

Recipe Steps

Loadstar

Recipe

CS-401 Ver.: 8

Line: PKSLIN01

Recipe code

Name Calender (Quin No

Mixing Aggregat: Mixer1

Step 1



Rubber feed in

SV

Ram Pressure

60 [N/cm²]

Rotations

45 [1/min]

Ram Cleaning

0 [0/1]

TR

Time

>

1 [sec]

&

MF

TSR 5/10/20

RB-1148

73.926 [kg]

SBR 1500 or 1502

RB-1013

62.426 [kg]

Tyre Reclaim Rubber (Imported)

RB 1022

32.856 [kg]

Step 2



carbon black

SV

Ram Pressure

60 [N/cm²]

Rotations

45 [1/min]

Ram Cleaning

0 [0/1]

MF

SSPC

RB 1157

19.714 [kg]

N 330

CB 2330

59.141 [kg]

Step 3



Manual Input time 30 sec

SV

Ram Pressure

50 [N/cm²]

Rotations

45 [1/min]

Ram Cleaning

0 [0/1]

TR

Time

>

10 [sec]

&

MF

1 st stage chemicals

1 ST-CHEMI

14.785 [kg]

Step 4



SV

Ram Pressure

60 [N/cm²]

Rotations

45 [1/min]

Ram Cleaning

0 [0/1]

Reusing [ON/OFF]

0 [0/1]

TR

Temperature

>

145 [°C]

&

Step 5



SV

Ram Pressure

60 [N/cm²]

Rotations

50 [1/min]

Ram Cleaning

0 [0/1]

Reusing [ON/OFF]

0 [0/1]

MF

Low Phase Process oil

PA 4040

9.857 [kg]

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Step	6		
SV		Ram Pressure	60 [N/cm²]
		Rotations	35 [1/min]
		Ram Cleaning	1 [0/1]
		Reusing [ON/OFF]	0 [0/1]
TR		Time	> 6 [sec] &
Step	7		mit to 155 C
SV		Ram Pressure	60 [N/cm²]
		Rotations	35 [1/min]
		Ram Cleaning	0 [0/1]
TR		Temperature	> 165 [°C] &
Step	8		dump
SV		Ram Pressure	60 [N/cm²]
		Rotations	35 [1/min]
		Ram Cleaning	0 [0/1]
TR		Time	> 6 [sec] &
Step	9		
SV		Ram Pressure	60 [N/cm²]
		Rotations	35 [1/min]
		Ram Cleaning	0 [0/1]
TR		Time	> 5 [sec] &
Step	10		close drop door
SV		Ram Pressure	60 [N/cm²]
		Rotations	35 [1/min]
		Ram Cleaning	0 [0/1]
TR		Time	> 6 [sec] &
Over Temp:	MaxTemp: 190 [°C]		Mixer Position: 
	Ram Pressure	40 [N/cm²]	Min Total Time: 0 [s]
			Rotations 40 [1/min]

Last changes: (Recipe Step Control) from: planop 26.02.2016 17:47:31	Verification:	Acceptance: