



Casting Emission Reduction Program

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US Army Task N256
**80% Western/20% Southern Bentonite
and Advanced Oxidation (AO) Water**

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Pre-Production Air Emission Tests

Bentonite Clay Ratios 80/20 Western/Southern

This report has been reviewed for completeness and accuracy and approved for release by the following:

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The data contained in this report were developed to assess the relative emissions profile of the product or process being evaluated. You may not obtain the same results in your facility. Data was not collected to assess casting quality, cost, or producibility

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Executive Summary

This report contains the results of testing conducted at the Technikon/CERP Pre-Production Foundry to investigate the effects of Advanced Oxidant (AO) enriched water on the emissions from vented cored greensand molds compared to a tap water reference. Casting surface quality was not evaluated during these tests. This report provides results from a total of twelve test pours (tests), with the first three tests performed to condition virgin sand and mold materials. The approved test plan for this test series may be found in Appendix A of this document. Points of comparison between this and related AO studies have been **bolded**.

The specific objective of Test Plan DU was to determine the emission reductions, if any, of organic Hazardous Air Pollutants (HAPs) and Volatile Organic Compounds (VOCs) for a vented **advanced-oxidant (AO) enriched water** tempered virgin greensand mold utilizing an **80/20** Western to Southern bentonite clay ratio and Seacoal. The core package consisted of organic free sodium silicate cores so that the only known mold organic was seacoal. The test results may be compared to Pre-Production Tests DA, and DS that also utilize an **AO enriched water** tempered virgin greensand vented mold with seacoal, and bentonite clay ratios of **20/80** and **50/50** Western to Southern respectively. In addition, test results may be compared to Pre-Production Tests DQ, DR, and DT that are duplicates of DA, DS, and DU, except that they utilize **tap water** additions instead of AO enriched water.

The Pre-Production Foundry is a simple general purpose manual foundry that was adapted and instrumented to make detailed organic emission measurements, using methods based on EPA protocols for pouring, casting cooling, and shakeout processes on discrete mold and core packages. The measurements are conducted under tightly controlled conditions not feasible in a commercial foundry. It is the initial step in the schema of evaluating a new product or process for the foundry industry. The results of testing in the Pre-production Foundry are evaluated to determine whether further testing in the Technikon Production Foundry is warranted.

The testing performed involved the collection of continuous air samples over a seventy-five minute period, including the mold pouring, cooling, shakeout, and post shakeout periods. Process and stack parameters were measured and include: the weights of the casting, mold, core binder, and core; Loss on Ignition (LOI) values for the mold prior to the test and at shakeout; percent clays; metallurgical data; and stack temperature, pressure, volumetric flow rate and moisture content. The process parameters were maintained within prescribed ranges in order to ensure the reproducibility of the tests. Nine (9) individual sampling events were conducted for test plan DU. Three test pours were utilized to condition the sand to the AO water, based on historical data, and nine test pours were utilized for the actual test.

Samples were collected and analyzed for a selected list of twenty (20) target compounds using procedures based on US EPA Method 18. Continuous monitoring of the Total Gaseous Organic Concentration (TGOC), formerly Total Hydrocarbon Content (THC), of the emissions was conducted according to US EPA Method 25A. Finally, the "condensable" organic material in the emissions was determined using a Technikon developed procedure. The "condensables" represent the "back half" catch from US EPA Method 5.

The mass emission rate of each parameter or target compound was calculated, in pounds per ton of metal, using the Method 25A data or the laboratory analytical results, the measured source data, and the weight of each casting. Results for structural isomers have been grouped and reported as a single entity. For example, ortho-, meta-, and para-xylene are the three (3) structural isomers of dimethyl benzene. Several "emissions indicators," in addition to the TGOC (THC) as Propane, were also calculated. The HC as Hexane results represent the sum of all organic compounds detected and expressed as Hexane. All of the following sums are sub-groups of this measure. The "Sum of VOCs" is based on the sum of the individual target VOCs measured and includes the HAPs and Polycyclic Organic Material (POMs) listed in the Clean Air Act Amendments of 1990. The "Sum of HAPs" is the sum of the individual target HAPs measured and includes the POMs. Finally, the "Sum of POMs" is the sum of all of the polycyclic organic material measured. Results for the emission indicators, for all nine test runs are shown in the following table. All results are measured as pounds emitted per ton of metal.

Number of Tests Included	TGOC (THC) As Propane	HC as Hexane	Sum of VOCs	Sum of HAPs	Sum of POMs
9	2.41	0.611	0.264	0.245	0.021

Due to the fact that the results expressed here are sums derived from a selected set of approximately 20 analytes, they are comparable only to test series utilizing an equivalent selected analyte list. All test series performed for the AO water/Tap water, clay ratio studies will utilize this selected analyte list, and are therefore comparable. But they cannot be compared to similarly titled results from test series in which a different analyte list has been used to generate the data.

In addition, it must be noted that the reference and product testing performed is not suitable for use as general emission factors or for purposes other than evaluating the relative emission reductions associated with the use of alternative materials, equipment, or processes. The emissions measurements are unique to the specific castings produced, materials used, and testing methodology associated with these tests, and should not be used as the basis for estimating emissions from actual commercial foundry applications.

1.0 Introduction

1.1 Background

Technikon LLC is a privately held contract research organization located in McClellan, California, a suburb of Sacramento. Technikon offers emissions and process research services to industrial and government client specializing in the metal casting and mobile emissions areas. Technikon also operates the Casting Emission Reduction Program (CERP). CERP is a cooperative initiative between the Department of Defense (US Army) and the United States Council for Automotive Research (USCAR). Its purpose is to evaluate alternative casting materials and processes that are designed to reduce air emissions and/or produce more efficient casting processes. Other technical partners directly supporting the project include: the American Foundrymen's Society (AFS); the Casting Industry Suppliers Association (CISA); the US Environmental Protection Agency (USEPA); and the California Air Resources Board (CARB). Each of these partners is represented on a Steering Committee (as voting or non-voting members) that has oversight for the CRADA testing conducted at the Technikon facility.

1.2 CERP Objectives

The primary objective of CERP program is to evaluate materials, equipment, and processes used in the production of metal castings. The Technikon facility was designed to evaluate alternate materials and production processes designed to achieve significant air emission reductions, especially for the 1990 Clean Air Act Amendment organic Hazardous Air Pollutants (HAP). The facility has two principal testing arenas: a Pre-production Foundry designed to measure airborne emissions from individually poured molds, and a Production Foundry designed to measure air emissions in a continuous full scale production process. Each of these testing arenas has been specially designed to facilitate the collection and evaluation of airborne emissions and associated process data. The data collected during the various testing projects are evaluated to determine both the airborne emissions impact of the materials and/or process changes, and their stability and impact upon the quality and economics of casting and core manufacture. The materials, equipment, and processes may need to be further adapted and defined so that they will integrate into current casting facilities smoothly and with minimum capital expenditure.

Normally, Pre-production testing is conducted first in order to evaluate the air emissions impact of a proposed alternative material, equipment, or process in the most cost effective manner. The Pre-production Foundry is a simple general purpose manual foundry that was adapted and instrumented to make detailed emission measurements using methods based on EPA protocols for pouring, casting cooling, and shakeout processes on discrete mold and core packages under tightly controlled conditions not feasible in a commercial foundry. The Pre-production Foundry uses an eight-cavity, bottom feed AFS step block as its test mold pattern.

The Production Foundry's design as a basic greensand foundry was deliberately chosen so that whatever is tested in this facility will also be convertible to existing mechanized commercial foundries. The type and size of equipment, materials, and processes used emulate an automotive foundry. This facility is used to evaluate materials, equipment, and processes in a continuous

process that is allowed to vary to the limits of commercial experience in a controlled manner. The Production Foundry provides simultaneous detailed individual emission measurements using methods based on USEPA protocols of the melting, pouring, sand preparation, mold making, and core making processes. It is instrumented so that the data on all activities of the metal casting process can be simultaneously and continuously collected, in order to completely evaluate the economic impact of the prospective emission reducing strategy. The Production Foundry's test casting is a single cavity Ford Motor Company I-4 engine block. Castings are randomly selected to evaluate the impact of the material, equipment, or process on casting quality. Alternative materials, equipment, and processes that demonstrate significant air emission reduction potential, preserve casting quality parameters, and that are economically viable based on the Pre-production testing, may be further evaluated in the Production Foundry.

It must be noted that the results from the reference and product testing performed are not suitable for use as general emission factors or for other purposes other than evaluating the relative emission reductions associated with the use of alternative materials, equipment, or manufacturing processes. The emissions measurements are unique to the specific castings produced, materials used, and testing methodology associated with these tests.

1.3 Report Organization

This report has been designed to document the methodology and results of a specific test plan that was used to evaluate the performance of an alternative material, equipment, or process in the Pre-production Foundry. Section 2 of this report includes a summary of the methodologies used for data collection and analysis, emission calculations, QA/QC procedures, and data management and reduction methods. Specific data collected in support of these tests are summarized in Section 3 of this report, with detailed data included in Appendices B and C of this report. Section 4 of this report contains a discussion of the results.

The raw data for this test series are included in a data binder that is maintained at the Technikon facility. There are several support documents that provide details regarding the testing and analytical procedures used. Appendix F contains a listing of these support documents.

1.4 Preliminary Testing

The foundation for the specific test protocols and airborne emission measurements have been determined from testing performed to:

- Establish the required number of samples needed to statistically support the evaluation of emission reduction potentials of the alternative materials, equipment, and processes that may be evaluated;
- Provide a series of standardized emissions from standard mold and core packages.

It has been determined that nine replicate tests will provide a statistically significant sample for the purposes of evaluating the emission reductions from alternative materials, equipment, and processes. The results of the testing conducted in support of this conclusion is included in a

report entitled Evaluation of the Required Number of Replicate Tests to Provide Statistically Significant Air Emission Reduction Comparisons for the CERP Pre-production Foundry Test Program.

Appendix A of this report contains the Test Plan for Test Series DU.

Appendix B of this report contains detailed test results for Test Series DU.

1.5 Specific Test Plan and Objectives

This report contains the results of testing performed to assess the emission reductions, if any, of organic Hazardous Air Pollutants (HAPs) and Volatile Organic Compounds (VOCs) for an Advanced-Oxidant (AO) enriched water treated virgin greensand mold utilizing an 80/20 Western to Southern bentonite clay ratio and Seacoal. The core package consists of organic free sodium silicate cores so that the only known mold organic is Seacoal.

The results from test DU will provide comparative data to Pre-production Tests DA and DS, which are also AO enriched water tempered greensand molds with seacoal, but with bentonite clay ratios of 20/80 and 50/50 Western to Southern, respectively. Test DU will also provide an AO enriched water reference for comparison to three additional Test Series, DQ, DR, and DT, where tap water additions were substituted for AO enriched water in molds containing each of the three clay ratios listed above.

Table 1-1 provides a summary of the Test Plan. The detail of the approved test plan is included in Appendix A.

Table 1-1 Test Plan Summary

	Test Plan
Type of Process tested	80/20 Western to Southern Clays w/ AO Water
Test Plan Number	RE 1 00116 DU
Mold Type	Hand Rammed Greensand
Core Type	Organic Free Sodium Silicate
Casting Type	Eight-cavity bottom feed AFS step block
Baseline Comparison	Greensand
Number of molds poured	12
Test Dates	2/5/01, 2/7/01
Emissions Measured	20 organic HAPs and VOCs
Process Parameters Measured	Total Casting, Mold and Core Weights, Metallurgical data, Mold and Core Component Weights, % LOI (mold and core), % Clay, Stack Temperature, Stack Moisture Content, Stack Pressure, and Stack Volumetric Flow Rate

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2.0 Test Methodology

2.1 Description of Process and Testing Equipment

Figure 2-1 is a diagram of the Pre-Production Foundry process equipment.

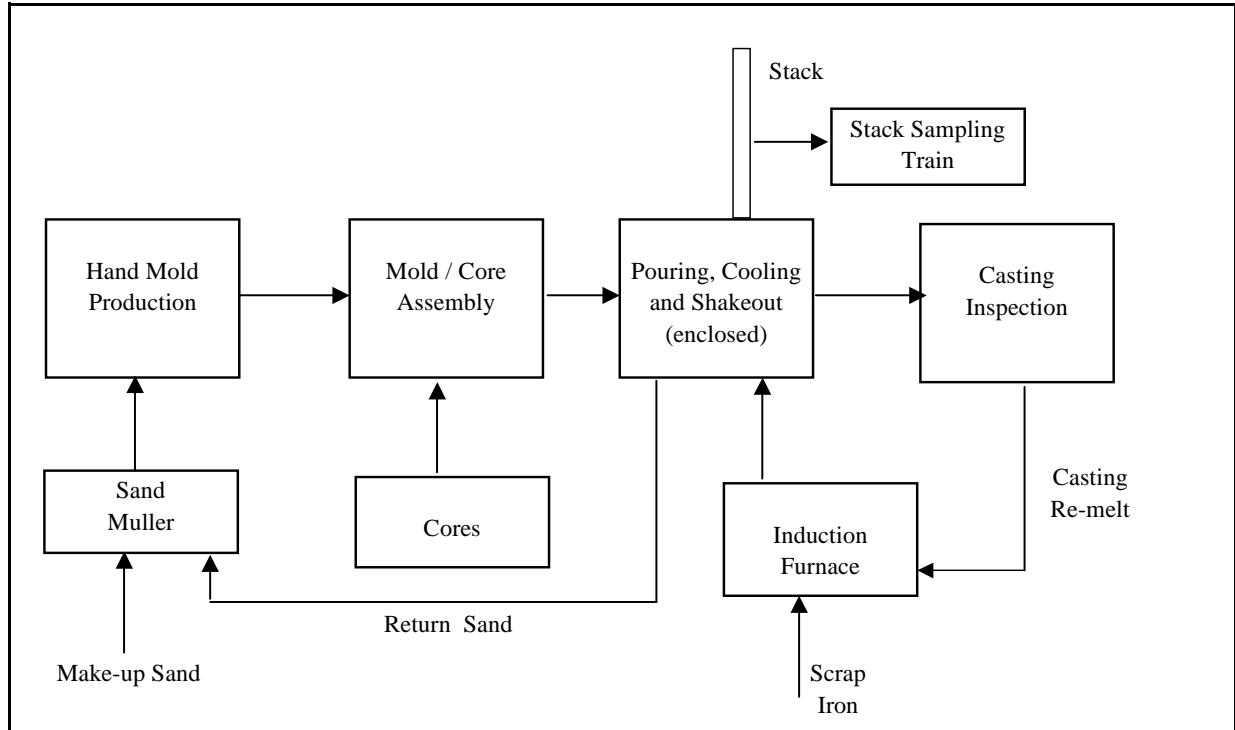


Figure 2-1 Pre-Production Foundry Layout Diagram

2.2 Description of Testing Program

The specific steps used in this sampling program are summarized below:

- 1. Test Plan Review and Approval:** The proposed test plan was reviewed by the Technikon staff and CTC Program Manager, and approved.
- 2. Mold, Core and Metal Preparation:** The molds and cores are prepared to a standard composition by the CERP production team. The cores are made either by hand (if sodium silicate) or blown by a Redford core blower, and relevant process data are collected. If new core processes are being tested, the cores are placed in new lake sand/clay/water molds. If new mold binder systems or processes are being evaluated, organic free sodium silicate step

cores are placed into the molds. Iron is melted in a 1000 lb. Ajax induction furnace (Model MFB-1000). The amount of metal melted is determined from the poured weight of the casting and the number of molds to be poured. The metal composition is prescribed by a metal composition worksheet. The weight of metal poured into each mold is recorded on the process data summary sheet.

- 3. Individual Sampling Events:** Replicate tests are performed on nine mold/core packages. The mold/core packages are placed into an enclosed test stand. Iron is poured through an opening in the top of the enclosure. The opening is closed as soon as pouring is completed. Continuous air samples are collected during the forty-five minute pouring and cooling process, during the fifteen minute shakeout of the mold, and for an additional fifteen minute period following shakeout. The total sampling time is seventy-five minutes.

The finished castings are cleaned and quality checks of the castings are performed. Additional tests may be required for new mold materials with the molding sand being recycled into new molds to evaluate the long-term effects on molding sand properties.

The weights of the molds, cores, seacoal additions, and binder are recorded for each mold on the Process Data Summary Sheet. In addition, the pouring temperature, number of cavities poured, the %LOI and the % clays of the mold before pouring and at shakeout, and the % LOI of the core are recorded on the Process Data Summary Sheet.

The unheated emission hood is ventilated at approximately 700 SCFM through a 12-inch diameter heated duct. Emissions samples are drawn from a sampling port located to ensure conformance with EPA Method 1. The tip of the probe is located in the centroid of the duct. The samples are collected at a constant rate in adsorption tubes.

- 4. Process Parameter Measurements:** Table 2-1 lists the process parameters that are monitored during each test. The analytical equipment and methods used are also listed.



Setting of Step Cores in Mold



*Pouring of Step Core Molds
Through Opening in
Collection Hood*



Castings on the Shake Out Deck



*Volatiles and
Condensables Sampling*

Table 2-1 Process Parameters Measured

Parameter	Analytical Equipment and Methods
Core Weight	Mettler PJ8000 Digital Scale (Gravimetric)
Mold Weight	Acme 4260 Crane Scale (Gravimetric)
Casting Weight	Westweigh PP2847 Platform Scale (Gravimetric)
Seacoal Weight	Toledo PAC-DPC-606050 balance (Gravimetric)
Binder Weight	Mettler PJ8000 Digital Scale (Gravimetric)
Volatiles	Mettler Pb302 Scale (AFS procedure 212-87-S)
LOI, % at mold and shakeout	Denver Instruments XE-100 Analytical Scale (AFS procedure 212-87-S)
Core LOI, %	Denver Instruments XE-100 Analytical Scale (AFS procedure 321-87-S)
Clay, % at mold and shakeout	Dietert 535A MB Clay Tester (AFS Procedure 210-89-S)
Metallurgical Parameters	
Pouring Temperature	Electro-Nite DT 260 (T/C immersion pyrometer)
Carbon/Silicon Fusion Temperature	Electro-Nite Datacast 2000 (Thermal Arrest)
Alloy Weights	Ohaus MP@
Mold Compactability	Dietert 319A Sand Squeezer (AFS procedure 221-87-S)
Carbon/Silicon	Baird Foundry Mate Optical Emissions Spectrometer

5. **Emissions Measurement:** The specific sampling and analytical methods used in the Pre-production Foundry tests are based on the US EPA reference methods shown in Table 2-2. The details of the specific testing procedures and their variance from the reference methods are included in the CERP Standard Operating Procedures.

Table 2-2 Sampling and Analytical Methods

Measurement Parameter	Test Method
Port location	EPA Method 1
Number of traverse points	EPA Method 1
Gas velocity and temperature	EPA Method 2
Gas density and molecular weight	EPA Method 3a
Gas moisture	EPA Method 4, gravimetric
HAPs concentration	EPA Method 18, TO11, NIOSH 2002*
VOCs concentration	EPA Method 18, 25A, TO11, NIOSH 2002*
Condensables	Technikon developed method**

* These methods were specifically modified to meet the testing objectives of the CERP Program.

** The Technikon condensables method is intended to provide a measure of the EPA Method 5 “back-half” determination.

6. **Data Reduction, Tabulation and Preliminary Report Preparation:** The analytical results of the emissions tests provide the mass of each analyte in the sample. The total mass of the analyte emitted is calculated by multiplying the mass of analyte in the sample times the ratio of total stack gas volume to sample volume. The total stack gas volume is calculated from the measured stack gas velocity and duct diameter, and corrected to dry standard conditions using the measured stack pressures, temperatures, gas molecular weight, and moisture content. The total mass of analyte is then divided by the weight of the casting poured to provide emissions data in pounds of analyte per ton of metal.

The results for each sampling event are included in Appendix B of this report. The results for each test are also averaged and are shown in Table 3-1.

7. **Report Preparation and Review:** The Preliminary Draft Report is reviewed by the Process Team and Emissions Team to ensure its completeness, consistency with the test plan, and adherence to the prescribed QA/QC procedures. Appropriate observations, conclusions and recommendations are added to the report to produce a Draft Report. The Draft Report is reviewed by the Vice President-Measurement Technologies, the Vice President-Operations, and the Technikon President. Comments are incorporated into a Final Report that is circulated for signatures and then distributed.

2.3 Quality Assurance and Quality Control (QA/QC) Procedures

Detailed QA/QC and data validation procedures for the process parameters, stack measurements, and laboratory analytical procedures are included in the CERP Standard Operating Procedures. In order to ensure the timely review of critical quality control parameters, the following procedures are followed:

- Immediately following the individual sampling events performed for each test, specific process parameters are reviewed by the Manager - Process Engineering to ensure that the parameters are maintained within the prescribed control ranges. Where data are not within the prescribed ranges, the Manager - Process Engineering and the Vice President-Operations determine whether the individual test samples should be invalidated or flagged for further analysis following review of the laboratory data.
- The source (stack) and sampling parameters, analytical results and corresponding laboratory QA/QC data are reviewed by the Emissions Measurement Team to confirm the validity of the data. The VP-Measurement Technologies reviews and approves the recommendation, if any, that individual sample data should be invalidated. Invalidated data are not used in subsequent calculations.

3.0 Test Results

The average emission results, in pounds per ton of metal poured, are presented in Table 3-1 for tests reported in this document. This table includes all the individual organic VOC compounds that comprise the selected analyte list for this test series, along with the corresponding sum of VOCs, sum of HAPs, and sum of POMs. The table also includes the TGOC (THC) as Propane and HC as Hexane. Figures 3-1 and 3-2 present the five emissions indicators, and individual HAP emissions data from Table 3-1 in graphical form. Appendix B contains the detailed data including the results for all analytes measured. Table 3-2 includes the averages of the key process and source parameters and the data target ranges. Detailed process and source data are presented in Appendix C.

Method 25A charts for the tests are included in Appendix D of this report. The charts are presented to show the VOC profile of emissions for each pour.

The validation log used to validate the laboratory data is maintained in the Technikon office.

Table 3-1 Test Series DU Average Results

COMPOUND / SAMPLE NUMBER	AVERAGE	STDEV
THC as Propane	2.41	0.326
HC as Hexane	0.611	0.043
Sum of VOCs	0.264	0.029
Sum of HAPs	0.245	0.027
Sum of POMs	0.021	0.009
Individual Organic HAPs		
Benzene	0.099	0.018
Toluene	0.055	0.007
Xylene (Total)	0.040	0.006
Naphthalene	0.021	0.009
Phenol	0.012	0.001
Acetaldehyde	0.007	0.001
Ethylbenzene	0.006	0.001
Aniline	0.004	<0.001
1-Methylnaphthalene	N/A	N/A
2-Methylnaphthalene	N/A	N/A
Other VOCs		
Octane	0.010	0.001
1,2,4-Trimethylbenzene	0.010	0.001
Other Analytes		
Condensables	0.372	0.077
Carbon Monoxide	4.56	0.239
Methane	1.08	0.150
Carbon Dioxide	26.8	2.93

I: Data was rejected based on data validation considerations.

All "Other Analytes" are not included in the sum of HAPs or VOCs.

N/A: Not Applicable; NT: Not Tested

Figure 3.1 Comparison of Average Emission Indicators From Test DU

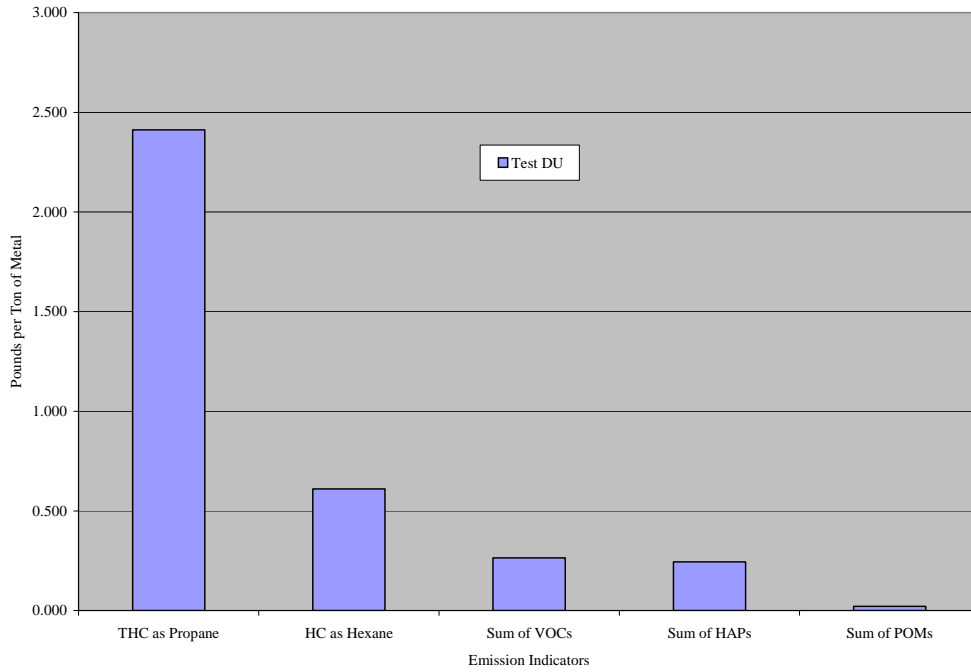


Figure 3-2 Comparison of Selected HAP Emissions from Test DU

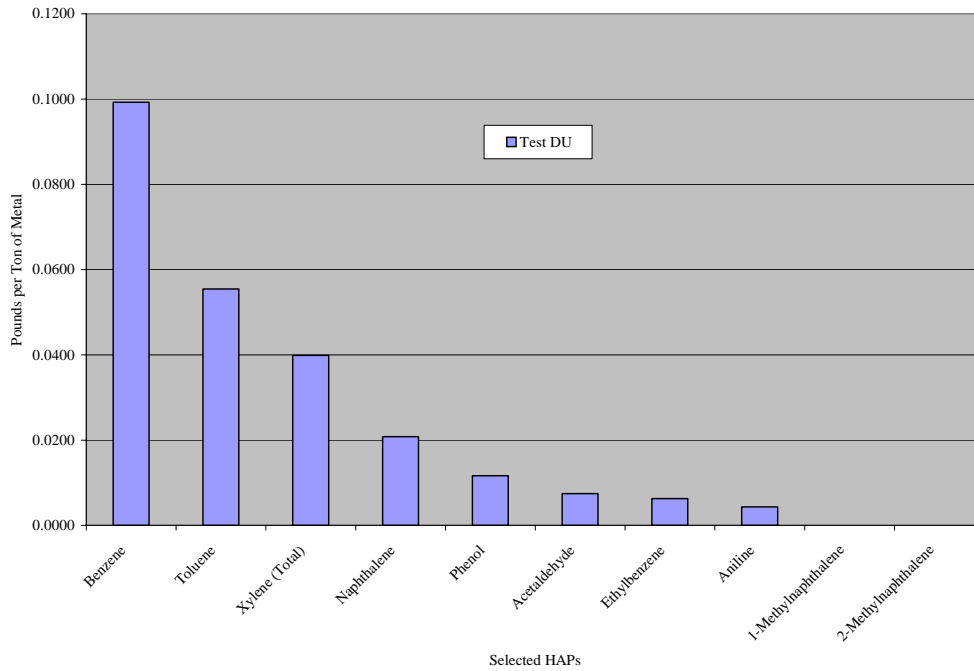


Table 3-2 Test Plan DU Average Process and Stack Parameters

Average Process and Stack Parameters	Average of DU	Target Range
Casting Metal Weight, lbs.	247	240 - 250
Total Mold Weight, lbs.	1320	1320 - 1420
Total Core Weight, lbs.	60.1	58 - 60
Compactability, %	45	45 - 51
Total Binder Weight, lbs	2.9	2.8 - 3.1
Core Ratio Resin (part I) to co-reactant (part II)	N/A	N/A
Greensand mold LOI, % @ 1800°F	5.0	4.7 - 5.3
MB Clay, %	7.1	6.5 - 7.5
Core LOI, % @ 1400°F	0.59	0.2 - 0.6
Greensand Mold Volatiles, % @ 900°F	0.91	N/A
Pour Temperature, °F	2631	2620 - 2640
Mold green compressive strength, psi	14.28	8 - 15
Core Resin Content, %	4.8	4.8 - 5.1
Water Type used in Mold	A/O	N/A
Average Stack Temperature, °F	110	110 ± 10
Total Moisture Content, %	1.51	N/A
Average Stack Velocity, ft./sec.	16.06	15 ± 2
Avg. Stack Pressure, in. Hg	29.96	N/A
Stack Flow Rate, scfm	692	700 ± 50

N/A: Not Applicable

4.0 Discussion of Results and Conclusions

The test plan for series DU included a total of twelve molds poured. The first three molds were used to condition virgin materials prior to collection of emissions from the subsequent nine molds. Results are reported for the nine post-conditioning molds.

A selected list of analytes was utilized in the determination of stack emissions from Test Series DU. The results for the sum of HAPs, VOCs, and POMs that are derived from this list can therefore only be compared to other test series that also utilize this same list. The sampling and analytical methodologies were the same for Tests DQ, DA, DR, DS, DT, and DU, so comparison of these six test series will allow the effects of advanced oxidation treatment to be evaluated compared to tap water for three different ratios of western/southern bentonite clays, 20/80, 50/50, and 80/20.

Two methods were employed to measure undifferentiated hydrocarbon emissions, TGOC (THC) as propane, performed in accordance with EPA Method 25A, and HC as hexane. EPA Method 25A, TGOC (as propane), is weighted to the detection of more volatile hydrocarbon species, beginning at C1 (methane), with results calibrated against a three-carbon alkane (propane). HC as hexane is weighted to detection of relatively less volatile compounds. This method detects hydrocarbon compounds in the alkane range between C6 and C16, with results calibrated against a six-carbon alkane (hexane).

In Test DU, hydrocarbons emissions determined by TGOC (THC) as propane were approximately four (4) times greater than hydrocarbons determined by the HC as hexane method, indicating the presence of a relatively larger amount of volatile species than semi-volatile. Of the individual analytes measured, benzene was found in the highest concentration, at 0.099 pounds per ton. At this concentration, benzene comprised approximately 38% of all VOCs and 40% of all HAPs. Toluene and Xylenes were the next most abundant target analytes found, at 0.055 and 0.040 pounds per ton respectively.

Observation of measured process parameters indicates that the tests were run within an acceptable range.

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APPENDIX A APPROVED TEST PLANS FOR TEST SERIES DU

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Series DU

Pre-Production Process Instructions

A. Experiment: A study to compare the impact of AO treated water on molds with the Western/Southern Bentonite ratio of 4:1. The mold will be made from virgin green sand mold materials consisting of Seacoal; bentonite in the ratio of 4:1; tempered with A/O water; poured at constant weight, surface area, sodium silicate core weight, and shape factor, a single batch turns test. This test is to be compared to reference tests DQ, DR, & DT, and comparative tests DA, & DS.

1. Mold sand: Virgin mix of Wexford W450 lake sand, Okie 90 silica sand, western and southern Bentonites in ratio of 4:1, seacoal, and **A/O water** per recipe.
2. Core: Step core made with Wedron 420 silica sand and 5% J.B. DeVeene Kleencast #1® sodium silicate core binder, gassed with CO₂.
3. Metal: Class 30-35 gray cast iron poured at 2630°F.

Caution: Observe all safety precautions attendant to these operations as delineated in the Pre-production operating and safety instruction manual.

4. The following test shall be conducted:
 - a. Sand batch: Single sand batch to be used for all 12 DU molds. All molds will be monitored in real time with the Airsense spectrometer and THC analyzer. Additionally sample tubes and condensables samples will be collected on each mold.
 - b. DU001: A/O conditioning; Virgin mix as described above, vented mold, reference JB DeVeene Kleencast #1® cores, **A/O water**.
 - c. DU002-DU003: A/O conditioning; Re-mulled, reconstituted sand, **A/O water**, vented mold, reference JB DeVeene Kleencast #1® cores.
 - d. DU004-DU012: The 80/20 western/southern bentonite comparative test; Re-mulled, reconstituted sand, **A/O water**, vented mold, reference JB DeVeene Kleencast #1® cores.

B. Sodium silicate Core

1. Core sand mixing.
 - a. Clean the core sand mixer.
 - b. Add 50 pounds of Wedron 420 silica sand to the running mixer.
 - c. Slowly pour 2.5 +/- 0.03 pounds of Sodium silicate resin into the sand. Distribute the resin as it is poured. Avoid pouring the resin on the plows or walls of the mixer or in one location or resin balling will occur preventing proper mixing.
 - d. Mix for three minutes after the resin is all in.
 - e. One batch will make about 6 cores.
 - f. Once per hour catch a clean 50-100 gm sample of the raw sand for the sand lab to perform a core LOI test. Place the sample in a clean bag and label with date and time.

2. Making step cores.

- a. Place the core box on a flat surface large open side up.
- b. Place about 2 inches of sand in the bottom of the step section. Firmly tamp the sand into the 1 inch diameter bottom using a ½ inch diameter rod.
- c. Place a few more inches of sand in the core box and compact it. Take care to avoid parting planes. Repeat until the box is full.
- d. Scrape off the excess. Remove the unused sand away from the gassing area.
- e. Place a gassing plate on the open end of the core box.
- f. Hold the plate down and gas the core for 20 seconds on each of the two gas holes with 20 psi CO₂ gas.
- g. Dry the cores for two hours at 250°F and allow cooling.
- h. Bag the cores in moisture proof bags for storage.
- i. Identify each bag by batch number.
- j. Record the date, batch number, the batch mix time, sand batch weight, resin weight, the gassing time, the gas pressure, individual dried core weight, good core count from each batch.
- k. The sand lab will determine the core LOI and the Resin Content LOI associated with each mold.

C. Sand preparation

1. Start up batch: make 1, DU001.

- a. Thoroughly clean the pre-production muller.
- b. Weigh and add 1600 +/- 50 pounds total new Wexford W450 Lakesand and Oklahoma 90 silica sand, per the recipe, to the running pre-production muller.
- c. Add 5 pounds of **A/O water** to the muller to suppress dust distributing it across the sand. Allow to mix for 1 minute.
- d. Add the clays in proportion to the sand weight per the **standardization mixture recipe** for this test slowly to the muller to allow them to be distributed throughout the sand mass.
- e. Dry mull for about 3 minutes to allow distribution and some grinding of the clays to occur.
- f. Split the batch into approximately equal sized portions.
- g. To each half-batch temper the sand-clay mixture slowly with **A/O water** to allow for distribution.
- h. After about 2 gallons of water have been added allow 30 seconds of mixing then start taking compatibility test samples. Grab sufficient sample at each compatibility test to fill a quart zip-lock bag. Label each bag and retain it.
- i. Based on each test add water incrementally to adjust the temper. Allow 1 minute of mixing. Retest. Repeat until the compatibility is in the range 45-51%.
- j. Discharge the sand into the mold half.
- k. Record the total sand mixed in the combined batch, the total of each type of clay added to the combined batch, the amount of water added to each half batch, the total

mix time on each half batch, the final compatibility and sand temperature at charge and discharge on each half batch, the time that the water was taken from its source, the time that each mold half was complete, the time the mold is delivered to the pour area, and the water type and temperature. Record the maximum muller current just prior to sand discharge.

- l.** The sand will be characterized for Methylene Blue Clay, Moisture content, Compatibility, Green Compression strength, 1800°F loss on ignition (LOI), and 900°F volatiles. Each volatile and LOI test requires a separate 50-gram sample from the collected sand.

Note: The sand lab data must be available and approved by the process engineer before the mold is committed to pouring.

- 2.** Re-mulling: make 11, DU002-DU012.

3.

- a.** Add all the sand from the previous mold to the muller including any sand previously mixed but not placed in the mold.
- b.** Add 5 pounds of **A/O water** to the muller to suppress dust distributing it across the sand. Allow to mix for 1 minute.
- c.** Add the clays and coals per the **re-bond recipe** slowly to the muller to allow them to be distributed throughout the sand mass. Follow the above procedure beginning at C.1.e.
- d.** The sand lab will sample the mold sand from each mold as it is being made and from the shaken out sand after it has been re-blended but before the additions are made. The three (3) “MOLD” samples will be taken from the initial muller discharge into the drag, from the last sand into the drag, and the last sand into the cope. The three (3) “SHAKEOUT” samples shall be taken from within the muller at three locations approximately 120 degrees apart. The sand will be tested for MB clay, compatibility, and moisture content, green compression strength, 1800oF LOI, 900°F volatile. Each volatile and LOI test requires a separate 50-gram sample from the collected sand. Report results associated with the mold (test number, DU0xx) from which it was taken.

Note: The sand lab data must be available from the blended shakeout sand and a recipe approved by the process engineer before the next mold is prepared. Additionally the sand lab data must be available and approved by the process engineer for the next mold’s sand before the mold is committed to pouring.

Note: Once each day, at the time when the shakeout sand has been re-blended the total sand shall be weighed and recorded. Extra sand shall be discarded to keep the batch weight at 1600 +/- 50 pounds.

D. Molding: Step block pattern.**1. Pattern preparation:**

- a.** Inspect and tighten all loose pattern and gating pieces.
- b.** Repair any damaged pattern or gating parts.

2. Making the green sand mold.

- a.** Lightly rub parting oil from a damp oil rag on the pattern particularly in the corners and recesses.

Caution: Do not pour gross amounts of parting oil on the pattern to be blown off with air. This practice will leave sufficient oil at the parting line to be adsorbed by the sand weakening it and the burning oil will be detected by the emission samplers.

- b.** Place 4 inches of loose sand on the pattern and ram all pockets and the perimeter tightly using only vertical strokes.

Caution: non- vertical ramming strokes will move blocks of compacted sand leaving voids which may cause the mold to fail. Do not ram all the sand to form a parting plane surface or the mold can fail. Add sand in increments of 4-6 inches of loose sand ramming tightly around the pattern.

- c.** When the rammed sand covers the pattern by 3 or more inches the sand can be rammed less tightly but still avoid lamination planes.
- d.** Level off the cope and drag mold surfaces opposite the pattern to minimize metal splatter and allow the mold to be fully supported.
- e.** Cut the pour basin smoothly to reduce the amount of sand prone to get washed down the sprue.
- f.** Remove the pattern, inspect and blow out the mold, and set the cores in the drag. Verify that the cores are fully set in their prints. The step cores will be flush with the parting line. If a piece of the mold is missing contact your supervision for a decision on the acceptability of the mold.
- g.** Vent the cope when required according to the test list above with $\frac{1}{4}$ vents according to the template.
- h.** Close the mold straight being careful not to crush anything.
- i.** Bolt the flask halves together and deliver the mold to the pouring area.
- j.** Weigh and record the closed unpoured mold, the core weight, and the sand weight by difference.

E. Emission hood:**1. Loading.**

- a.** Hoist the mold onto the shakeout deck within the emission hood.

- b. Close, seal, and lock the emission hood

2. Shakeout.

- a. After the cooling time prescribed in the emission test plan turn on the shakeout unit and run for the time prescribed in the emission test plan.
- b. Turn off the shakeout, open the hood, remove the flask with casting, and recover the sand from the pit.
- c. Weigh and record the metal poured.
- d. Place the recovered sand in its entirety back into the brushed out muller and blend for three (3) minutes. Take three (3) samples from the re-blended shakeout sand. The three (3) "SHAKEOUT" samples shall be taken from within the muller at three locations 120 degrees apart. The sand will be tested for MB clay, compatibility, and moisture content, green compression, 1800°F LOI, and 900°F volatile. Each volatile and LOI test requires a separate 50-gram sample from the collected sand. Report results associated with the mold (test number, DA0xx) from which it was taken.

F. Melting:

1. Initial charge:

- a. Charge the furnace according to the heat recipe.
- b. Place part of the steel scrap on the bottom, followed by carbon alloys, and the balance of the steel.
- c. Place a pig on top on top.
- d. Bring the furnace contents to the point of beginning to melt over a period of 1 hour at reduced power.
- e. Add the balance of the metallic under full power until all is melted and the temperature has reached 2600 to 2700°F.
- f. Slag the furnace and add the balance of the alloys.
- g. Raise the temperature of the melt to 2700°F and take a DataCast 2000 sample. The temperature of the primary liquidus (TPL) must be in the range of 2200-2350°F.
- h. Hold the furnace at 2500-2550°F until near ready to tap.
- i. When ready to tap raise the temperature to 2700°F and slag the furnace.
- j. Record all metallic and alloy additions to the furnace, tap temperature, and pour temperature. Record all furnace activities with an associated time.

2. Back charging.

- a. Back charge the furnace according to the heat recipe,
- b. Charge a few pieces of steel first to make a splash barrier, followed by the carbon alloys.
- c. Follow the above steps beginning with F.1.e.

3. Emptying the furnace.

- a.** Pig the extra metal only after the last emission measurement is complete to avoid contaminating the air sample.
- b.** Cover the empty furnace with ceramic blanket to cool.

G. Pouring:**1.** Preheat the ladle.

- a.** Tap 400 pounds more or less of 2700°F metal into the cold ladle.
- b.** Casually pour the metal back to the furnace.
- c.** Cover the ladle.
- d.** Reheat the metal to 2780 +/- 20°F.
- e.** Tap 450 pounds of iron into the ladle while pouring inoculating alloys onto the metal stream near its base.
- f.** Cover the ladle to conserve heat.
- g.** Move the ladle to the pour position, open the emission hood pour door and wait until the metal temperature reaches 2630 +/- 10°F.
- h.** Commence pouring keeping the sprue full.
- i.** Upon completion close the hood door, return the extra metal to the furnace, and cover the ladle.

Steven Knight
Process Engineering Manager
12/12/00

PRE-PRODUCTION DU SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
2/5/01											Samples to Clayton Lab.
EVENT 4											Unless noted.
AIRSENSE	DU00401										TOTAL
THC	DU00402	X									TOTAL
NIOSH 1500 Mod.	DU00403		1						200	1	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU00404		1						200	2	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU00405				1				0	2	QC-Manifold Blank
Excess									200	3	Excess
Excess									200	4	Excess
GAS, CO + CO2	DU00406		1						60	5	BAG Sample to Airtoxics Lab.
TO11	DU00407		1						500	6	Total
TO11	DU00408				1				0	6	QC - Manifold Blank
Excess									500	7	Excess
NIOSH 2002	DU00409		1						750	8	TOTAL (SKC 226-15)
NIOSH 2002	DU00410				1				0	8	QC- Manifold Blank (SKC 226-15)
Excess									750	9	Excess
Excess									1000	10	Excess
Excess									750	11	Excess
Moisture									500	12	EPA Method 4
Excess									2500	13	
PUF	DU004		1						15L		Sample using opposite port

PRE-PRODUCTION DU SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
2/5/01											Samples to Clayton Lab.
EVENT 5											Unless noted.
AIRSENSE	DU00501										TOTAL
THC	DU00502	X									TOTAL
NIOSH 1500 Mod.	DU00503		1						200	1	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU00504		1						200	2	TOTAL (Orbo 32 SM)
Excess									200	3	Excess
Excess									200	4	Excess
GAS, CO + CO2	DU00505		1						60	5	BAG Sample to Airtoxics Lab.
TO11	DU00506		1						500	6	TOTAL
TO11	DU00507					1			500	6	TOTAL
Excess									500	7	Excess
NIOSH 2002	DU00508		1						750	8	TOTAL (SKC 226-15)
Excess									750	9	Excess
Excess									1000	10	Excess
Excess									750	11	Excess
Moisture									500	12	EPA Method 4
Excess									2500	13	
PUF	DU005		1						15L		Sample using opposite port

PRE-PRODUCTION DU SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
2/5/01											Samples to Clayton Lab.
EVENT 6											Unless noted.
AIRSENSE	DU00601										TOTAL
THC	DU00602	X									TOTAL
NIOSH 1500 Mod.	DU00603		1						200	1	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU00604			1					200	2	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU00605		1						200	3	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU00606			1					200	4	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU00607				1						QC - (Orbo 32 SM)
GAS, CO + CO2	DU00608		1						60	5	BAG Sample to Airtoxics Lab.
TO11	DU00609		1						500	6	TOTAL
TO11	DU00610			1					500	7	TOTAL
TO11	DU00611				1						QC
NIOSH 2002	DU00612		1						750	8	TOTAL (SKC 226-15)
NIOSH 2002	DU00613			1					750	9	TOTAL (SKC 226-15)
NIOSH 2002	DU00614				1						QC - (SKC 226-15)
Excess									1000	10	Excess
Excess									750	11	Excess
Moisture									500	12	EPA Method 4
Excess									2500	13	
PUF	DU006		1						15L		Sample using opposite port

PRE-PRODUCTION DU SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
2/6/01											Samples to Clayton Lab.
EVENT 7											Unless noted.
AIRSENSE	DU00701										TOTAL
THC	DU00702	X									TOTAL
NIOSH 1500 Mod.	DU00703		1						200	1	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU00704		1						200	2	TOTAL (Orbo 32 SM)
Excess									200	3	Excess
Excess									200	4	Excess
GAS, CO + CO2	DU00705		1						60	5	BAG Sample to Airtoxics Lab.
TO11	DU00706		1						500	6	TOTAL
Excess									500	7	Excess
NIOSH 2002	DU00707		1						750	8	TOTAL (SKC 226-15)
Excess									750	9	Excess
Excess									1000	10	Excess
Excess									750	11	Excess
Moisture									500	12	EPA Method 4
Excess									2500	13	
PUF	DU007		1						15L		Sample using opposite port

PRE-PRODUCTION DU SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
2/6/01											Samples to Clayton Lab.
EVENT 8											Unless noted.
AIRSENSE	DU00801										TOTAL
THC	DU00802	X									TOTAL
NIOSH 1500 Mod.	DU00803		1						200	1	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU00804		1						200	2	TOTAL (Orbo 32 SM)
Excess									200	3	Excess
Excess									200	4	Excess
GAS, CO + CO2	DU00805		1						60	5	BAG Sample to Airtoxics Lab.
TO11	DU00806		1						500	6	TOTAL
Excess									500	7	Excess
NIOSH 2002	DU00807		1						750	8	TOTAL (SKC 226-15)
Excess									750	9	Excess
Excess									1000	10	Excess
Excess									750	11	Excess
Moisture									500	12	EPA Method 4
Excess									2500	13	
PUF	DU008		1						15L		Sample using opposite port

PRE-PRODUCTION DU SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
2/6/01											Samples to Clayton Lab.
EVENT 9											Unless noted.
AIRSENSE	DU00901										TOTAL
THC	DU00902	X									TOTAL
NIOSH 1500 Mod.	DU00903		1						200	1	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU00904		1						200	2	TOTAL (Orbo 32 SM)
Excess									200	3	Excess
Excess									200	4	Excess
GAS, CO + CO2	DU00905		1						60	5	BAG Sample to Airtoxics Lab.
TO11	DU00906		1						500	6	TOTAL
Excess									500	7	Excess
NIOSH 2002	DU00907		1						750	8	TOTAL (SKC 226-15)
Excess									750	9	Excess
Excess									1000	10	Excess
Excess									750	11	Excess
Moisture									500	12	EPA Method 4
Excess									2500	13	
PUF	DU009		1						15L		Sample using opposite port

PRE-PRODUCTION DU SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
2/7/01											Samples to Clayton Lab.
EVENT 10											Unless noted.
AIRSENSE	DU01001										TOTAL
THC	DU01002	X									TOTAL
NIOSH 1500 Mod.	DU01003		1						200	1	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU01004			1					200	2	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU01005		1						200	3	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU01006			1					200	4	TOTAL (Orbo 32 SM)
GAS, CO + CO2	DU01007		1						60	5	BAG Sample to Airtoxics Lab.
TO11	DU01008		1						500	6	TOTAL
TO11	DU01009			1					500	7	TOTAL
NIOSH 2002	DU01010		1						750	8	TOTAL (SKC 226-15)
NIOSH 2002	DU01011			1					750	9	TOTAL (SKC 226-15)
Excess									1000	10	Excess
Excess									750	11	Excess
Moisture									500	12	EPA Method 4
Excess									2500	13	
PUF	DU010		1						15L		Sample using opposite port

PRE-PRODUCTION DU SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
2/7/01											Samples to Clayton Lab.
EVENT 11											Unless noted.
AIRSENSE	DU01101										TOTAL
THC	DU01102	X									TOTAL
NIOSH 1500 Mod.	DU01103		1						200	1	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU01104		1						200	2	TOTAL (Orbo 32 SM)
Excess									200	3	Excess
Excess									200	4	Excess
GAS, CO + CO2	DU01105		1						60	5	BAG Sample to Airtoxics Lab.
TO11	DU01106		1						500	6	TOTAL
Excess									500	7	Excess
NIOSH 2002	DU01108		1						750	8	TOTAL (SKC 226-15)
Excess									750	9	Excess
Excess									1000	10	Excess
Excess									750	11	Excess
Moisture									500	12	EPA Method 4
Excess									2500	13	
PUF	DU011		1						15L		Sample using opposite port

PRE-PRODUCTION DU SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
2/7/01											Samples to Clayton Lab.
EVENT 12											Unless noted.
AIRSENSE	DU01201										TOTAL
THC	DU01202	X									TOTAL
NIOSH 1500 Mod.	DU01203		1						200	1	TOTAL (Orbo 32 SM)
NIOSH 1500 Mod.	DU01204		1						200	2	TOTAL (Orbo 32 SM)
Excess									200	3	Excess
Excess									200	4	Excess
GAS, CO + CO2	DU01205		1						60	5	BAG Sample to Airtoxics Lab.
TO11	DU01206		1						500	6	TOTAL
Excess									500	7	Excess
NIOSH 2002	DU01207		1						750	8	TOTAL (SKC 226-15)
Excess									750	9	Excess
Excess									1000	10	Excess
Excess									750	11	Excess
Moisture									500	12	EPA Method 4
Excess									2500	13	
PUF	DU012		1						15L		Sample using opposite port

NIOSH 1500 Mod.	DU01208						X		200		BOTTLE - Mix 1A (Orbo 32 SM)
NIOSH 1500 Mod.	DU01209						X		200		BOTTLE - Mix 1A (Orbo 32 SM)

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APPENDIX B EMISSION TEST RESULTS FOR TEST SERIES DU

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Test Plan DU Individual Test Results – Lbs./Ton Metal

POMs	HAPS	COMPOUND / SAMPLE NUMBER	DU004 2/5/01	DU005 2/5/01	DU006 2/5/01	DU007 2/6/01	DU008 2/6/01	DU009 2/6/01	DU010 2/7/01	DU011 2/7/01	DU012 2/7/01	Average	STDEV
		TGOC (THC) as Propane	2.83E+00	2.85E+00	2.75E+00	2.36E+00	2.38E+00	2.23E+00	2.24E+00	2.08E+00	1.98E+00	2.41E+00	3.26E-01
		HC as Hexane	6.26E-01	6.61E-01	6.68E-01	5.79E-01	6.04E-01	5.33E-01	6.14E-01	5.75E-01	6.35E-01	6.11E-01	4.32E-02
		Sum of VOCs	2.78E-01	3.06E-01	3.03E-01	2.70E-01	2.69E-01	2.46E-01	2.52E-01	2.25E-01	2.29E-01	2.64E-01	2.93E-02
		Sum of HAPs	2.57E-01	2.85E-01	2.81E-01	2.51E-01	2.48E-01	2.29E-01	2.32E-01	2.07E-01	2.12E-01	2.45E-01	2.72E-02
		Sum of POMs	ND	1.89E-02	2.18E-02	1.93E-02	2.40E-02	2.20E-02	2.36E-02	2.09E-02	3.65E-02	2.08E-02	9.39E-03
			Individual HAPs and VOCs										
	z	Benzene	1.22E-01	1.20E-01	1.14E-01	1.06E-01	9.82E-02	9.51E-02	8.68E-02	7.75E-02	7.42E-02	9.93E-02	1.75E-02
	z	Toluene	6.07E-02	6.45E-02	6.36E-02	5.72E-02	5.66E-02	5.00E-02	5.35E-02	4.70E-02	4.59E-02	5.54E-02	6.87E-03
	z	Xylene (Total)	4.44E-02	4.77E-02	4.84E-02	4.01E-02	3.90E-02	3.52E-02	3.80E-02	3.31E-02	3.28E-02	3.99E-02	5.88E-03
x	z	Naphthalene	ND	1.89E-02	2.18E-02	1.93E-02	2.40E-02	2.20E-02	2.36E-02	2.09E-02	3.65E-02	2.08E-02	9.39E-03
	z	Phenol	1.07E-02	1.36E-02	1.41E-02	1.09E-02	1.21E-02	1.03E-02	1.11E-02	1.13E-02	1.08E-02	1.16E-02	1.35E-03
		Octane	1.13E-02	1.10E-02	1.13E-02	1.03E-02	1.07E-02	8.80E-03	1.05E-02	9.00E-03	8.79E-03	1.02E-02	1.04E-03
		1,2,4-Trimethylbenzene	1.03E-02	1.09E-02	1.14E-02	8.98E-03	9.87E-03	8.66E-03	9.54E-03	8.29E-03	7.68E-03	9.52E-03	1.23E-03
	z	Acetaldehyde	7.73E-03	8.87E-03	7.22E-03	6.65E-03	6.98E-03	6.71E-03	8.57E-03	7.52E-03	6.78E-03	7.45E-03	8.09E-04
	z	Ethylbenzene	7.16E-03	7.67E-03	7.69E-03	5.80E-03	6.45E-03	5.23E-03	6.12E-03	5.40E-03	5.18E-03	6.30E-03	1.00E-03
	z	Aniline	4.20E-03	3.59E-03	4.07E-03	4.46E-03	4.84E-03	4.48E-03	4.32E-03	4.73E-03	I	4.34E-03	3.95E-04
x	z	1-Methylnaphthalene	ND	ND	ND	ND	ND	ND	ND	ND	ND	N/A	N/A
x	z	2-Methylnaphthalene	ND	ND	ND	ND	ND	ND	ND	ND	ND	N/A	N/A
			Other Analytes										
		Condensables	4.84E-01	4.72E-01	3.67E-01	4.29E-01	3.15E-01	3.29E-01	3.72E-01	3.28E-01	2.54E-01	3.72E-01	7.65E-02
		Carbon Monoxide	4.15E+00	4.70E+00	4.49E+00	4.73E+00	4.79E+00	4.64E+00	4.82E+00	4.53E+00	4.22E+00	4.56E+00	2.39E-01
		Methane	1.26E+00	1.29E+00	1.16E+00	1.13E+00	1.09E+00	1.04E+00	9.81E-01	9.15E-01	8.44E-01	1.08E+00	1.50E-01
		Carbon Dioxide	3.31E+01	2.86E+01	2.68E+01	2.79E+01	2.63E+01	2.60E+01	2.41E+01	2.37E+01	2.42E+01	2.68E+01	2.93E+00
		Ethane	ND	ND	ND	ND	ND	ND	ND	ND	ND	N/A	N/A
		Propane	ND	ND	ND	ND	ND	ND	ND	ND	ND	N/A	N/A
		Isobutane	ND	ND	ND	ND	ND	ND	ND	ND	ND	N/A	N/A
		Butane	ND	ND	ND	ND	ND	ND	ND	ND	ND	N/A	N/A
		Neopentane	ND	ND	ND	ND	ND	ND	ND	ND	ND	N/A	N/A
		Isopentane	ND	ND	ND	ND	ND	ND	ND	ND	ND	N/A	N/A
		Pentane	ND	ND	ND	ND	ND	ND	ND	ND	ND	N/A	N/A

I: Data was rejected based on data validation considerations. All "Other Analytes" are not included in the sum of HAPs or VOCs.

N/A: Not Applicable; ND: Not Detected

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**APPENDIX C PROCESS AND SOURCE DATA FOR TEST SERIES
DU**

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Description	DU001	DU002	DU003	DU004	DU005	DU006	DU007	DU008	DU009	DU010	DU011	DU012	Averages All	Averages For Report
	2/2/01	2/2/01	2/2/01	2/5/01	2/5/01	2/5/01	2/6/01	2/6/01	2/6/01	2/7/01	2/7/01	2/7/01		
Casting Metal Weight, lbs.	249	241	245.5	236.5	250	245.5	249	246.5	253.5	246	249	249.5	247	247
Total Mold Weight, lbs.	1321	1304	1311	1311	1324	1351	1295	1311	1315	1311	1333	1331	1318	1320
Total Core Weight, lbs.	60.77	60.87	61.00	60.96	60.90	60.92	60.36	61.01	60.30	61.03	61.66	61.46	60.94	60.96
Compatibility, %	50	53	54	50	44	44	44	38	44	50	46	45	47	45
Total Binder Weight, lbs	2.890	2.897	2.904	2.902	2.899	2.899	2.873	2.904	2.870	2.905	2.935	2.925	2.900	2.901
No. Cavities Poured	8	8	8	8	8	8	8	8	8	8	8	8	8	8
LOI, % (at mold)	5.77	5.08	4.98	5.08	5.21	5.06	4.93	5.08	4.81	5.00	4.77	4.81	5.05	4.97
LOI, % (at shakeout)	5.07	5.13	5.17	4.94	4.75	4.76	4.36	4.32	4.76	4.30	4.20	3.90	4.64	4.48
Clays, % (at mold)	8.09	6.66	7.18	6.92	7.05	7.05	7.57	7.44	6.92	6.92	6.79	7.31	7.16	7.11
Clays, % (at shakeout)	6.40	6.27	5.74	5.61	5.61	5.48	6.01	6.14	6.01	6.01	5.74	6.14	5.93	5.86
LOI, % (Cores) 1400°F	0.53	0.55	0.44	0.60	0.59	0.66	0.54	0.57	0.58	0.65	0.54	0.62	0.57	0.59
Volatiles, % (at mold) avg. 900°F	1.34	1.12	1.12	1.06	1.02	0.92	0.92	0.88	0.78	0.88	0.80	0.90	0.98	0.91
Volatiles, % (at shakeout) avg. 900°F	1.38	1.02	0.90	0.98	0.98	0.74	0.82	0.74	0.70	0.70	0.72	0.50	0.85	0.76
Pouring Temperature, °F	2634	2633	2632	2624	2636	2633	2631	2623	2632	2631	2635	2633	2631	2631
Mold Strength, psi	8.66	9.50	10.33	10.71	11.34	14.04	13.88	15.20	15.30	15.60	15.94	16.53	13.09	14.28
Core Resin Content, %	4.76	4.76	4.76	4.76	4.76	4.76	4.76	4.76	4.76	4.76	4.76	4.76	4.76	4.76
Water Type used in Mold	A/O	A/O	A/O	A/O	A/O	A/O	A/O	A/O	A/O	A/O	A/O	A/O	A/O	A/O
Total Clays - added, lbs/mold	90.88	-	11.20	6.40	8.80	8.00	8.00	5.60	4.48	7.20	8.00	8.96	15.23	7.27
Seacoal - added, lbs/mold	87.04	-	3.20	4.32	3.36	2.88	3.20	4.32	3.36	4.48	3.85	5.12	11.38	3.88
Lignite - added, lbs/mold	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Soda Ash - added, gms/mold	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Mold Sand Acidity, pH	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND
Average Stack Temperature, °F	-	-	-	105	114	113	110	110	112	106	108	109	110	110
Total Moisture Content, %	-	-	-	1.58	1.92	1.94	1.58	1.46	1.45	1.31	1.20	1.11	1.51	1.51
Average Stack Velocity, ft./sec.	-	-	-	16.1	16.0	16.0	16.0	16.0	16.1	15.9	16.2	16.2	16.06	16.06
Avg. Stack Pressure, in. Hg	-	-	-	30.16	30.12	30.02	29.89	29.90	29.82	29.89	29.93	29.89	29.96	29.96
Stack Flow Rate, scfm	-	-	-	705	685	685	687	688	686	691	702	702	692	692

Binder fraction = (binder (lbs))/(sand + binder (lbs)). Binder fraction x total core weight used in mold = Total Binder Weight

Example: $(5.0 / (100 + 5.0)) = 0.0476$. 0.0476 (binder fraction) x 60.77 (total core wt.) = 2.890 (lbs binder per mold).

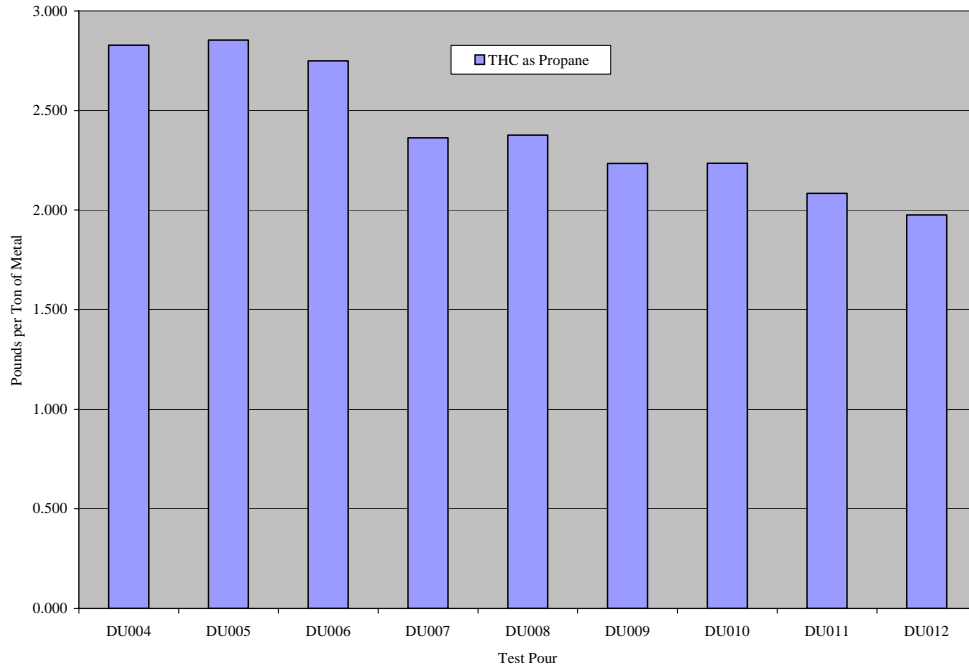
NOTE 1: Test pours DU001 through DU003 were used for conditioning the sand and no stack data was taken. **NOTE 2:** Test pours in bold type will be used for the report.

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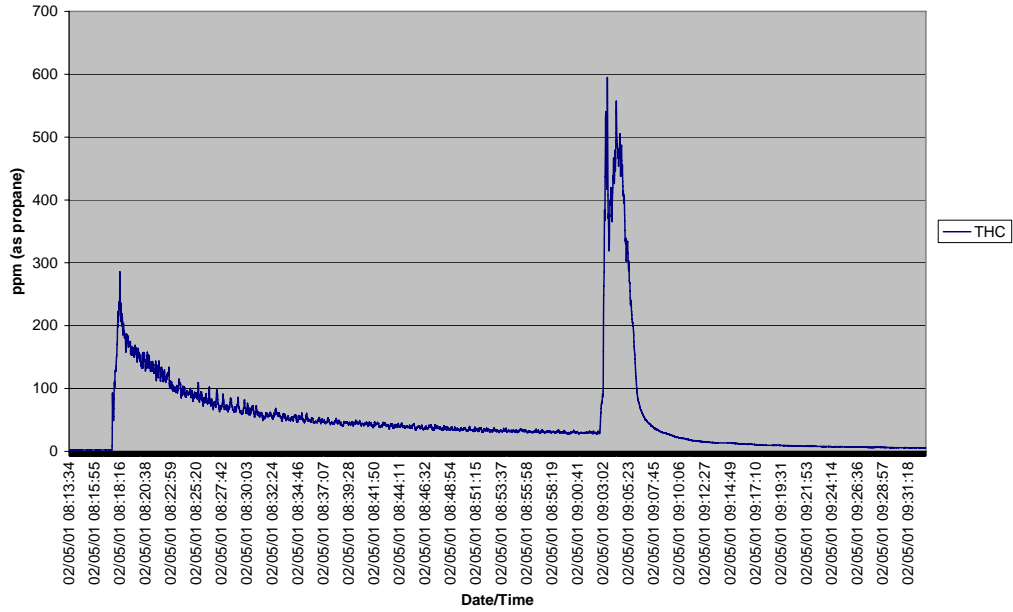
**APPENDIX D US EPA METHOD 25A CHARTS FOR TEST
SERIES DU**

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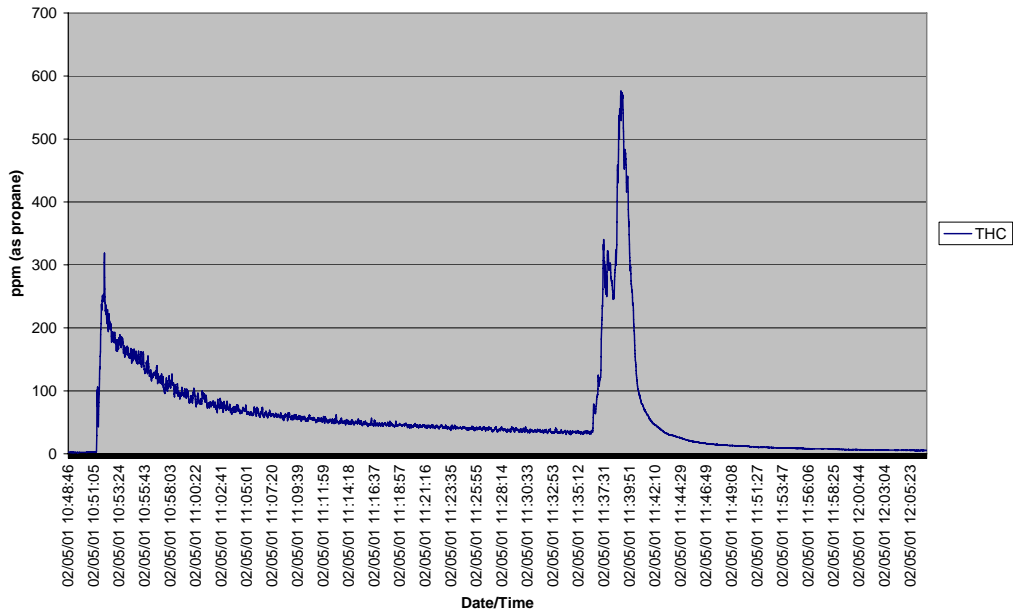
Test Series DU



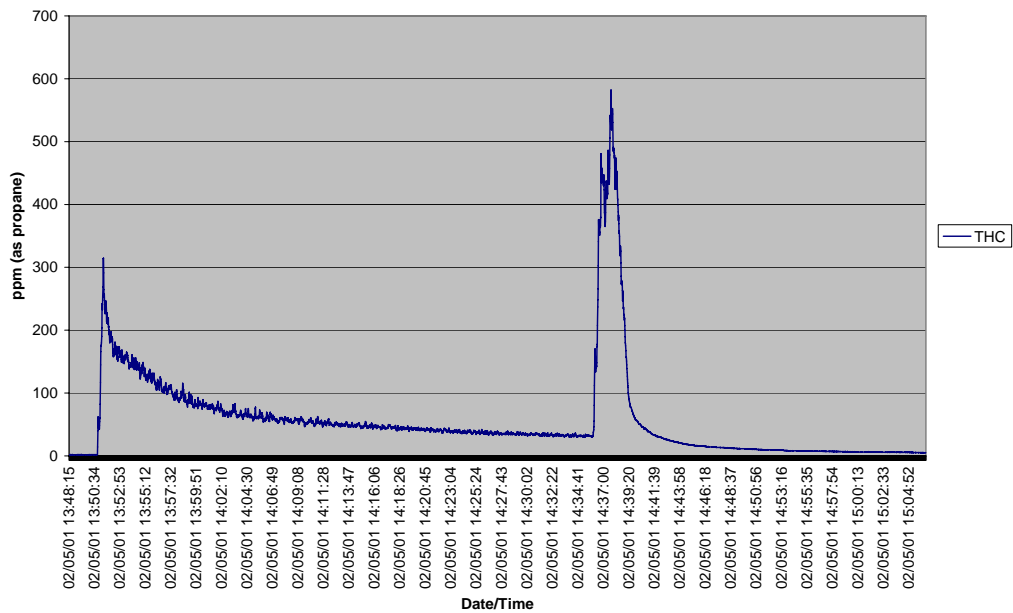
DU 004



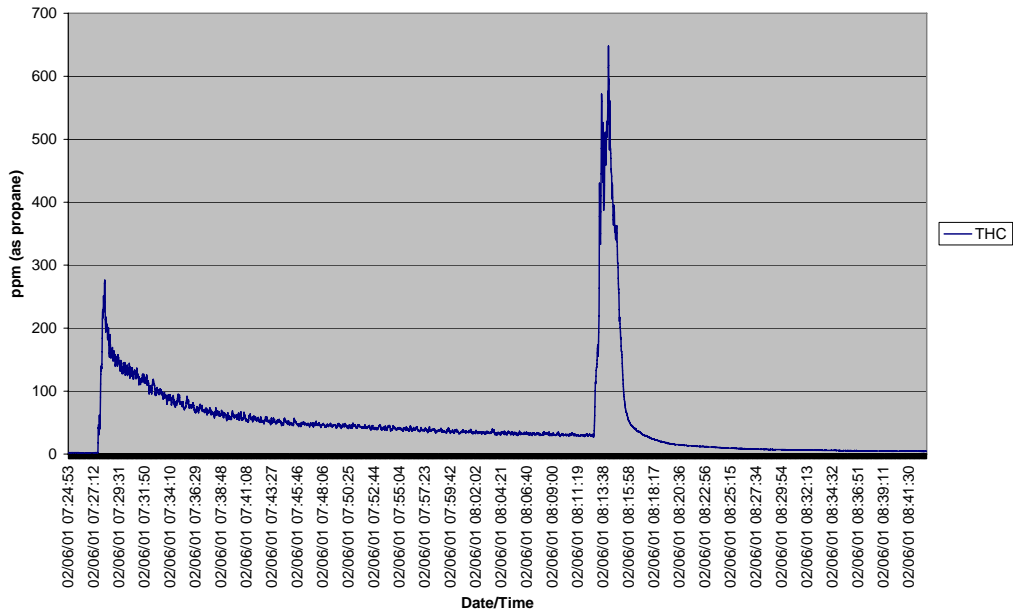
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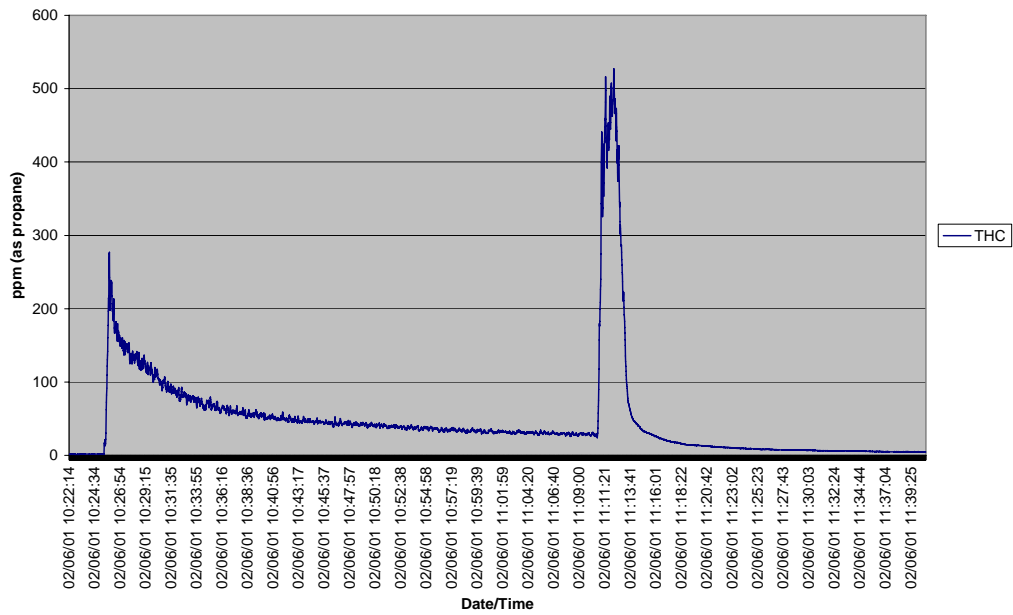
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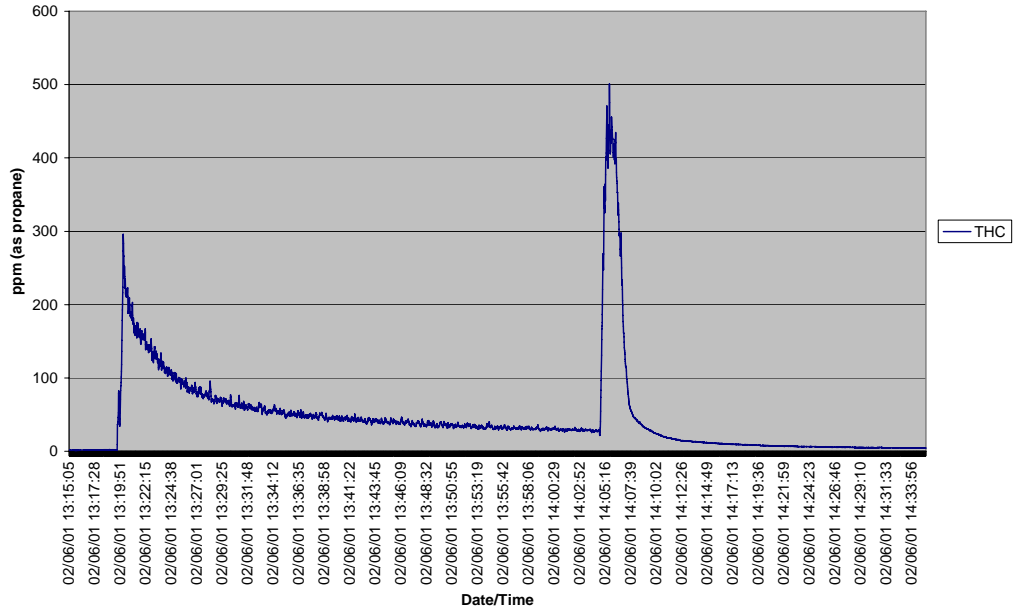
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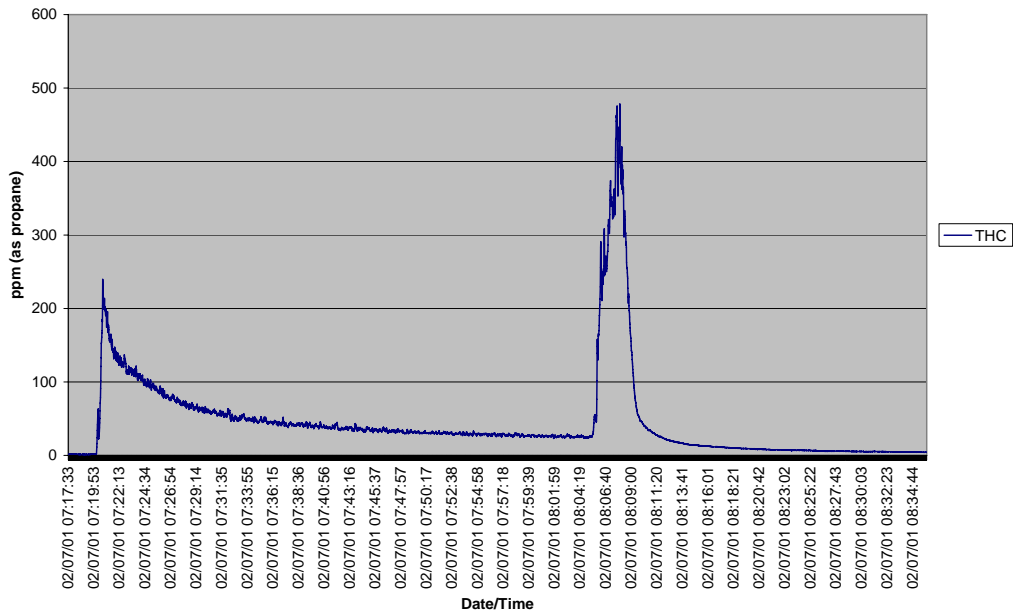
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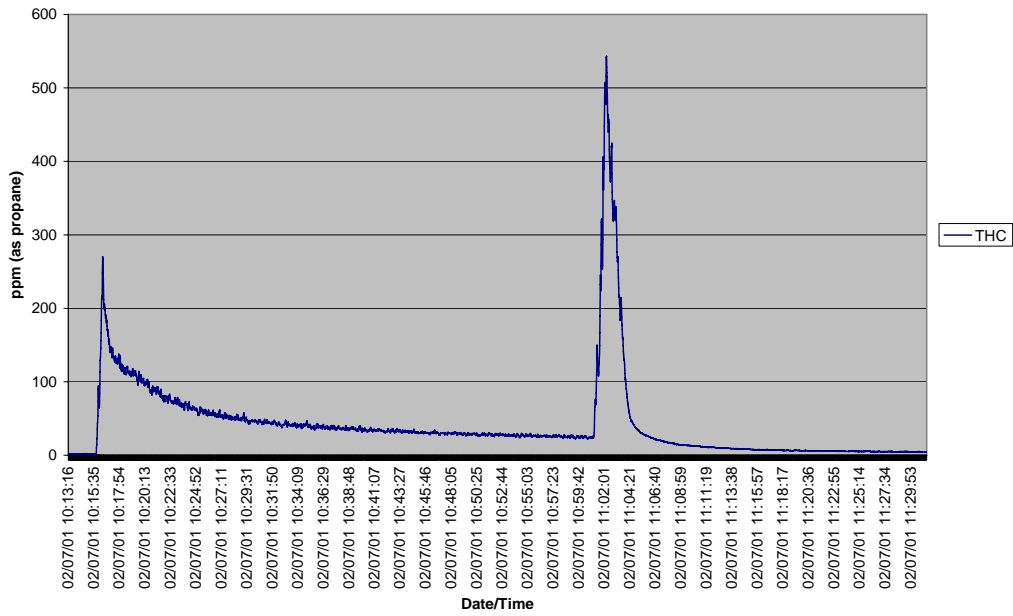
DU 009



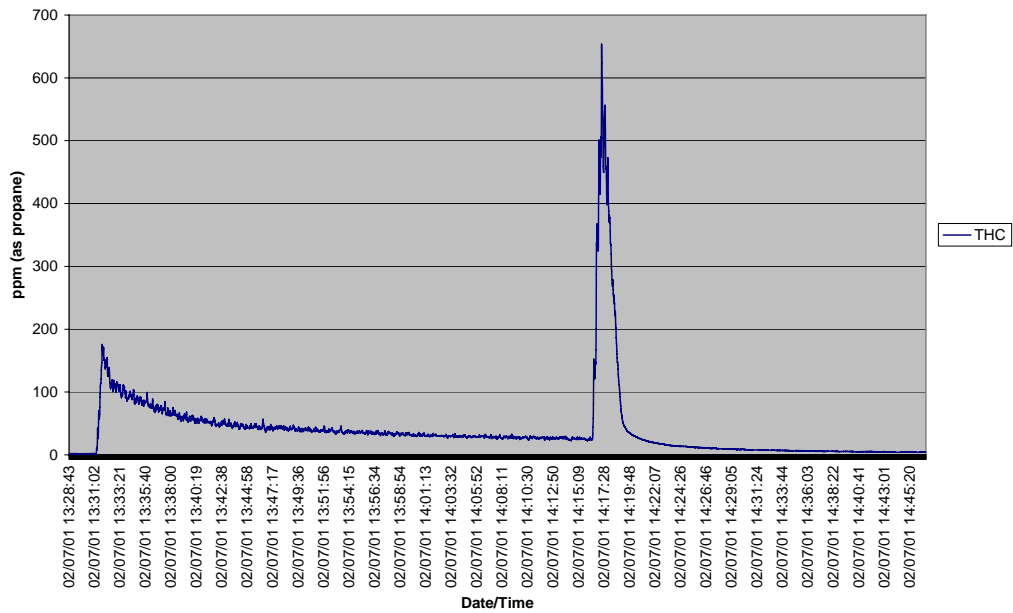
DU 010



DU 011



DU 012



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APPENDIX E LISTING OF SUPPORT DOCUMENTS

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Listing of Support Documents

The following documents contain specific test results, procedures, and documentation used in support of this Test Plan

1. Casting Emission Reduction Program – Foundry Product Testing Guide: Reducing Emissions by Comparative Testing, May 4, 1998.
2. Technikon Emissions Testing and Analytical Testing Standard Operating Procedures.
3. Emission Baseline Test Results for the CERP Pre-Production Foundry Processes.
4. Evaluation of the Required Number of Replicate Tests to Provide Statistically Significant Air Emission Reduction Comparisons for the CERP Pre-Production Foundry Test Program.

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APPENDIX F GLOSSARY

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GLOSSARY

ND	Non Detect, No Data
NT	Not Tested - Lab testing was not done on this analyte.
HC as Hexane	Calculated by the summation of all area between elution of Hexane through the elution of Hexadecane. The quantity of HC is performed against a five-point calibration curve of Hexane by dividing the total area count from C6 through C16 to the area of Hexane from the initial calibration curve.
POM	Polycyclic Organic Matter (POM) including Naphthalene and other compounds that contain more than one benzene ring and have a boiling point greater than or equal to 100 degrees Celsius.
LOI	Loss of Ignition. LOI represents the change in weight of a sample expressed as % of the original dry weight as a consequence of combustion in air at the test temperature of 1400°F