $MC$ Inspect conductive cover for deterioration or holes. If found please notify your cell lead or supervisor.MCRecord Press Start Time: $5 \cdot 4$ .Set up press for required polite dimension per operator instructions.After press has reached steady granule flow, obtain ten pellet samples.MCVerify Relative Humidity (RH) in press bay is between 40% and 60%. Record the readingMCMatter Start wt (kg) / Press Time (hrs) = $5 \cdot 4$ .MCNOTE: If rate in Bay 5 (CT) is > 22.73 kg/hr notify supervisor immediately		1013947	79006100	3.2mm	202-221 mg	6.35mm	2.12-2.10	15kp min	5. MC
<ul> <li>Remove rejected material from last press run.</li> <li>Verify granule moisture is not greater than 0.3%. Moisture: <u>58.2</u></li> <li>Verify tooling to be used is present in all stations.</li> <li>Verify dedusters have bolts, nuts, screws, and washers in place and secure.</li> <li>Verify that receiving final product containers are placed on the rolling cart and underneath the deduster on both sides.</li> <li>Verify that all the socks and powder chutes are aligned for a proper pellet and granule flow. (for example: Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to the receiving container, the sock that connects the press hopper to the chute)</li> <li>Verify that bin-docking station on the second level is clean and free of debris.</li> <li>Remove the docking station cover and verify that the collar is inflated. (for Bay 5 only)</li> <li>Verify that bin-docking station cover and verify that the collar is inflated. (for Bay 5 only)</li> <li>Verify that olice is on/open before starting of blend and that the correct amount is flowing.</li> <li>Verify that oiler is on/open before starting process</li> <li>Record Press Start Time: <u>1.9.9</u></li> <li>Record Press stop time: <u>0.99</u></li> <li>Record Press stop time: <u>0.99</u></li> <li>Rate = Start wt (kg)/ Press Time (hrs) = <u>1.95</u></li> <li>NOTE: If rate in Bay 5 (GT) is &gt; 22.73 kg/hr notify supervisor immediately.</li> </ul>		Record Gram	le lot number	ot#GP	1167Ann	6	2.12 2.10		6. MC
<ul> <li>Verify granule moisture is not greater than 0.3%. Moisture: <u>58.4</u></li> <li>Verify granule moisture is not greater than 0.3%. Moisture: <u>58.4</u></li> <li>Verify tooling to be used is present in all stations.</li> <li>Verify that receiving final product containers are placed on the rolling cart and underneath the deduster on both sides.</li> <li>Verify that receiving final product containers are placed on the rolling cart and underneath the deduster on both sides.</li> <li>Verify that the socks and powder chutes are aligned for a proper pellet and granule flow. (for example: Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to the receiving container, the sock that connects the press hopper to the chute)</li> <li>Verify that bin-docking station on the second level is clean and free of debris.</li> <li>Remove the docking station cover and verify that the collar is inflated. (for Bay 5 only)</li> <li>Verify that the screen on the docking station is free of generant.</li> <li>Remove the docking station cover. (for Bay 3 only)</li> <li>Inspect conductive cover. (for Bay 3 only)</li> <li>Inspect conductive cover.</li> <li>Verify that to ill is neal from the bin that is ready to be process and replace it with the conductive cover.</li> <li>Verify that VCR's are recording before starting process</li> <li>Record Press Start Time: <u>10.4</u></li> <li>Werify Relative Humidity (RH) in press bay is between 40% and 60%. Record the reading <u>1.42.2</u></li> <li>MCC</li> <li>MCC</li></ul>	. 1	Remove reject	ted material from	n last press r	m.	· <u>v</u> ·	_		7. MC
<ul> <li>Verify tooling to be used is present in all stations.</li> <li>Verify tooling to be used is present in all stations.</li> <li>Verify dedusters have bolts, nuts, screws, and washers in place and secure.</li> <li>Verify that receiving final product containers are placed on the rolling cart and underneath the deduster on both sides.</li> <li>0. Verify that all the socks and powder chutes are aligned for a proper pellet and granule flow. (for example: Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to the receiving container, the sock that connects the press hopper to the chute)</li> <li>1. Verify that bin-docking station on the second level is clean and free of debris.</li> <li>2. Remove the docking station cover and verify that the collar is inflated. (for Bay 5 only)</li> <li>Verify that the screen on the docking station is free of generant.</li> <li>3. P/C</li> <li>13. P/C</li> <li>14. MtC</li> <li>15. McC</li> <li>16. MC</li> <li>17. Mtc</li> <li>18. MCC</li> <li>19. MCC</li> <li>10. MC</li> <li>11. MC</li> <li>11. MC</li> <li>12. M/4</li> <li>13. P/C</li> <li>14. MtC</li> <li>15. McC</li> <li>16. MC</li> <li>17. Mtc</li> <li>18. MCC</li> <li>19. MCC</li> <li>10. MC</li> <li>11. MC</li> <li>11. MC</li> <li>12. M/4</li> <li>13. P/C</li> <li>14. MtC</li> <li>15. McC</li> <li>16. MC</li> <li>17. Mtc</li> <li>18. MtC</li> <li>19. MtC</li> <li>10. MC</li> <li>11. MC</li> <li>11. MC</li> <li>12. M/4</li> <li>13. P/C</li> <li>14. MtC</li> <li>15. McC</li> <li>16. MC</li> <li>17. Mtc</li> <li>18. MtC</li> <li>19. MtC</li> <li>10. MC</li> <li>10. MC</li> <li>11. MC</li> <li>11. MC</li> <li>12. M/4</li> <li>13. P/C</li> <li>14. MtC</li> <li>15. McC</li> <li>16. MC</li> <li>17. Mtc</li> <li>18. MtC</li> <li>19. MtC</li> <li>10. MC</li> <li>10. MC</li> <li>11. MC</li> <li>11. MC</li> <li>12. ML</li> <li>13. MtC</li> <li>14. MtC</li> <li>14. MtC</li> <li>15. MtC</li> <li>16. MC</li> <li>17. Mtc</li> <li>18. MtC</li> <li>19. MtC</li> <li>19. MtC</li> <l< td=""><td></td><td>Verify granule</td><td>e moisture is no</td><td>t greater than</td><td>0.3%. Moistur</td><td>e: 58 l</td><td>7 \$</td><td></td><td>8. MC</td></l<></ul>		Verify granule	e moisture is no	t greater than	0.3%. Moistur	e: 58 l	7 \$		8. MC
<ul> <li>Verify dedusters have bolts, nuts, screws, and washers in place and secure.</li> <li>Verify that receiving final product containers are placed on the rolling cart and underneath the deduster on both sides.</li> <li>Verify that all the socks and powder chutes are aligned for a proper pellet and granule flow. (for example: Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to the receiving container, the sock that connects the press hopper to the chute)</li> <li>Verify that bin-docking station on the second level is clean and free of debris.</li> <li>Remove the docking station cover and verify that the collar is inflated. (for Bay 5 only)</li> <li>Verify that the screen on the docking station is free of generant.</li> <li>Remove the docking station cover. (for Bay 3 only)</li> <li>Inspect conductive cover for deterioration or holes. If found please notify your cell lead or supervisor.</li> <li>Remove the metal lid bin seal from the bin that is ready to be process and replace it with the conductive cover.</li> <li>Verify that oller is on/open before starting of blend and that the correct amount is flowing.</li> <li>Verify that oller is on/open before starting process</li> <li>Record Press Start Time:</li></ul>		Verify tooling	to be used is pr	resent in all st	ations.				9. Mrc
<ul> <li>Verify that receiving final product containers are placed on the rolling cart and underneath the deduster on both sides.</li> <li>Verify that all the socks and powder chutes are aligned for a proper pellet and granule flow. (for example: Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to the receiving container, the sock that is on the discharge end of the deduster to the receiving container, the sock that connects the press hopper to the chute)</li> <li>Verify that bin-docking station on the second level is clean and free of debris.</li> <li>Remove the docking station cover and verify that the collar is inflated. (for Bay 5 only)</li> <li>Verify that the screen on the docking station is free of generant.</li> <li>Remove the docking station cover. (for Bay 3 only)</li> <li>Inspect conductive cover for deterioration or holes. If found please notify your cell lead or supervisor.</li> <li>Remove the metal lid bin seal from the bin that is ready to be process and replace it with the conductive cover.</li> <li>Verify that VCR's are recording before starting process</li> <li>Record Press Start Time: <b>1</b>: <b>1</b>: <b>1</b>: <b>1</b>: <b>1</b>: <b>1</b>: <b>1</b>: <b>1</b></li></ul>	. '	Verify deduste	ers have bolts, n	uts, screws, a	nd washers in	place and se	cure.		t .
<ul> <li>deduster on both sides.</li> <li>Verify that all the socks and powder chutes are aligned for a proper pellet and granule flow. (for example: Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to the receiving container, the sock that connects the press hopper to the chute)</li> <li>Verify that bin-docking station on the second level is clean and free of debris.</li> <li>Remove the docking station cover and verify that the collar is inflated. (for Bay 5 only)</li> <li>Verify that the screen on the docking station cover. (for Bay 3 only)</li> <li>Inspect conductive cover for deterioration or holes. If found please notify your cell lead or supervisor.</li> <li>Remove the metal lid bin seal from the bin that is ready to be process and replace it with the conductive cover.</li> <li>Verify that VCR's are recording before starting process</li> <li>Record Press Start Time:</li></ul>	. 1	Verify that rec	eiving final pro	duct containe	rs are placed o	n the rolling	, cart and un	derneath the	10. <u>MC</u>
<ul> <li>Verify that all the socks and powder chutes are aligned for a proper pellet and granule flow. (for example: Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to the receiving container, the sock that connects the press hopper to the chute)</li> <li>Verify that bin-docking station on the second level is clean and free of debris.</li> <li>Remove the docking station cover and verify that the collar is inflated. (for Bay 5 only)</li> <li>Verify that the screen on the docking station is free of generant.</li> <li>Remove the docking station cover. (for Bay 3 only)</li> <li>Inspect conductive cover for deterioration or holes. If found please notify your cell lead or supervisor.</li> <li>Remove the metal lid bin seal from the bin that is ready to be process and replace it with the conductive cover.</li> <li>Verify that oiler is on/open before starting of blend and that the correct amount is flowing.</li> <li>Verify that VCR's are recording before starting process</li> <li>Record Press Stor Time:</li></ul>	(	deduster on bo	oth sides.	·				4 64 6	
<i>example:</i> Sock and Chute connected from the press to the deduster, the sock that is on the discharge end of the deduster to the receiving container, the sock that connects the press hopper to the chute)11. $M \subset$ 1. Verify that bin-docking station on the second level is clean and free of debris.11. $M \subset$ 2. Remove the docking station cover and verify that the collar is inflated. (for Bay 5 only)14. $M \subset$ 3. Verify that the screen on the docking station or wholes. If found please notify your cell lead or supervisor.16. $M \subset$ 5. Remove the docking station cover. (for Bay 3 only)16. $M \subset$ 6. Remove the metal lid bin seal from the bin that is ready to be process and replace it with the 	J. '	Verify that all	the socks and p	owder chutes	are aligned to	r a proper pe	ellet and gra	nule flow. (for	
the chute) 1. Verify that bin-docking station on the second level is clean and free of debris. 2. Remove the docking station cover and verify that the collar is inflated. (for Bay 5 only) 3. Verify that the screen on the docking station is free of generant. 4. Remove the docking station cover. (for Bay 3 only) 5. Inspect conductive cover for deterioration or holes. If found please notify your cell lead or supervisor. 5. Remove the metal lid bin seal from the bin that is ready to be process and replace it with the conductive cover. 6. Verify that oiler is on/open before starting of blend and that the correct amount is flowing. 7. Verify that oiler is on/open before starting process 7. Record Press Start Time: 8. Verify Relative Humidity (RH) in press bay is between 40% and 60%. Record the reading 7. Werify that press is vacuumed after the run. 7. Verify that press is vacuumed after the run. 7. Verify that press is vacuumed after the run. 7. Verify that press is vacuumed after the run. 7. Rate = Start wt (kg)/ Press Time (hrs) = 7. NOTE: If rate in Bay 5 (GT) is > 22.73 kg/hr notify supervisor immediately.	e	example: Soci	c and Chute con	nected from t	he press to the	deduster, th	e sock that 1	s on the	11 MC
<ul> <li>and child bin docking station on the second level is clean and free of debris.</li> <li>Remove the docking station cover and verify that the collar is inflated. (for Bay 5 only)</li> <li>Verify that the screen on the docking station is free of generant.</li> <li>Remove the docking station cover. (for Bay 3 only)</li> <li>Inspect conductive cover for deterioration or holes. If found please notify your cell lead or supervisor.</li> <li>Remove the metal lid bin seal from the bin that is ready to be process and replace it with the conductive cover.</li> <li>Verify that oiler is on/open before starting of blend and that the correct amount is flowing.</li> <li>Verify that VCR's are recording before starting process</li> <li>Record Press Start Time:</li></ul>	( +	the chute)	of the deduster	to the receiving	ig container, u	ie sock mai	connects me	e press nopper to	12. N/A
<ul> <li>14. Matching station cover and verify that the collar is inflated. (for Bay 5 only)</li> <li>Verify that the screen on the docking station is free of generant.</li> <li>Remove the docking station cover. (for Bay 3 only)</li> <li>Inspect conductive cover for deterioration or holes. If found please notify your cell lead or supervisor.</li> <li>Remove the metal lid bin seal from the bin that is ready to be process and replace it with the conductive cover.</li> <li>Verify that oiler is on/open before starting of blend and that the correct amount is flowing.</li> <li>Verify that VCR's are recording before starting process</li> <li>Record Press Start Time: <u>10.9</u></li> <li>Verify Relative Humidity (RH) in press bay is between 40% and 60%. Record the reading</li> <li>Set up press for required pellet dimension per operator instructions.</li> <li>After press has reached steady granule flow, obtain ten pellet samples.</li> <li>Verify Relative Humidity (RH) in press bay is between 40% and 60%. Record the reading</li> <li>Set up the stress is vacuumed after the run.</li> <li>Rate = Start wt (kg)/ Press Time (hrs) = <u>10.85</u></li> <li>NOTE: If rate in Bay 5 (GT) is &gt; 22.73 kg/hr notify supervisor immediately.</li> </ul>		Verify that him	-docking station	on the secon	nd level is clea	n and free of	fdebris		13. MC
<ul> <li>15. <u>Mathematical (Conductive Conductions)</u></li> <li>15. <u>Mathematical (Conductive Conductive Conductive Cover for deterioration or holes. If found please notify your cell lead or supervisor.</u></li> <li>16. <u>Mathematical (Mathematical)</u></li> <li>17. <u>Mathematical (Mathematical)</u></li> <li>18. <u>Mathematical (Conductive Cover)</u></li> <li>19. <u>Mathematical (Conductive Cover)</u></li> <li>19. <u>Mathematical (Conductive Cover)</u></li> <li>10. <u>Mathematical (Conductive Cover)</u></li> <li>11. <u>Mathematical (Conductive Cover)</u></li> <li>12. <u>Mathematical (Conductive Cover)</u></li> <li>13. <u>Mathematical (Conductive Cover)</u></li> <li>14. <u>Mathematical (Conductive Cover)</u></li> <li>15. <u>Mathematical (Conductive Cover)</u></li> <li>16. <u>Mathematical (Conductive Cover)</u></li> <li>17. <u>Mathematical (Conductive Cover)</u></li> <li>18. <u>Mathematical (Conductive Cover)</u></li> <li>19. <u>Mathem</u></li></ul>	2. T	Remove the do	ocking station of	over and verif	$\hat{\mathbf{v}}$ that the coll	ar is inflated	(for Bay 5	only)	14. MC
A. Remove the docking station cover. (for Bay 3 only)16. $M^{C}$ 1. Inspect conductive cover for deterioration or holes. If found please notify your cell lead or supervisor.16. $M^{C}$ 1. Remove the metal lid bin seal from the bin that is ready to be process and replace it with the conductive cover.17. $M^{C}$ 1. Verify that oiler is on/open before starting of blend and that the correct amount is flowing.19. $M^{C}$ 1. Verify that VCR's are recording before starting process19. $M^{C}$ 2. Verify that VCR's are recording before starting process19. $M^{C}$ 2. Set up press for required pellet dimension per operator instructions.19. $M^{C}$ 2. Merify Relative Humidity (RH) in press bay is between 40% and 60%. Record the reading23. $M^{C}$ 2. Merify that press is vacuumed after the run.24. $M^{C}$ 2. Werify that press is vacuumed after the run.25. $M^{C}$ 2. NOTE: If rate in Bay 5 (GT) is > 22.73 kg/hr notify supervisor immediately.25. $M^{C}$	S. 1	Verify that the	screen on the d	ocking station	is free of gen	erant.	. ( <i> uj</i> J		15. Ja C
<ul> <li>Inspect conductive cover for deterioration or holes. If found please notify your cell lead or supervisor.</li> <li>Remove the metal lid bin seal from the bin that is ready to be process and replace it with the conductive cover.</li> <li>Verify that oiler is on/open before starting of blend and that the correct amount is flowing.</li> <li>Verify that VCR's are recording before starting process</li> <li>Record Press Start Time:</li></ul>	4. F	Remove the do	ocking station co	over. (for Bay	3 only)				
supervisor. 5. Remove the metal lid bin seal from the bin that is ready to be process and replace it with the conductive cover. 5. Verify that oiler is on/open before starting of blend and that the correct amount is flowing. 5. Verify that VCR's are recording before starting process 6. Record Press Start Time: $3^{+}$ $4^{+}$ . 7. Set up press for required pellet dimension per operator instructions. 7. After press has reached steady granule flow, obtain ten pellet samples. 7. Verify Relative Humidity (RH) in press bay is between 40% and 60%. Record the reading 7. $3^{-}$ . 7. Record Press stop time: $3^{-}$ . 7. $4^{-}$ . 7.	5. I	inspect conduc	tive cover for d	eterioration o	r holes. If four	nd please no	tify your cel	l lead or	16. <u>M</u> C
1.Remove the metal lid bin seal from the bin that is ready to be process and replace it with the conductive cover.17. $MC$ 1.Verify that oiler is on/open before starting of blend and that the correct amount is flowing.19. $MC$ 1.Verify that VCR's are recording before starting process19. $MC$ 1.Verify that VCR's are recording before starting process19. $MC$ 20. $MC$ 21. $M_1C$ 21. $M_1C$ 21. $M_1C$ 22. $MC$ 21. $M_1C$ 23. $MC$ 22. $MC$ 24. $MC$ 23. $MC$ 25. $MC$ 25. $MC$ 26. $MC$ 25. $MC$ 27.NOTE: If rate in Bay 5 (GT) is > 22.73 kg/hr notify supervisor immediately.25. $MC$	s	supervisor.							
conductive cover.18. $MC$ 9. Verify that oiler is on/open before starting of blend and that the correct amount is flowing.19. $MC$ 9. Verify that VCR's are recording before starting process20. $MC$ 9. Set up press for required pellet dimension per operator instructions.21. $M_1 C$ 9. Set up press for required pellet dimension per operator instructions.22. $MC$ 9. Verify Relative Humidity (RH) in press bay is between 40% and 60%. Record the reading23. $MC$ 21. $M_1 C$ 24. $MC$ 22. $MC$ 25. $MC$ 23. $MC$ 25. $MC$ 24. $MC$ 25. $MC$ 25. $MC$ 25. $MC$	5. F	Remove the m	etal lid bin seal	from the bin	that is ready to	be process a	and replace	it with the	17. MC
.Verify that oiler is on/open before starting of blend and that the correct amount is flowing.19. $MC$ .Verify that VCR's are recording before starting process20. $MC$ .Record Press Start Time: $M^2 \cdot 4/D$ 21. $M_1 C$ .Set up press for required pellet dimension per operator instructions.22. $MC$ .After press has reached steady granule flow, obtain ten pellet samples.23. $MC$ .Verify Relative Humidity (RH) in press bay is between 40% and 60%. Record the reading24. $MC$	с	onductive cov	ver.	_		_			18. <u>MC</u>
.Verify that VCR's are recording before starting process20. $M/C$ .Record Press Start Time: $(S + 4/)$ 21. $M_1 C$ .Set up press for required pellet dimension per operator instructions.22. $K C$ .After press has reached steady granule flow, obtain ten pellet samples.23. $M/C$ .Verify Relative Humidity (RH) in press bay is between 40% and 60%. Record the reading23. $M/C$ <td>. V</td> <td>/erify that oile</td> <td>er is on/open be</td> <td>fore starting o</td> <td>f blend and the</td> <td>at the correc</td> <td>t amount is :</td> <td>flowing.</td> <td>19. <u>Jan</u> (</td>	. V	/erify that oile	er is on/open be	fore starting o	f blend and the	at the correc	t amount is :	flowing.	19. <u>Jan</u> (
Record Press Start Time: $0 \cdot 40$ 21. $\frac{MC}{22}$ Set up press for required pellet dimension per operator instructions.       22. $LC$ After press has reached steady granule flow, obtain ten pellet samples.       23. $MC$ Verify Relative Humidity (RH) in press bay is between 40% and 60%. Record the reading       24. $MC$ Record Press stop time: $0 \cdot 30$ 25. $MC$ Verify that press is vacuumed after the run.       25. $MC$ Rate = Start wt (kg)/ Press Time (hrs) = $M \cdot 85$ NOTE: If rate in Bay 5 (GT) is > 22.73 kg/hr notify supervisor immediately.	. <u>\</u>	/erity that VC	R's are recordin	ig before star	ting process				20. <u>M(</u> 21 K. C
After press for required penet dimension per operator instructions. After press has reached steady granule flow, obtain ten pellet samples. Verify Relative Humidity (RH) in press bay is between 40% and 60%. Record the reading $\underline{S}$ . Record Press stop time: $O$ . Verify that press is vacuumed after the run. Rate = Start wt (kg)/ Press Time (hrs) = $O$ . NOTE: If rate in Bay 5 (GT) is > 22.73 kg/hr notify supervisor immediately.	. R	kecord Press S	tart 1 ime:	· 40		han a ti			22 1. 1010
Yerify Relative Humidity (RH) in press bay is between 40% and 60%. Record the reading       23. $\mathcal{MC}$ .       .       .         .       .       . </td <td>. S</td> <td>fter press to</td> <td>required pellel</td> <td>aronula florr</td> <td>obtain ton not</td> <td>let complex</td> <td></td> <td></td> <td></td>	. S	fter press to	required pellel	aronula florr	obtain ton not	let complex			
$\frac{3}{24} \frac{1}{44}$ $\frac{24}{25} \frac{1}{44}$ $\frac{1}{4} \frac{1}{4}$ $\frac{1}{4} \frac{1}{4} \frac{1}{4}$ $\frac{1}{4} \frac{1}{4} \frac{1}{4}$ $\frac{1}{4} \frac{1}{4} \frac{1}{4} \frac{1}{4}$ $\frac{1}{4} \frac{1}{4} \frac{1}{4} \frac{1}{4}$ $\frac{1}{4} \frac{1}{4} \frac{1}{4} \frac{1}{4} \frac{1}{4}$ $\frac{1}{4} \frac{1}{4} \frac{1}{$	· P	Zerify Relative	Humidity (RU	) in press bay	, obtain ten per	wand 60%	Record the	reading	23. KC
<ul> <li>Record Press stop time: <u>0.30</u></li> <li>Verify that press is vacuumed after the run.</li> <li>Rate = Start wt (kg)/ Press Time (hrs) = <u>94.85</u></li> <li>NOTE: If rate in Bay 5 (GT) is &gt; 22.73 kg/hr notify supervisor immediately.</li> </ul>	· ·	$\langle \mathcal{A} \rangle$	/.	у ш ртезэ bay	13 UCLWCCII 40	/0 and 00 /0.		roaumg	24. MC
<ul> <li>Verify that press is vacuumed after the run.</li> <li>Rate = Start wt (kg)/ Press Time (hrs) =</li></ul>	 . R	lecord Press st	top time: /	):7()					25. MC
Rate = Start wt (kg)/ Press Time (hrs) = $24.8$ NOTE: If rate in Bay 5 (GT) is > 22.73 kg/hr notify supervisor immediately.	. V	Verify that pres	ss is vacuumed	after the run.	5	-			to the second second
NOTE: If rate in Bay 5 (GT) is > 22.73 kg/hr notify supervisor immediately.	. R	Late = Start wt	(kg)/ Press Tim	he (hrs) =	24.8	)			
	]	NOTE: If ra	ate in Bay 5 (G	T) is $> 22.73$	kg/hr notify s	upervisor iı	nmediatelv		
			· D / /		~ / ( )	· ····			

\* The Press Bay Scrubbers' pressure drop should be between 4.5 and 8.5 inches of water.

,

EU 004

## PROCESS RATE CALCULATIONS - Bldg 7

Date:	13-May-10				
	Cel	I GQ - P/N 7	9005420		
			1st shift	3rd shift	_
		Γ	8		
	# Hours in shift(8 or 10)		10	10	
1	Fotal Material Processed	40		Total Pro	ductivity
	Total Minutes needed	320		1st shift	3rd shift
	Process Rate(kg/hr)	7.50		80.0%	0.0%
	Process Rate lb/hr*	16.5			-

\* If process rate exceeds 18.85 lbs/hr contact Supervisor

Cell GF - P/N 79800110/79800111									
		1st shift	3rd shift						
# kg's pressed & canne	a [	34.85							
# Hours in shift(8 or 10)		10	10	]					
Total Material Processed	34.85		3rd shift						
Total downtime 1st shift(% of shift)	30.83								
Total downtime 3rd shift(% of shift)	0.00								
Total downtime of 24 hour day	0.128		Total Pro	ductivity					
Total Time available of 24 hour day	0.83333333		1st shift	3rd shift					
Process Rate(kg/hr)	2.06		72.6%	0.0%					
Process Rate lb/hr*	4.532217								

\* If process rate exceeds 24 lbs/hr contact Supervisor

Cell Lead/Supervisor Signature: \_\_\_\_\_

XSG09003 Rev. C MCN # 14378 5/1/2008

. . .

## PROCESS RATE CALCULATIONS - Bldg 7

22				
Date: 24-May-10				
	Cell GQ - P	/N 79005420		
		1st shift	3rd shift	
		5		
# Hours in shift	(8 or 10)	10	10	]
Total Material Process	ed	25	Total Pro	oductivity
Total Minutes needed		200	1st shift	3rd shift
Process Rate(kg/hr)	7	.50	50.0%	0.0%
Process Rate Ib/hr*	1	6.5		

\* If process rate exceeds 18.85 lbs/hr contact Supervisor

Cell GF - P/N 79800110/79800111								
		1st shift	3rd shift					
# kg's pressed & canned	d 🗌	36.65						
# Hours in shift(8 or 10)		10	10					
Total Material Processed	36.65		3rd shift					
Total downtime 1st shift(% of shift)	38.33							
Total downtime 3rd shift(% of shift)	0.00							
Total downtime of 24 hour day	0.160		Total Pro	ductivity				
Total Time available of 24 hour day	0.83333333		1st shift	3rd shift				
Process Rate(kg/hr)	2.27		76.4%	0.0%				
Process Rate lb/hr*	4.987423							

\* If process rate exceeds 24 lbs/hr contact Supervisor

Cell Lead/Supervisor Signature:

Mallon 11

XSG09003 Rev. C MCN # 14378 5/1/2008

PART NO: 79000160 DATE: <u>5-21-10</u>

SHIFT

С

В

Batch Lot Number: <u><u><u>G</u>WV 141</u></u>

PRODUCT DESCRIPTION:

CELL LEADER OR SUPERVISOR: 155101

OP. NUMBER / DESCRIPTION	Process Notes								
OP 60 Weighout Ingredients	COMPONENT & PART NUMBER	FORMULATION PERCENT	SUPPLIER LOT NUMBER	Required Weight (kg)		Actual Weight	Operator	Date	
and Screen into Generant	TOTAL BATCH WEIGHT TO BE 45.05 KG			Min.	Target	Max.	Added (kg)	nintiais	
Bin	Ground Nitroguanidine P/N 79000163	50.0± 0.5 FB	DV/34C12 139C-11	22.3	22.5	22.7	22.5	mw	
	Ground Strontium Nitrate P/N 79005700	35.0 ± 0.5	N1134A0001	15.6	15.8	16.0	15.8	1	5
	Ground Potassium Nitrate P/N 79005600	6.0 ± 0.2	(V/27A000/	2.61	2.70	2.79	2:10	ļ	
	Mica P/N 79005200	8.0 ± 0.2	10040701	3.51	3.60	3.69	3.60	HA	21/
	Cupric Oxide P/N 79000162	1.0 ± 0.2	R0080101	0.36	0.45	0.54	145	•	
	-					Total	45.05		10
	Verify relative humidity (RH) in Bay is between 40% and 60%. Notify Supervisor if out of range. Record the reading:								
	Weighout Bay Scrubber (#4) inlet pressure(inches of Water) Reading should be between 3.0 and 4.6 inches of water, if outside this range don't process, stop and notify technician)								
	DVR and monitor are operational and recording								61
	Verify scrubber water level is acceptable								$\mathbb{Z}$
	Verify generant blending bin is clean	and dry and that bin	valve actuation b	olock is :	secure				21/
	Verify generant blending bin discharg			12					
	Verify scrubber is on and dust hood is functional								10
	Verify ingredient screen is present at bin lid opening								
	Weighout Start Time: $\frac{0.30}{7.00}$ Weighout Finish Time: $7.00$	(start time is time op (Start time is time op (Finish time is time v	out berator begins ret vhen operator ren	rieving r noves b	material to in from sca	conduct ale)	weighout)	mw	

EU OO 6

NA-227, NON-AZIDE GENERANT, GRANULES

A03

AFELY SY	SIEM CELL DESIGNATOR: GW EU OOG PART	NO: 790001	160
PRODUCT D	ESCRIPTION: NA-227, NON-AZIDE GENERANT, GRANULES	: 5-21-	10
Batch Lot N	umber:		
CELL LEADE	RORSUPERVISOR: WESton SHIF	Т: (А́) В	С
OP. NUMBER / DESCRIPTION	Process Notes		
OP 60	Total Minutes: 30 Minutes / 60 = total Hours _ / 5	Mh	
CONT.	Rate = <u>Amount of Material</u> = $G \cap I$		
	Total Hrs. $////$		.6/
	NEVER process more than three batches in one hour		1/2/
	Verify generant bin lid seal is in place after removing ingredient screen		4
	Bin blending lid on bin and secured with clamp	- mal	10
			I
OP 70	Verify DVR and Monitor are Operational and Recording	13	5.21
Generant	Verify granule bin lid with two paddles is clamped to top of container.		10-21
Blending	Verify clap on lid is facing at back or at front of tumbler entrance		
-	Retention strap secured across front of tumbler cradle	90 	
-	Verify tumbler control panel counter set to 900 revolutions		
	Tumble bin a minimum of 900 times per operator instruction.Start Time: $1.05$ Stop Time: $1.50$	10	5-21
D	ry Blend Finished in Bay 4 use YSG09035 or Blend wet mixed at Bldg 10, Bay 2) (Circle one)	Operator	
	After dry blend is finished in Bay 4 place paperwork in control hallway in Bldg 10. If dry blend mixed in Bldg 10 Bay 2 keep paperwork with blend until complete.	Initials	Date
OP 80	Verify relative humidity (RH) in Bay is between 40% and 90%.		
Granulation	Record the reading: 72%	HA	5-25
and Drying	Granulation Bay Scrubber (#5) inlet pressure : $\underline{s} \phi$ (inches of water) **		
	(pressure should be between 3.5 and 7.5 inches of water – if outside range do not process, stop and notify technicia	n) HA	5-25
	Verify DVR and monitor are operational and recording	HA	5-25
	Verify receiving bin or drum is clean and dry and that bin actuation block is secure	HA	5-25
	Verify receiving bin discharge valve is closed and seated or drum is secure	44	5-25
	Grounding strap connected to generant receiving bin or drum	HA	5-25
	Verify fluid bed dryer weir is up and overs screen is in place and clear of material.	HA	5-25
	YCG09025 REV. T MCN # 15156 4/22/10	<u>111 kN</u>	

Page 2 of 5

Ĵ

NA-227, NON-AZIDE GENERANI, UNANUEL

Batch Lot Number: Call 141A-5

PRODUCT DESCRIPTION:

Batch Lo	ot Number: $\underline{C_{H}}$ $\underline{V_{I4IA}}$ $\underline{S}$ $\underline{EV}$ 0.0 C		· ·			
CELL LE	ADER OR SUPERVISOR: Maria W	(A)	вс			
OP 80	Verify fluid bed dryer assembly and that screw clamps are tightened	HA	5.25			
CONT.	Verify chiller is on and functional	HA	5.25			
	Verify Teledyne mixer extrusion screen/plate is present, clear, and undamaged	HA	5-25			
	Accurate feeder screen is clean and not damaged					
	Verify flexible connection between bin station discharge and AccuRate hopper is secure	140	5.25			
	Verify scrubber water level is acceptable					
	Verify that the vibrator for the accurate feeder is operating when wier is in the up position					
	Docking station slide place is open and clear from debris etc.					
	Accurate feeder screen is clean and free of debris	HA	5.25			
,	Verify Alexanderwerk screen present, cutting perforations not damaged or worn, and there is proper blade clearance	HA	5-25			
	Granulation Start Time: 5:00 (Start time begins when operator begins hoisting bin to docking station)	HA	5.25			
	Granulation Finish Time: (Finish time is time operator enters bay to seal completed bin of product)	HA	5.25			
	Total Minutes: $/20$ Minutes / 60 = total Hours $_208$					
	Rate = Amount of Material = _2/.30					
	I otal Hrs.	110	5-25			
	In face exceeds 23.3kg / In notify Supervisor of Lead, and HSE infinediately	14-00	(0 0)			

YCG09025

MCN # 15156

4/22/10