

Premix / CMRC CM Test

Traverse

BMC 1-1

Day - 13

Date - 9/4/08

Time - 1:40 pm

NWS Barometric in Hg

Local Altitude ft

Stack Static in w.g.

Dry Bulb F

Wet Bulb F

30 ct/15 sec

VP @
.41

Traverse Point	V (in wg)	H (in wg)
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enclosure
-.04 / -.06

1	37	33
2	40	34
3	41	36
4	40	37
5	41	42
6	40	44
7	35	38
8	28	30

Premix / CMRC CM Test

Traverse	<u>BMC 1-2</u> : LG CHARGE LACOVARA
Day - 13	
Date - 9/14/08	
Time - 2:17 PM	

NWS Barometric in Hg

Local Altitude ft

Stack Static in w.g.

Dry Bulb F

Wet Bulb F

50 ct / 15 sec

VP @

.38 / .40

Traverse Point	V (in wg)	H (in wg)
1	.37	.36
2	.39	.34
3	.40	.37
4	.40	.37
5	.41	.41
6	.40	.43
7	.35	.39
8	.34	.35

enclosure

-.05 / -.07

Premix / CMRC CM Test

Traverse

BMC 1-3

Day - 13
Date - 9/14/08
Time - 3:30p

NWS Barometric in Hg

Local Altitude ft

Stack Static in w.g.

Dry Bulb F

48 cT / 15 sec

Wet Bulb F

VP &
.40/.41

Traverse Point

V
(in wg)

H
(in wg)

ENCLOSURE
-0.04/-0.06

1	.36	.33
2	.40	.35
3	.40	.36
4	.40	.37
5	.41	.41
6	.39	.42
7	.31	.39
8	.26	.34

BIAS
-0.01

B2-1

Premix / CMRC CM Test

Traverse BMC 2-1

Day - 13
Date - 9/14/08
Time - 4:58 p

NWS Barometric 29.91 ↓ in Hg

Local Altitude ft

Stack Static -1.27 in w.g.

Dry Bulb 79.3 F

Wet Bulb 67.5 F

23 ct / 15 sec

VP @
.40

ENCLOSURE
-0.05 / -0.07

	V (in wg)	H (in wg)
Traverse Point 1	37	33
2	40	34
3	41	36
4	40	37
5	40	41
6	41	43
7	34	39
8	29	34

Premix / CMRC CM Test

Traverse

BMC 2-2

Day - 14
Date - 9/5/08
Time - 8:55 a

NWS Barometric S in Hg

Local Altitude ft

Stack Static in w.g.

Dry Bulb F

Wet Bulb F

34 ct / 15 sec

VP
.40

Traverse Point

V
(in wg)

H
(in wg)

ENCLOSURE

-.06 / -.08

- 1
- 2
- 3
- 4
- 5
- 6
- 7
- 8

38	32
40	34
42	35
40	37
40	42
40	43
32	38
27	33

B2-3

Premix / CMRC CM Test

Traverse

BMC 2-3

Day - 14

Date - 9/5/08

Time - 10:10 am

NWS Barometric in Hg

Local Altitude ft

Stack Static in w.g.

VP @
.40

Dry Bulb F

Wet Bulb F

46 ct / 15 sec

Traverse Point

V
(in wg)

H
(in wg)

ENCLOSURE

-.05/6 -


-.07/8

- 1
- 2
- 3
- 4
- 5
- 6
- 7
- 8

1	38	32
2	40	34
3	41	36
4	40	38
5	40	42
6	40	43
7	36	38
8	28	34

PREMIX

Compression Molded Parts Parameters - CMEF TTE Test - BMC

PART DESCRIPTION	CHARGE WEIGHT		HOURLY BMC USAGE	HOURLY QUOTA	CHARGE PREP TIME	MOLD CLOSING TIME	CURE TIME	CHARGE DIMENSIONS	FORMULATION NUMBER	STYRENE CONTENT	LOWER MOLD TEMP	BULK DENSITY	COMMENTS
	g/charge	lb/charge	lb/hr	parts/hr	sec	sec	sec	W" x L"		% wt SMC	°F	lb/ft^3	
Cover	490	1.08	23	21	var.	-5	120	9x3 oval ball	[REDACTED]	11.84%	310	tbd	
3 Pole ACB Housing, Front	6700	14.74	147	10	var.	-5	300		[REDACTED]	11.84%	305	tbd	

W:\New Directory Structure\AIR\CMEF and Related\MP TTE Master Part List-Redacted.xls]BMC

SMC Test Data

Date: 9-4-08

Run #: Bmc1-1

Sample #: Bmc1

Styrene Content - % wt. 11.84 Styrene Content - % vol.

Part Quota - #/hr: 10

Target Cycle Time:

Target Weight: 14.74

Mold Temp: 297.8

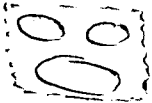
Start Time: 1:00

End Time: 1:57

Total Test Time: 57

*Box Enclosure
inches*

15x15x7



Series #:	1st Half Charge Prep	Full Charge Prep	Transfer to Tool	On Tool	Out Door	Total Cycle Time	Total Charge Wt.
1						4:36.60	14.72
2						2:04.69	14.72
3						2:01.00	14.74
4						2:37.15	14.75
5						1:26.15	14.71
6						2:00.90	14.73
7						2:22.33	14.74
8						2:14.43	14.73
9						2:35.39	14.73
10						2:26.06	14.73
11							
12							
13							
14							
15							
16							
17							
18							
19							
20							
21							
22							
23							
24							
25							
26							
27							
28							
29							

SMC Test Data

Date: 9-4-08

Run #: Bmcl-2

Sample #: Bmcl

Styrene Content - % wt. 11.84

Styrene Content - % vol.

Part Quota - #/hr: 10

Target Cycle Time:

Target Weight: 14.74

Mold Temp: 298.2

Start Time: 2:15

End Time:

Total Test Time: 56min

Series #:	1st Half Charge Prep	Full Charge Prep	Transfer to Tool	On Tool	Out Door	Total Cycle Time	Total Charge Wt.
1						1:37.13	14.72
2						2:14.00	14.74
3						2:12.61	14.73
4						2:25.81	14.74
5						2:49.96	14.74
6						2:20.02	14.74
7						2:15.28	14.74
8						2:20.28	14.74
9						1:56.20	14.74
10						2:00.57	14.74
11							
12							
13							
14							
15							
16							
17							
18							
19							
20							
21							
22							
23							
24							
25							
26							
27							
28							
29							

SMC Test Data

Date: 9-4-08

Run #: BmC1-3

Sample #: BmC1

Styrene Content - % wt. 11.84 Styrene Content - % vol.

Part Quota - #/hr: 10 Target Cycle Time:

Target Weight: 14.74 Mold Temp: 294.7

Start Time: 3:20 End Time: 4:17

Total Test Time: 57 min

Series #:	1st Half Charge Prep	Full Charge Prep	Transfer to Tool	On Tool	Out Door	Total Cycle Time	Total Charge Wt. <i>lbs</i>
1						2:17.26	14.74
2						2:44.76	14.74
3						3:22.32	14.74
4						2:04.03	14.74
5						2:18.90	14.74
6						2:55.34	14.74
7						2:18.86	14.74
8						2:16.23	14.74
9						2:15.77	14.74
10						2:34.08	14.74
11							
12							
13							
14							
15							
16							
17							
18							
19							
20							
21							
22							
23							
24							
25							
26							
27							
28							
29							

SMC Test Data

Date: 9-4-08

Run #: Bmc2-1

Sample #: Bmc2

Styrene Content - % wt. 11.84 Styrene Content - % vol.

Part Quota - #/hr: 21 Target Cycle Time:

Target Weight: 1.08 Mold Temp: 290.9

Start Time: 4:35 End Time: 4:

Total Test Time: 58 min

Series #:	1st Half Charge Prep	Full Charge Prep	Transfer to Tool	On Tool	Out Door	Total Cycle Time	Total Charge Wt.
1						1:00.17	1.08
2						57.99	1.08
3						48.19	1.08
4						56.77	1.08
5						45.25	1.08
6						43.34	1.08
7						1:24.31	1.08
8						59.03	1.08
9						38.64	1.08
10						1:04.52	1.08
11						50.40	1.08
12						1:13.52	1.08
13						56.24	1.08
14						54.55	1.08
15						46.16	1.08
16						37.69	1.08
17						56.19	1.08
18						37.34	1.08
19						1:07.04	1.08
20						52.06	1.08
21						43.48	1.08
22							
23							
24							
25							
26							
27							
28							
29							

SMC Test Data

Date: 9-5-08

Run #: Bmc2-2

Sample #: Bmc2

Styrene Content - % wt. 11.84

Styrene Content - % vol.

Part Quota - #/hr: 21

Target Cycle Time:

Target Weight: 1.08 lbs

Mold Temp:

Start Time: 8:38

End Time: 9:37

Total Test Time: 59 min

Box Enclosure
inches



7x4.5x3.5 inches

Series #:	1st Half Charge Prep	Full Charge Prep	Transfer to Tool	On Tool	Out Door	Total Cycle Time	Total Charge Wt.
1						1:02.62	1.08
2						43.23	1.08
3						42.14	1.08
4						1:12.75	1.08
5						1:13.87	1.08
6						57.41	1.08
7						46.02	1.08
8						31.51	1.08
9						57.36	1.08
10						1:03.96	1.08
11						54.73	1.08
12						43.16	1.08
13						50.91	1.08
14						43.35	1.08
15						53.22	1.08
16						1:03.36	1.08
17						49.66	1.08
18						38.90	1.08
19						46.89	1.08
20						44.42	1.08
21						57.09	1.08
22							
23							
24							
25							
26							
27							
28							
29							

SMC Test Data

Date: 9-5-08

Run #: Bmc23

Sample #: Bmc2

Styrene Content - % wt. 11.84 Styrene Content - % vol.

Part Quota - #/hr: 21

Target Cycle Time:

Target Weight: 1.08 lbs

Mold Temp: 303.2

*DURING
Run 4*

Start Time: 9:54

End Time: 10:53

Total Test Time: 59 min

Series #:	1st Half Charge Prep	Full Charge Prep	Transfer to Tool	On Tool	Out Door	Total Cycle Time	Total Charge Wt.
1						42.05	1.08
2						45.81	1.08
3						48.52	1.08
4						46.13	1.08
5						52.12	1.08
6						49.92	1.08
7						43.46	1.08
8						38.38	1.08
9						47.28	1.08
10						42.82	1.08
11						38.19	1.08
12						38.86	1.08
13						42.28	1.08
14						1:01.35	1.08
15						53.92	1.08
16						59.49	1.08
17						40.50	1.08
18						49.53	1.08
19						38.29	1.08
20						45.56	1.08
21						34.53	1.08
22							
23							
24							
25							
26							
27							
28							
29							