Product Test:
Pouring, Cooling, Shakeout of Coated Phenolic Urethane Core (Greensand with Parting Spray, Iron)

Technikon # 8011-001 GC

November 2004
(Released for public distribution – July 2007)

Prepared by:
Technikon, LLC
5301 Price Avenue ▼ McClellan, CA 95652 ▼ (916) 929-8001
www.technikonllc.com

for

Hill & Griffith Company
1085 Summer Street
Cincinnati, OH 45204

this page intentionally left blank

Product Test:
Pouring, Cooling, Shakeout of
Coated Phenolic Urethane Core
(Greensand with Parting Spray, Iron)

Technikon # 8011-001 GC

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

Research Chemist	*// Original Signed //* Carmen Hornsby	Date
Process Engineering Manager	*// Original Signed //* Steven M. Knight	Date
V.P. Measurement Technology	*// Original Signed //* Clifford R. Glowacki, CIH	Date
V.P. Operations	*// Original Signed //* George Crandell	Date
President	*// Original Signed //* William Walden	Date

this page intentionally left blank

Table of Contents

List of Figures

List of Tables

Appendices

Executive Summary

This report contains the results of emission testing to evaluate the pouring, cooling, and shakeout emissions from Test GC, a coated, phenolic urethane core with H & G Vein Away HT® in a cellulose and starch greensand using a graphite parting spray as a seacoal replacement. Test GC is a comprehensive test designed to reduce core emissions by using the anti-veining material Vein Away HT® and reduce greensand emissions by replacing the seacoal normally distributed throughout the sand with a mold/metal interface coating of graphite carried by the pattern release agent. Test GC emissions will be compared to the combination baseline Test GB, a coated phenolic urethane core without anti-veining materials in greensand and with standard seacoal. Test GC castings will be compared to Test FQ without seacoal. Test FQ has the same core material as Test GB. FQ's greensand has no seacoal so that the influence of the graphite in Test GC can be compared. Test GB castings are also included for completeness. All testing was conducted by Technikon, LLC in its research foundry. The emissions results are reported in both pounds of analyte per pound of binder and pounds of analyte per ton of metal poured.

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, and binder; Loss on Ignition (LOI) values for the mold prior to the test; 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 runs. Samples were collected and analyzed for sixty-eight (68) target compounds using procedures based on US EPA Method 18. Continuous monitoring of the Total Gaseous Organic Concentration (TGOC) of the emissions was conducted according to US EPA Method 25A. Carbon monoxide and carbon dioxide where monitored according to US EPA Methods 10 and 3A, respectively.

The mass emission rate of each parameter or target compound was calculated using the monitoring data or the laboratory analytical results, the measured source data, weight of binder, 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. The individual isomer results are available in Appendix B of this report. Other "emissions indicators," in addition to the TGOC 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 Target Analytes" is based on the sum of the individual Target Analytes measured and includes selected HAPs and selected 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 selected POMs. Finally, the "Sum of POMs" is the sum of all of the polycyclic organic material measured.

Results for the emission indicators are shown in the following tables reported in both lbs/lb of binder and lbs/tn of metal.

Test Plan GB and GC Emissions Indicators – Lb/Lb Binder

Analytes	TGOC as Propane	HC as Hexane	Sum of Target Analytes	Sum of HAPs	Sum of POMs
Test GB Lb/Lb Binder	0.3179	0.1073	0.0845	0.0703	0.0073
Test GC Lb/Lb Binder	0.1621	0.0578	0.0484	0.0436	0.0073

Test Plan GB and GC Emissions Indicators – Lb/Tn Metal

Analytes	TGOC as Propane	HC as Hexane	Sum of Target Analytes	Sum of HAPs	Sum of POMs
Test GB Lb/Tn Metal	2.454	0.8289	0.6581	0.5484	0.0565
Test GC Lb/Tn Metal	1.191	0.4250	0.3558	0.3204	0.0535

A pictorial casting record was made of cavity number 3 from each mold for comparison to baseline FQ without seacoal. The pictures are shown in rank-order in Appendix C.

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 research services to industrial and government clients specializing in the metal casting and mobile emissions areas. Technikon 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). The parties to the CERP Cooperative Research and Development Agreement (CRADA) include The Environmental Research Consortium (ERC), a Michigan partnership of DaimlerChrysler Corporation, Ford Motor Company, and General Motors Corporation; the U.S. Army Tank-automotive and Armaments Command, Armament Research, Development, and Engineering Center (TACOM-ARDEC), a laboratory of the United States Army; the American Foundry Society; and the Casting Industry Suppliers Association.

1.2 TECHNIKON OBJECTIVES

One of the primary objectives of Technikon is to evaluate materials, equipment, and processes used in the production of metal castings. Technikon's 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. 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.

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 VOC emissions from a cored greensand system. 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 during this test are summarized in Section 3 of this report, with detailed data included in the appendices 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.

1.4 SPECIFIC TEST PLAN AND OBJECTIVES

Table 1-1 provides a summary of the test plan. The details of the approved test plan are included in Appendix A.

Table 1-1 Test Plan Summary

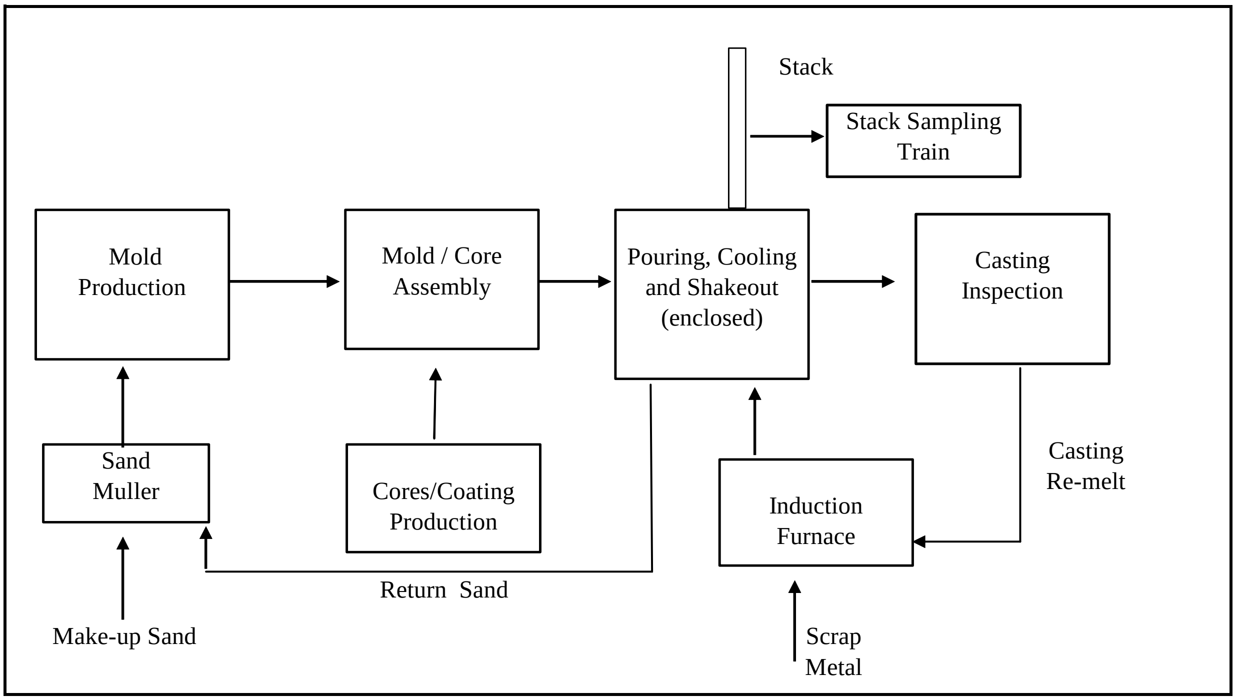
	Test Plan GB	Test Plan GC	Test Plan FQ
Type of Process Tested	◦ Coated Core ◦ Greensand with Seacoal ◦ Iron PCS Baseline	◦ Coated Core with Anti-Vein ◦ Greensand Graphite Parting Spray ◦ Iron PCS	◦ Coated Core ◦ Greensand without Seacoal ◦ Iron PCS Baseline
Test Plan Number	1411 121 GB	8011 001 GC	1410 124 FQ
Greensand System	◦ Wexford W450 ◦ Western and Southern Bentonite	◦ Wexford W450 ◦ H&G Premix	◦ Wexford W450 ◦ Western and Southern Bentonite
Metal Poured	Iron	Iron	Iron
Casting Type	4-on Step Core	4-on Step Core	4-on Step Core
Core Binder	1.4% Ashland ISOCURE® 305/904	1.4% Ashland ISOCURE® 305/904	1.4% Ashland ISOCURE® 305/904
Core Coating	Ashland Velvaplast® CGW 9022SL	Ashland Velvaplast® CGW 9022SL	Ashland Velvaplast® CGW 9022SL
Anti-Veining Material	None	5% H&G Vein Away HT	None
Parting Spray	Black Diamond®	H & G AQUA PART® II plus Graphite	None
Number of Molds Poured	3 Conditioning + 9 Sampling	3 Conditioning + 3 Sampling	3 Conditioning + 9 Sampling
Test Dates	7/14/04 > 7/16/04	8/9/04 > 8/10/04	12/18/03 < 12/23/03
Emissions Measured	◦ TGOC as Propane ◦ Carbon Monoxide ◦ Carbon Dioxide ◦ HC as Hexane ◦ 68 Organic HAPs and VOCs	◦ TGOC as Propane ◦ Carbon Monoxide ◦ Carbon Dioxide ◦ HC as Hexane ◦ 68 Organic HAPs and VOCs	◦ TGOC as Propane ◦ HC as Hexane ◦ 69 Organic HAPs and VOCs
Process Parameters Measured	◦ Total Casting ◦ Mold ◦ Binder Weights ◦ Metallurgical data ◦ % LOI ◦ Stack Temperature ◦ Moisture Content ◦ Sand Temperature ◦ Pressure ◦ Volumetric Flow Rate	◦ Total Casting ◦ Mold ◦ Binder Weights ◦ Metallurgical data ◦ % LOI ◦ Stack Temperature ◦ Moisture Content ◦ Sand Temperature ◦ Pressure ◦ Volumetric Flow Rate	◦ Total Casting ◦ Mold ◦ Binder Weights ◦ Metallurgical data ◦ % LOI ◦ Stack Temperature ◦ Moisture Content ◦ Sand Temperature ◦ Pressure ◦ Volumetric Flow Rate

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.

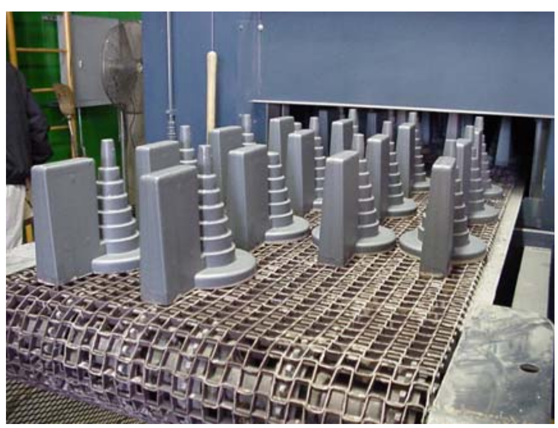
Figure 2-1 Pre-Production Foundry Layout Diagram



2.2 DESCRIPTION OF TESTING PROGRAM

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

1. **<u>Test Plan Review and Approval:</u>** The proposed test plan was reviewed and approved by the Technikon staff and by a representative of Hill and Griffith.



Coated Step Cores

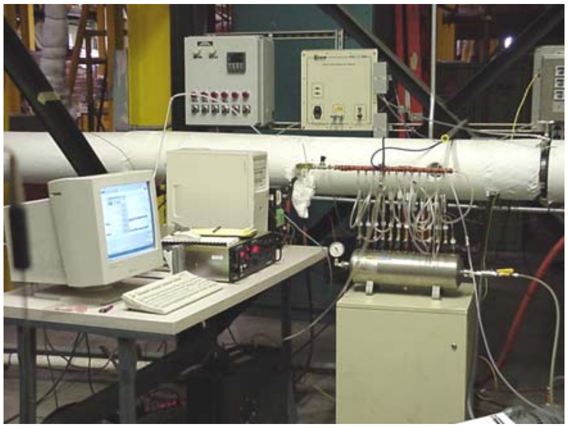
2. **<u>Mold, Core and Metal Preparation:</u>** The molds and cores were prepared to a standard composition by the Technikon production team. The cores were blown in a Redford/Carver core blower and then coated with the vendor supplied core coating. Relevant process data was collected and recorded. Iron was melted in a 1000 lb. Ajax induction furnace. The amount of metal melted was determined from the poured weight of the casting and the number of molds to be poured. The metal composition was Class-30 Gray Iron as prescribed by a metal composition worksheet. The weight of metal poured into each mold was recorded on the process data summary sheet.

3. **<u>Individual Sampling Events:</u>** Replicate tests were performed on three mold packages. The mold packages were placed into an enclosed test stand heated to approximately 85°F. Iron was poured through an opening in the top of the emission enclosure, after which the opening was closed.

   Continuous air samples were 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 was seventy-five minutes.

Mold with Step Cores

Total Enclosure Test Stand



Method 25A (TGOC) and Method 18 Sampling Train

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.

Table 2-1 Process Parameters Measured

Parameter	Analytical Equipment and Methods
Mold Weight	Cardinal 748E platform scale (Gravimetric)
Casting Weight	Cardinal 748E platform scale (Gravimetric)
Muller water weight	Cardinal 748E platform scale (Gravimetric)
Binder Weight	Mettler SB12001 Digital Scale (Gravimetric)
Volatiles	Mettler PB302 Scale (AFS Procedure 2213-00-S)
LOI, % at Mold and Shakeout	Denver Instruments XE-100 Analytical Scale (AFS procedure 5100-00-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 MP2 Scale
Mold Compactability	Dietert 319A Sand Squeezer (AFS Procedure 2221-00-S)
Carbon/Silicon	Electro-Nite DataCast 2000 (thermal arrest)

5. **Air Emissions Analysis:** 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 Technikon 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 1500, 2002
VOCs Concentration	EPA Method 18, 25A, TO11, NIOSH 1500, 2002
Carbon Monoxide	EPA Method 10
Carbon Dioxide	EPA Method 3A

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

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 both pounds of analyte per pound of binder and pounds of analyte per ton of metal.

   The results of each of the sampling events are included in the appendices of this report. The emissions results are also averaged and are shown in Tables 3-1 and 3-3.

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, the Manager-Process Engineering, and the Technikon President. Comments are incorporated into a draft Final Report prior to final signature approval and distribution.

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 Technikon Emissions Testing and Analytical Testing 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 pound of binder and pounds per ton of metal are presented in Tables 3-1 and 3-2 respectively. The tables include the individual target compounds that comprise at least 95% of the total target analytes measured, along with the corresponding Sum of Target Analytes, Sum of HAPs, and Sum of POMs. The tables also include the carbon monoxide, carbon dioxide, TGOC as propane, and HC as hexane.

Figures 3-1 to 3-3 present the five emissions indicators and selected HAP and VOC emissions data from Table 3-1 in graphical form based on binder weight.

Figures 3-4 to 3-6 present the five emissions indicators and selected HAP and VOC emissions data from Table 3-2 in graphical form based on metal weight.

Appendix B contains the detailed emissions data including the results for all analytes measured. Table 3-3 includes the averages of the key process parameters. Detailed process data are presented in Appendix C.

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

Photographs of the Best, Median and Worst GC castings with cellulose, starch, and surface applied graphite as a replacement for seacoal are presented in Appendix C. The greensand surfaces are compared to greensand surfaces of castings where the mold contained seacoal (Test GB) and no seacoal (Test FQ). The cored surfaces are compared to castings where cored surfaces reflect core coating (all) but no anti-veining materials (Test GB and FQ).

Note that the casting numbers appearing on the casting pictures in Appendix C are the Production Numbering System. The picture titles contain the Emission Numbering System. Both number systems are presented tin the process data tables in Appendix C.

Table 3-1 Summary of Test Plans GB and GC Average Results – Lb/Lb Binder

Analytes	Test GB Lb/Lb Binder	Test GC Lb/Lb Binder	% Change from Test GB
TGOC as Propane	0.3179	0.1621	**-49**
HC as Hexane	0.1073	0.0578	**-46**
Sum of Target Analytes	0.0845	0.0484	**-43**
Sum of HAPs	0.0703	0.0436	**-38**
Sum of POMs	0.0073	0.0073	0
Individual Organic HAPs			
Benzene	0.0236	0.0096	**-59**
Toluene	0.0101	0.0027	**-73**
Phenol	0.0100	0.0103	3
o,m,p-Xylene	0.0072	0.0016	**-78**
o,m,p-Cresol	0.0049	0.0042	**-14**
Methylnaphthalenes	0.0033	0.0036	9
Dimethylnaphthalenes	0.0033	0.0019	**-42**
Aniline	0.0028	0.0041	**46**
Naphthalene	0.0026	0.0018	**-31**
Hexane	0.0021	0.0004	**-81**
Ethylbenzene	0.0012	0.0002	**-83**
Acetaldehyde	0.0010	0.0022	**120**
Formaldehyde	0.0003	0.0004	**33**
Other VOCs			
Trimethylbenzenes	0.0026	0.0010	**-62**
Octane	0.0025	ND	**NA**
Heptane	0.0015	0.0002	**-87**
Ethyltoluenes	0.0014	0.0005	-64
Undecane	0.0013	<0.0001	**NA**
Nonane	0.0010	ND	**NA**
Decane	0.0009	<0.0001	**NA**
Dodecane	0.0007	0.0002	**-71**
Tetradecane	0.0003	0.0005	**67**
Dimethylphenols	0.0003	0.0013	**333**
Other Analytes			
Carbon Dioxide	1.296	0.8207	**-37**
Carbon Monoxide	0.5481	0.3646	**-33**

Individual results constitute >95% of mass of all detected Target Analytes.

ND: Non Detect; NA: Not Applicable

Table 3-2 Summary of Test Plans GB and GC Average Results – Lb/Tn Metal

Analytes	Test GB Lb/Tn Metal	Test GC Lb/Tn Metal	% Change from Test GB
TGOC as Propane	2.454	1.191	**-51**
HC as Hexane	0.8289	0.4250	**-49**
Sum of Target Analytes	0.6581	0.3558	**-46**
Sum of HAPs	0.5484	0.3204	**-42**
Sum of POMs	0.0565	0.0535	-5
Individual Organic HAPs			
Benzene	0.1821	0.0707	**-61**
Toluene	0.0773	0.0196	**-75**
Phenol	0.0773	0.0755	-2
o,m,p-Xylene	0.0555	0.0118	**-79**
o,m,p-Cresol	0.0377	0.0309	**-18**
Methylnaphthalenes	0.0256	0.0267	4
Aniline	0.0213	0.0299	**40**
Naphthalene	0.0203	0.0129	**-36**
Hexane	0.0167	0.0032	**-81**
Dimethylnaphthalenes	0.0105	0.0139	**32**
Ethylbenzene	0.0096	0.0016	**-83**
Acetaldehyde	0.0080	0.0163	**104**
Formaldehyde	0.0020	0.0030	**50**
Other VOCs			
Trimethylbenzenes	0.0204	0.0076	**-63**
Octane	0.0190	ND	**NA**
Heptane	0.0117	0.0013	**-89**
Ethyltoluenes	0.0111	0.0038	**-66**
Undecane	0.0100	0.0002	**-98**
Nonane	0.0079	ND	**NA**
Decane	0.0070	0.0003	**-96**
Dodecane	0.0053	0.0013	**-75**
Dimethylphenols	0.0023	0.0097	**322**
Tetradecane	0.0022	0.0037	**68**
Other Analytes			
Carbon Dioxide	9.996	6.038	**-40**
Carbon Monoxide	4.231	2.680	**-37**

Individual results constitute >95% of mass of all detected Target Analytes.

ND: Non Detect; NA: Not Applicable

Table 3-3 Summary of Test Plans GB and GC Average Process Parameters

Greensand PCS		
	Test GB	**Test GC**
Test Dates	**7/15-16/04**	**8/9-10/04**
Cast Weight (all metal inside mold), Lbs.	**106.45**	**109.33**
Pouring Time, sec.	**24**	**15**
Pouring Temp ,°F	**2633**	**2630**
Pour Hood Process Air Temp at Start of Pour, °F	**86**	**88**
Core Mixer Auto Dispensed Batch Weight, Lbs	**49.08**	**50**
Calibrated auto dispensed core binder weight, Lbs	**0.69**	**0.70**
Core Binder Calibrated Weight, %BOS	**1.41**	**1.40**
Core Binder Calibrated Weight, %	**1.39**	**1.38**
Total Uncoated Core Weight in Mold, Lbs.	**29.61**	**29.15**
Total Binder Weight in Mold, Lbs.	**0.41**	**0.40**
Core LOI, %	**1.15**	**1.48**
Weight of H& G VeinAway HT, Lbs.	**NA**	**1.37**
Total Dried Core Coating Weight in Mold. Lbs	**0.36**	**0.13**
Dogbone Tensile Test (Thwing-Albert psi)	**236**	**202**
Core Age, hrs.	**75**	**138**
Muller Batch Weight, Lbs.	**944**	**904**
H & G Premix. Lbs.	**NA**	**3.8**
GS Mold Sand Weight, Lbs.	**615**	**635**
Weightof H&G AquaPart II-Graphite Mold rel., gms	**NA**	**40.4**
Mold Compactability, %	**55**	**56**
Mold Temperature, °F	**83**	**89**
Average Green Compression , psi	**21.4**	**21.9**
GS Compactability, %	**49**	**49**
GS Moisture Content, %	**2.51**	**2.70**
GS MB Clay Content, %	**7.49**	**7.78**
MB Clay Reagent, ml	**28.9**	**30.0**
1800°F LOI - Mold Sand, %	**5.30**	**1.31**
900°F Volatiles , %	**0.51**	**0.41**

Appearance ranking: 1 = best, 13 = worst Cavity 3	**GB Greensand Surface Emission Run Number**	**FQ Greensand Surface Run Number**	**GC Greensand Surface Emission Run Number**	**GB Core Surface Emission Run Number**	**GC Core Surface Emission Run Number**
Rank 1	1			2	
Rank 2	8			3	
Rank 3	3			5	3
Rank 4	5			8	
Rank 5	2	2		6	2
Rank 6	9	1		1	
Rank 7	4	9		7	1
Rank 8	7	5		4	
Rank 9	6	6		9	
Rank 10		8	1		
Rank 11		4	3		
Rank 12		7	2		
Rank 13		3			

Figure 3-1 Emission Indicators from Test Series GB and GC – Lb/Lb Binder

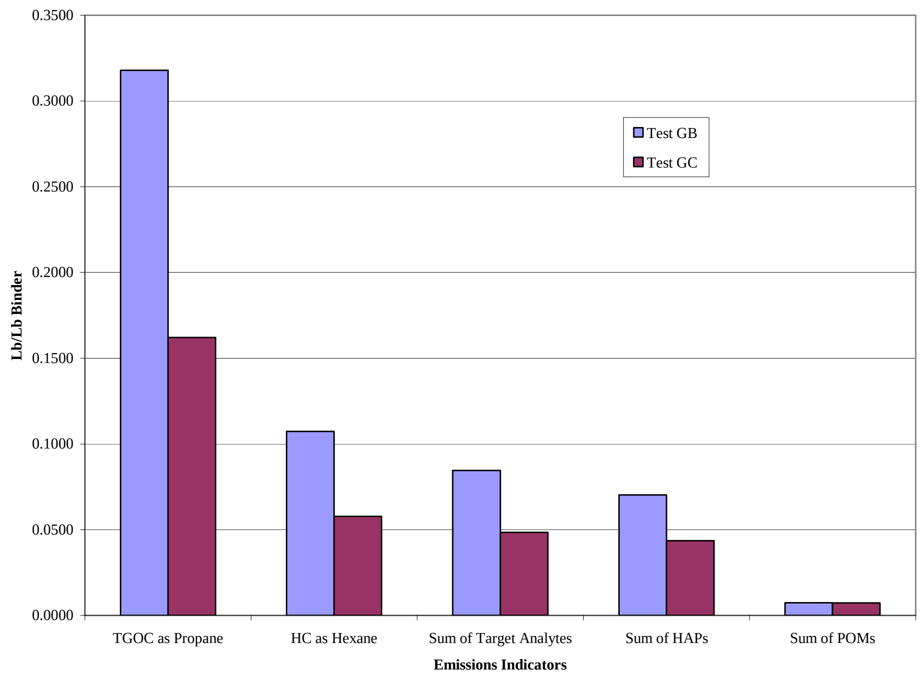


Figure 3-2 Selected HAP Emissions from Test Series GB and GC – Lb/Lb Binder

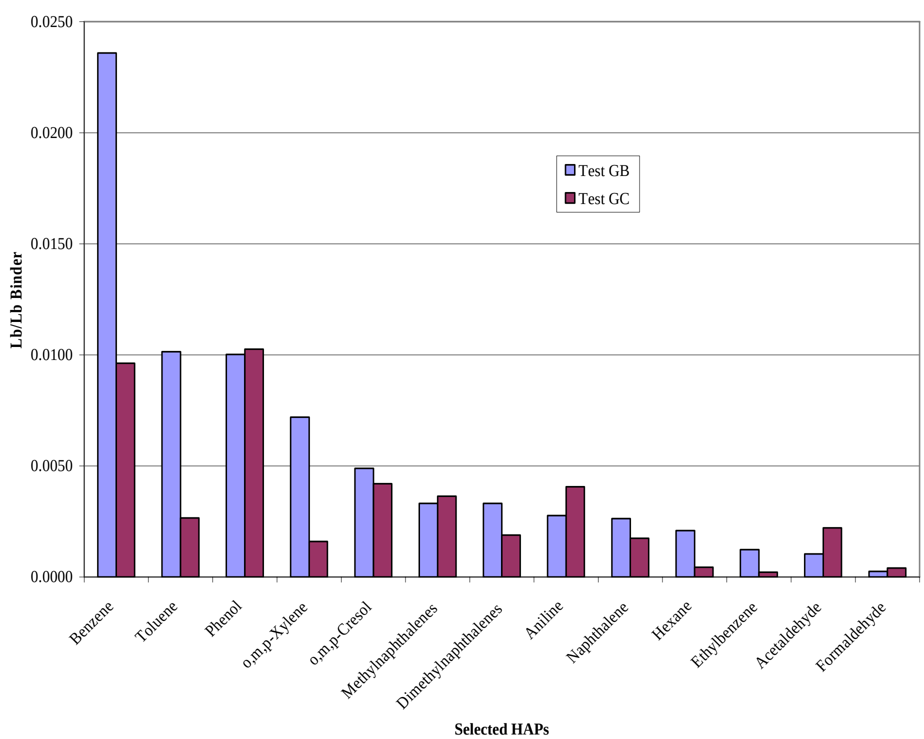


Figure 3-3 Selected VOC Emissions from Test Series GB and GC – Lb/Lb Binder

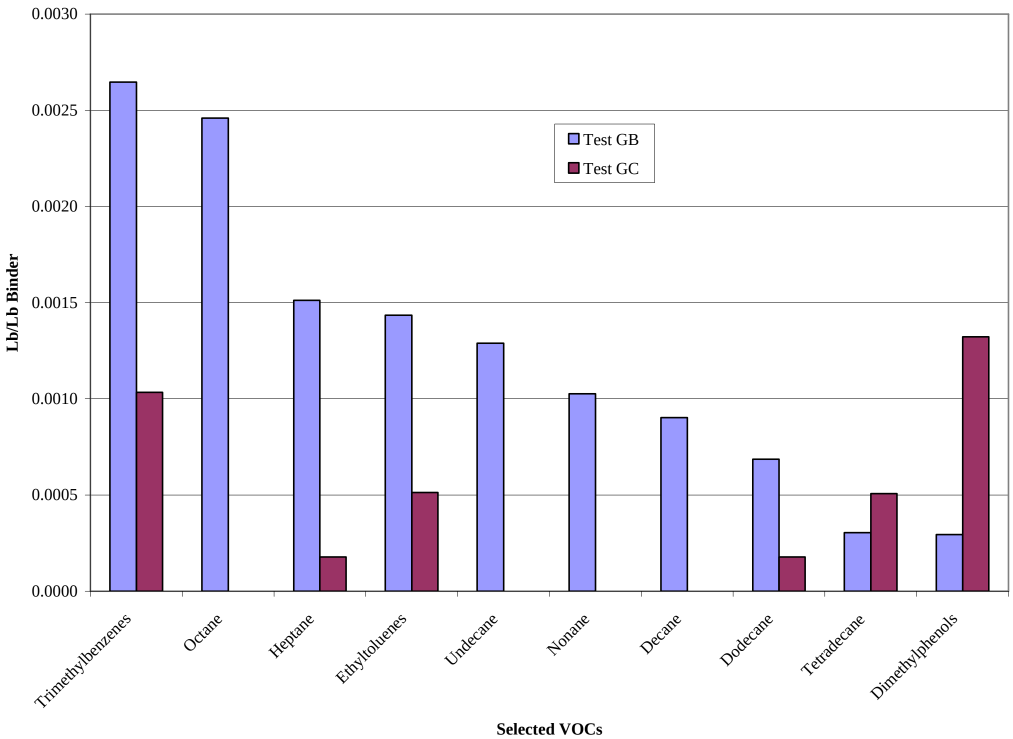


Figure 3-4 Emissions Indicators from Test Series GB and GC – Lb/Tn Metal

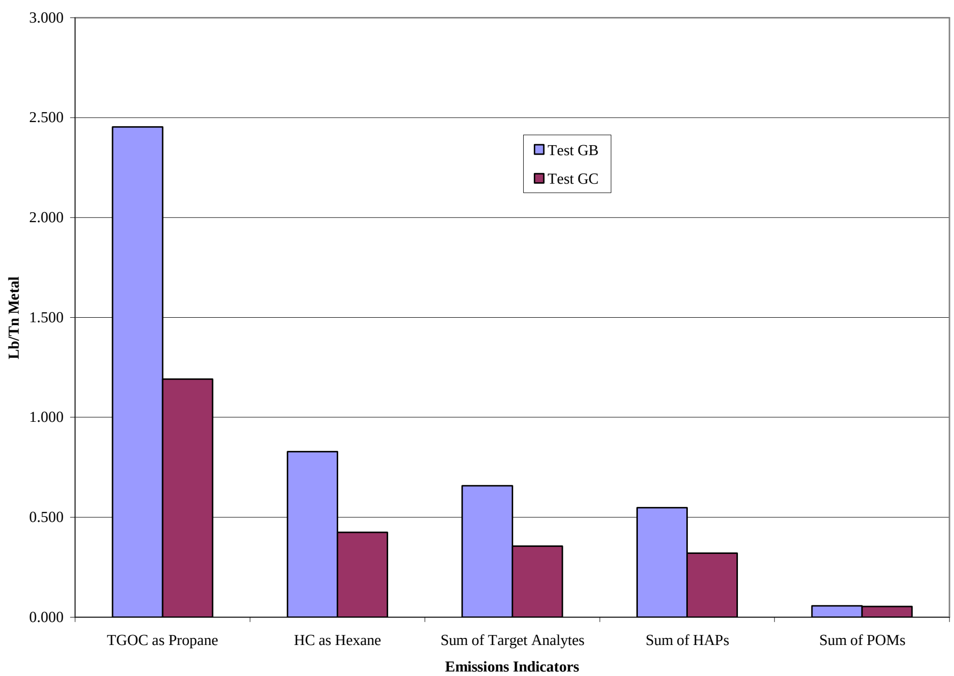


Figure 3-5 Selected HAP Emissions from Test Series GB and GC – Lb/Tn Metal

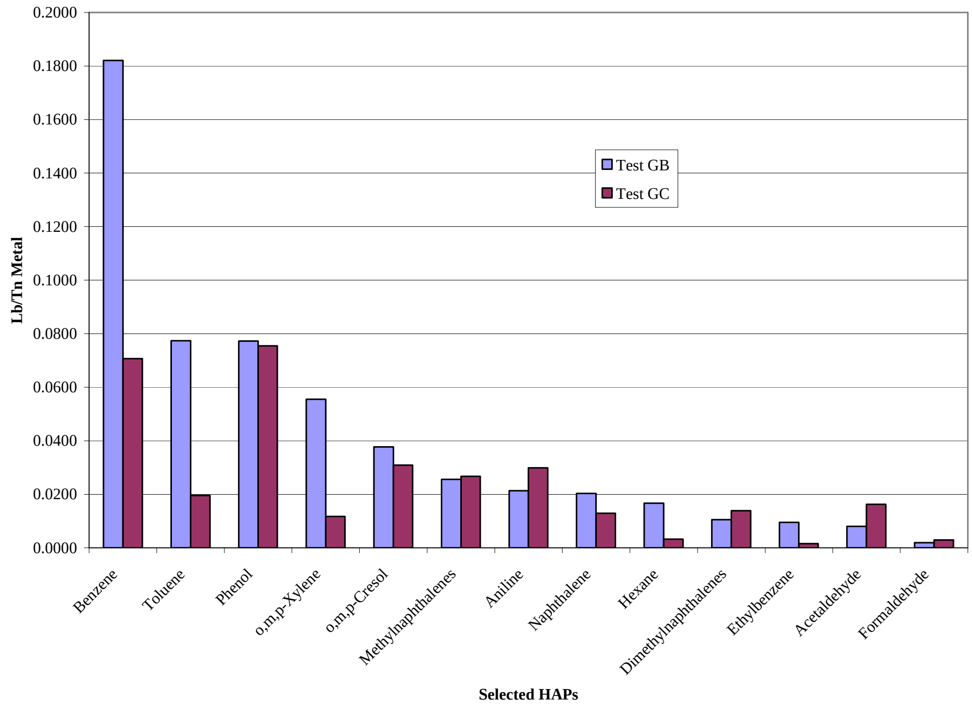
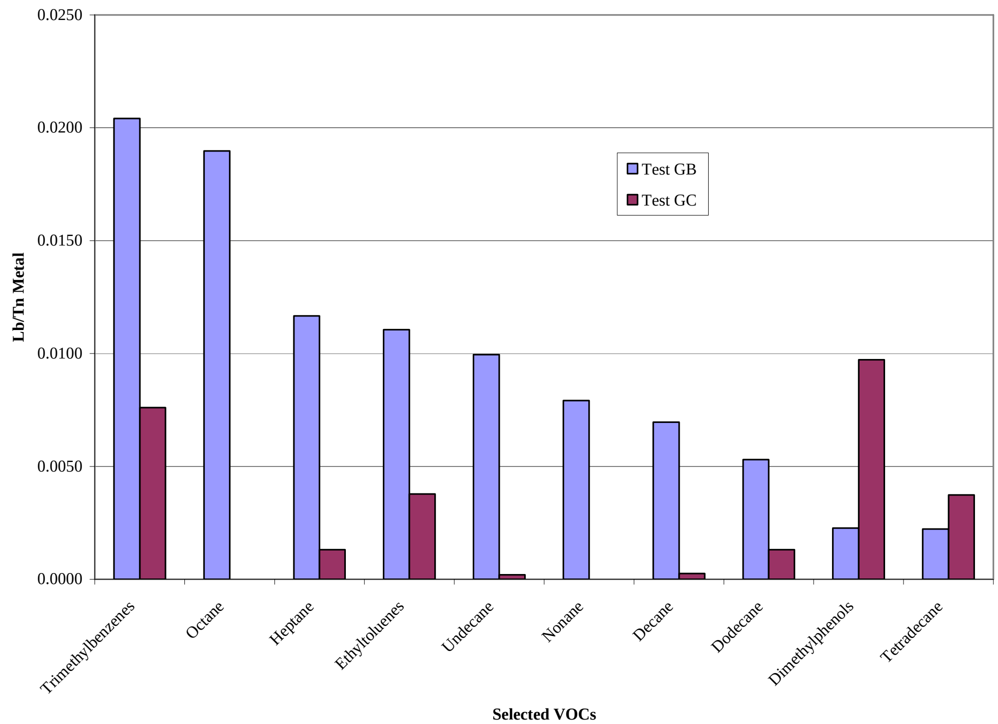


Figure 3-6 Selected VOC Emissions from Test Series GB and GC – Lb/Tn Metal



this page intentionally left blank

4.0 Discussion of Results

The sampling and analytical methodologies were the same for Test Plans GB and GC.

Test GC was a composite test using coated phenolic urethane cores containing an anti-vein additive placed in greensand containing cellulose and starch and a graphite-containing parting spray as seacoal replacements. Test GC was designed to include a combination of parameters in one test package and to examine the overall effect on the emissions and the casting quality. Test GC emissions were compared to the baseline Test GB a coated phenolic urethane core in greensand using standard seacoal. Test GC casting appearance was also compared to Test FQ that lacked seacoal. The GC casting greensand surfaces were inferior to those from molds containing seacoal (GB) and similar to those without seacoal (FQ). The cored surfaces were similar to the core surfaces of the baseline coated cores not having any anti-veining compound (GB).

Observation of measured process parameters indicates that the tests were run within an acceptable range. In Tables 3-1 and 3-3, the “% Change from Test GB” emissions values presented in **bold** letters indicate a greater than 95% probability that the differences in the average values were not the result of variability in the test protocol as determined from T-Statistic calculations. Tables showing the T-Statistics calculated are found in Appendix B.

The results of the tests performed for the comparison of Test GB to test GC show a **51%** reduction in TGOC as propane, a **33%** reduction in carbon monoxide, a **37%** reduction in carbon dioxide, a **49%** reduction in HC as hexane, a **46%** reduction in Sum of Target Analytes, a **42%** reduction in Sum of HAPs, and a **5%** reduction in Sum of POMs when expressed in pounds per ton of metal. Benzene was found to be the largest contributor to the total HAPs and Target Analytes for Test GB followed by toluene and phenol. For Test GC, phenol was the largest contribution followed by benzene and o,m,p-cresol.

Two methods were employed to measure undifferentiated hydrocarbon emissions, TGOC 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 the 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).

Target analyte reporting limits expressed in both pounds per pound of binder and pounds per ton of metal are shown in Appendix B.

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

The GC casting quality ranked in the lower third compared to Test FQ and totally inferior to GB.

this page intentionally left blank

APPENDIX A APPROVED TEST PLAN AND SAMPLE PLAN FOR TEST SERIES GB AND GC

this page intentionally left blank

Technikon Test Plan

- > **CONTRACT NUMBER:** 1411 **TASK NUMBER:** 1.2.1 **Series:** GB
- > **SITE:** Pre-production
- > **TEST TYPE:** Combination Baseline Test: Pouring, cooling, & shakeout of seacoal containing greensand with coated phenolic urethane step cores.
- > **METAL TYPE:** Class 30 gray iron
- > **MOLD TYPE:** Virgin greensand with 7% western and southern bentonite in 5:2 ratio and seacoal to generate a 5 % LOI. Molds will be recycled.
- > **NUMBER OF MOLDS:** Three engineering & conditioning runs + 9 sampling runs. Twelve (12) molds total**.**
- > **CORE TYPE:** Step: 1.4 % Ashland ISOCURE ® Phenolic Urethane LF305 part I (55%), 904GR Part II (45%), amine cured, 50-120 hrs old.
- > **CORE COATING:** Test cores shall be coated with Ashland Velva Plast CWG9022SL core coating and dried at 275 F.
- > **SAMPLE EVENTS:** Nine (9)
- > **TEST DATE:** **START:** 12 Jul 2004
  FINISHED: 23 Jul 2004

TEST OBJECTIVES:

Measure the airborne pouring, cooling, & shakeout emissions from coated organic step cores in a mechanically-produced clay, water, coal containing greensand mold.

VARIABLES:

The pattern will be the 4-on step core. The mold will be made with Wexford W450 Lakesand, western and southern bentonite in a 5:2 ratio to yield 7.0 +/- 0.5% MB Clay, seacoal to produce 5% LOI, and tempered to 40-45% compactability, mechanically compacted. The molds will be maintained at 80-90^{o}F prior to pouring. The sand heap will be maintained at 900 pounds. Molds will be poured with iron at 2630 +/- 10^{o}F. Mold cooling will be 45 minutes followed by 15 minutes of shakeout, or until no more material remains to be shaken out, followed by 15 minutes additional sampling for a total of 75 minutes. Cores will be made with Wedron 530 silica sand heated to 85-90^{o}F and made in an 80-90^{o}F heated enclosed core machine. No emission sampling will be done during core manufacture. The cores will be dip coated in Ashland Velvaplast ® core coating and dried at 275^{o}F.

BRIEF OVERVIEW:

This is the third of the 4-on greensand baseline tests. This test differs from previous 4-on greensand tests in that both seacoal and organic binder are sources for emissions.
The greensand molds will be produced on the mechanically assisted Osborne 716 molding machines.

The emission results will be used to compare future product tests using a seacoal replacement in the presence of organic core or a different core binder in the presence of a seacoal containing greensand. In addition to a suite of selected emission analytes TGOC, CO, & CO_2 content of the runs will be monitored using instruments specific to those gasses.

SPECIAL CONDITIONS:

The process will include rigorous maintenance of the size of sand heap and maintenance of the material and environmental testing temperatures to reduce seasonal and daily temperature dependent influence on the emissions. Initially for each subtest a 1300 pound greensand heap will be created from a single muller batch. Nine hundred pounds will become the re-circulating heap. The balance will be used to makeup for attrition. The cores shall be maintained at 80-90 ^{o}F awaiting insertion in the mold. The cores shall be stabilized for 50-120 hours when tested.

Series GB

PCS Core Baseline Test in Greensand with Ashland 305/904 Core Binder, & Mechanized Molding

Process Instructions

A. Experiment:

B. Measure pouring, cooling, & shakeout emissions from coated organic cores in a greensand mold made with all virgin Wexford W450 sand, bonded with Western & Southern Bentonite in the ratio of 5:2 to yield 7.0 +/- 0.5 % MB Clay, & seacoal. The molds shall be tempered with potable water to 40-45% compactability, poured at constant weight, temperature, surface area, & shape factor. This test will recycle the same mold material, replacing burned clay with new materials after each casting cycle and providing clay for the retained core sand. Emissions will be compared to those from the same mold configuration containing cores with no anti-veining compound

C. Materials:

D. Mold sand:

E. Virgin mix of **Wexford W450** lake sand, western and southern bentonites in the ratio of 5:2, and potable water per recipe.

1) Core:

a) Step cores made with virgin Wedron 530 sand and 1.4% Ashland ISOCURE® **LF305/52-904GR** regular phenolic urethane binder in a 55/45 ratio, TEA catalyzed.

2) Ashland Velvaplast® CWG9022SL core coating.

3) Metal:

a) Class-30 gray cast iron poured at 2630 +/- 10^{o}F.

4) Pattern Spray**:**

a) **Black Diamond**, <u>hand wiped</u>.

B. Briefing:

1) The Process Engineer, Emissions Engineer, and the area Supervisor will brief the operating personnel on the requirements of the test at least one (1) day prior to the test.

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

C. ISOCURE® regular Step Cores:

1) Klein vibratory core sand mixer.

a) Attach the day tanks with the intended part I and part II binder components via respective binder shut-off valves so that they gravity feed to the respective pumps. The binder components should be 80-85^{o}F.

b) On the main control panel turn the AUTO/MAN switch to MANUAL, turn on main disconnect and MASTER START push button.
c) Fill the Part I and Part II pumps and de-air the lines.
d) Calibrate the Klein mixer.
i) Remove the mixing bowl skirt to gain access to the binder injection tubes and the bottom side of the batch hopper outlet gate.

2) Calibrate sand. Recalibrate for each sand mixture used.
a) Turn the AUTO/MAN switch to MANUAL on main control panel.
b) Place one bucket of preheated sand, raw, or containing one of the iron oxides, of at least fifty-two (52) pounds net weight, into the sand hopper and manually fill batch hopper using max and min proximity switches.
c) Discharge the sand from the batch hopper using the single cycle push button. Catch the sand as it leaves the batch hopper and record the net weight and the dispensing time.
d) Repeat 3 times to determine the weight variation. The sand should be 80-85^{o}F.

3) Calibrate the binder pumps.
a) Adjust the part I dispensing rate by adjusting the part I pump stroke to be 55% of 1.4% (0.77% BOS) of the average sand batch weight dispensed in D.2.e.2).
b) Adjust the machine's inlet air pressure to dispense the binder in about the same time as the sand is dispensed, about 10-15 seconds.
c) Record the pressure and dispensing time, and net weight.
d) Repeat 3 times to determine the variation in dispensing rate.
e) Adjust the part II dispensing rate by adjusting the part II pump stroke to be 45 % of 1.4 % (.63% BOS) of the average sand rate dispensed in D.2.e.2).
f) Repeat D.2.d.3).c), & d) for Part II pump.

4) Turn off the mixer and replace the mixing bowl skirt.

D. Turn on the mixer and turn the AUTO/MAN switch to AUTO.
E. Press the SINGLE CYCLE push button on the operators station to make a batch of sand. Make three (3) batches to start the Redford Carver core machine.
F. Make a batch of sand for every 7 core machine cycles when using the step core. About two (2) batches will be retained in the core machine sand magazine.
G. Clean the mixer after each material.

Caution: Do not make more sand than sand magazine will hold plus one (1) batch. If too much sand is made the sand will be exposed to captured TEA and significantly shorten the sand bench life

H. Redford/Carver core machine.
1) Mount the Step-Core core box on the Carver/Redford core machine.
2) Start the core machine auxiliary equipment per the <u>Production Foundry OSI</u> for that equipment.

3) Set up the core machine in the cold box mode with gassing and working pressures and gas and purge time according to the core recipe sheet.

4) Core process setup
   - **a)** Set the TEA to a nominal 5 grams per blow (gas time 0.75 sec (R/C), flow .019 lbs/sec (Luber).
   - **b)** Set the blow pressure to 30+/-2 psi for 3 seconds (R/C).
   - **c)** Set the max purge pressure to 45 psi on the Luber gas generator.
   - **d)** Purge for 20 seconds(R/C) with a 10 second rise time (Luber).
   - **e)** Total cycle time approximately 1 minute.

5) Run the core machine for three (3) cycles and discard the cores. When the cores appear good begin test core manufacture. Five (5) good cores are required for each mold. Make five (5) additional 50 pound sand batches and run the sand out making core. A minimum of 35 cores are required.

6) One half hour to 1 hour after manufacture randomly perform a scratch hardness test on the outer edge of the blow surface on 10 % of the cores and record the results on the Core Production Log. Values less than 25 shall be marked with a HOLD TAG until they can be 100 % scratch hardness tested to re-qualify. Contact the Process Engineer for disposition on all cores with values less than 15 after 1 hour. Weigh each core and log the results.

7) The sand lab will sample, at the time of manufacture, one (1) core from each row of each shelf (1 of 11) on each core rack. Those cores will be tested for LOI using the standard 1800 ^{o}F core LOI test method and reported out associated with the core rack shelf it represents. Qualified cores receiving the green **Quality Checked** tag must have **LOI** values between 1.25-1.50 %. Individual rows that qualify may have the **Quality Checked** tag affixed. Only cores with the green Quality Tag bearing the current test series and dates and signature of the lab technician and core rack/shelf/position on shelf may be taken to the mold assembly area.

Note: The core rack position from the Quality Checked tag shall be transferred to the mold assembly check list with the core weights.

8) The sand lab will sample one (1) core from the core rack for each mold produced just prior to the emission test to represent the four (4) cores placed in that mold. Those cores will be tested for LOI using the standard 1800 ^{o}F core LOI test method and reported out associated with the test mold it is to represent.

9) Core coating.
   - **a)** Ashland Velvaplast® CGW 9022 SL core coating material will be used to dip-coat the cores.
   - **b)** Weigh the uncoated core and log the weight.
   - **c)** Coat the entire core up to the ½ inch from the invest side.
   - **d)** Normalize the core coating temperature to 70-80^{o}F.
   - **e)** Dip the core into the core wash and hold for a count of two (2).
   - **f)** Shake the core vertically until the coating ceases to drip.
   - **g)** Place the core invest side down on the OSI ovenlear (chain belt).

h) Dry the core at 275^{o}F for 1 hour in the OSI core drying oven.
i) Weigh the dried and cooled coated core and log the weight.

I. Sand preparation

1) Start up batch: make 1, GBCD1
a) Thoroughly clean the pre-production muller, elevator, and molding hoppers.
b) Weigh and add 1225 +/-10 pounds of new Wexford W450 Lakesand, per the recipe, to the running pre-production muller to make a 1300 batch.
c) Add 5 pounds of potable to the muller to suppress dust distributing it across the sand. Allow to mix for 1 minute.
d) Add the clays slowly to the muller to allow them to be distributed throughout the sand mass in proportion to the sand weight per the recipe for this test.
e) Dry mull for about 3 minutes to allow distribution and some grinding of the clays to occur.
f) Temper the sand-clay mixture slowly, with potable water, to allow for distribution.
g) After about 2 gallons of water have been added allow 30 seconds of mixing then start taking compactability test samples.
h) Based on each test add water incrementally to adjust the temper. Allow 1 minute of mixing. Retest. Repeat until the compactability is in the range 40-45%.
i) Discharge the sand into the mold station elevator.
j) Grab sufficient sample after the final compactability test to fill a quart zip-lock bag. Label bag with the test series and sequence number, date, and time of day and deliver it immediately to the sand lab for analysis
k) Record the total sand mixed in the batch, the total of each type of clay added to the batch, the amount of water added, the total mix time, the final compactability and sand temperature at discharge.
l) The sand will be characterized for Methylene Blue Clay, Moisture content, Compactability, Green Compression strength, 1800^{o}F loss on ignition (LOI), and 900^{o}F volatiles. Each volatile and LOI test requires a separate 50 gram sample from the collected sand.
m) Empty the extra greensand from the mold hopper into a clean empty dump hopper whose tare weight is known. Set this sand aside to be used to maintain the recycled batch at 900+/-10 pounds

2) Re-mulling: GBCD2, GBCD3, & GB4-12
a) Add to the sand recovered from poured mold **GBCD1** sufficient pre-blended sand so that the sand batch weight is 900 +/- 10 pounds. Record the sand weight.
b) Return the sand to the muller and dry blend for about one minute.
c) Add the clays, as directed by the process engineering staff, slowly to the muller to allow them to be distributed throughout the sand mass.
d) Add 5 pounds of water to the muller to suppress dust distributing it across the sand. Allow to mix for 1 minute.
e) Follow the above procedure beginning at E.1.f.

J. Molding:

1) Step core pattern.

a) Pattern preparation:

b) Inspect and tighten all loose pattern and gating pieces.

c) Repair any damaged pattern or gating parts.

2) Making the green sand mold.

a) Mount the drag pattern on one Osborne Whisper Ram molding machine and mount the cope pattern on the other Osborne machine.

b) 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 of 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.

3) Use the overhead crane to place the pre-weighed drag/cope flask on the mold machine table, parting line surface down.

4) Locate a 24 x 24 x4 inch deep wood upset on top of the flask.

5) Make the green sand mold cope or drag on the Osborn Whisper Ram Jolt-Squeeze mold machine

WARNING: Only properly trained personnel may operate this machine. Proper personal protective equipment must be worn at all times while operating this equipment, including safety glasses with side shields and a properly fitting hard hat. Industrial type boots are highly recommended.

WARNING: Stand clear of the mold machine table and swinging head during the following operation or serious injury or death could result.

a) Open the air supply to the mold machine.

WARNING: The squeeze head may suddenly swing to the outboard side or forward. Do not stand in the outer corners of the molding enclosure.

b) On the operator's panel turn the POWER switch to ON.

c) Turn the RAM-JOLT-SQUEEZE switch to ON.

d) Turn the DRAW UP switch to AUTO

e) Set the PRE-JOLT timer to 4-5 seconds.

f) Set the squeeze timer to 8 seconds.

g) Set the crow-footed gagger on the support bar. Verify that it is at least ½ inch away from any pattern parts.

h) Manually riddle a half to one inch or so of sand on the pattern using a ¼ inch mesh riddle. Source the sand from the overhead mold sand hopper by actuating the CHATTER GATE valve located under the operators panel.

i) Fill the center potion of the flask.

- **j)** Manually move sand from the center portion to the outboard areas and hand tuck the sand.
- **k)** Finish filling the 24 x 24 x 10 inch flask and the upset with greensand from the overhead molding hopper.
- **l)** Manually level the sand in the upset. By experience manually adjust the sand depth so that the resulting compacted mold is fractionally above the flask only height.
- **m)** Initiate the settling of the sand in the flask by pressing the PRE-JOLT push button. Allow this cycle to stop before proceeding.
- **n)** Remove the upset and set it aside.

WARNING: Failure to stand clear of the molding table and flasks in the following operations could result in serious injury as this equipment is about to move up and down with great force.

WARNING: Stand clear of the entire mold machine during the following operations. Several of the machine parts will be moving. Failure to stand clear could result in severe injury even death.

- **o)** Using both hands initiate the automatic machine sequence by simultaneously pressing, holding for 2-3 seconds, and releasing the green push buttons on either side of the operators panel. The machine will squeeze and jolt the sand in the flask and then move the squeeze head to the side.

WARNING: Do not re-approach the machine until the squeeze head has stopped at the side of the machine.

- **p)** Screed the bottom of the drag mold flat to the bottom of the flask if required.
- **q)** Press and release the LOWER DRAW/STOP push button to separate the flask and mold from the pattern.
- **r)** Use the overhead crane to lift the mold half and remove it from the machine. If the mold half is a drag, roll it parting line side up, set it on the floor, blow it out.
- **s)** Finally, press and release the DRAW DOWN pushbutton to cause the draw frame to return to the start position.

6) Set four (4) step cores that have been weighed and logged into the drag. Verify that the cores are fully set and flush with the parting line.
7) Close the cope over the drag being careful not to crush anything.
8) Clamp the flask halves together.
9) Weigh and record the weight of the closed un-poured mold, the pre-weighed flask, the coated cores, and the sand weight by difference.
10) Measure and record the sand temperature.
11) Deliver the mold to the previously cleaned shakeout to be poured.
12) Cover the mold with the emission hood.

K. Pig molds
1) Each day make a 900 pound capacity pig mold for the following day's use.

L. Emission hood:

1) Loading.
 a) Hoist the mold onto the shakeout deck within the emission hood.
 b) Close, seal, and lock the emission hood
 c) Adjust the ambient air heater control so that the measured temperature of the blended air within the hood is 85-90 ^{o}F at the start of the test run.

2) Shakeout.
 a) After the 45 minute cooling time prescribed in the emission sample plan has elapsed turn on the shakeout unit and run for it the 15 minutes prescribed in the emission sample plan or until the sand has all fallen through the grating.
 b) Turn off the shakeout.
 c) Sample the emissions for 30 minutes after the start of shakeout, a total of 75 minutes.

3) When the emission sampling is completed remove the flask with casting, and recover the sand from the hopper and surrounding floor.
 a) Weigh and record the metal poured and the total sand weight recovered and rejoined with the left over mold sand from the molding hopper, spilled molding sand, and sand loosely adhered to the casting.
 b) Add sufficient unused premixed sand to the recycled sand to return the sand heap to 900 +/- 10 pounds.

M. Melting:
1) Initial iron 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 of the steel.
 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 metallics under full power until all is melted and the temperature has reached 2600 to 2700 ^{o}F.
 f) Slag the furnace and add the balance of the alloys.
 g) Raise the temperature of the melt to 2700 ^{o}F and take a DataCast 2000 sample. The temperature of the primary liquidus (TPL) must be in the range of 2200-2350^{o}F.
 h) Hold the furnace at 2500-2550^{o}F until near ready to tap.
 i) When ready to tap raise the temperature to 2700^{o}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 I.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.

N. Pouring:

1) Preheat the ladle.
  - **a)** Tap 400 pounds more or less of 2700^{o}F iron into the cold ladle.
  - **b)** Carefully pour the metal back to the furnace.
  - **c)** Cover the ladle.
  - **d)** Reheat the metal to 2780 +/- 20^{o}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 and wait until the metal temperature reaches 2630 +/- 10^{o}F.
  - **h)** Commence pouring keeping the sprue full.
  - **i)** Upon completion return the extra metal to the furnace, and cover the ladle.
  - **j)** Record the pour temperature and pour time on the heat log

O. Rank order evaluation.

1) The supervisor shall select a group of five persons to make a collective subjective judgment of the casting relative surface appearance.

2) Review the general appearance of the castings and select specific casting features to compare.

3) For cavity 3 only:
  - **a)** Place each casting initially in sequential mold number order.
  - **b)** Beginning with casting from mold GB001 compare it to castings from mold GB002.
  - **c)** Place the better appearing casting in the first position and the lesser appearing casting in the second position.
  - **d)** Repeat this procedure with GB001 to its nearest neighbors until all castings closer to the beginning of the line are better appearing than GB001 and the next casting farther down the line is inferior.
  - **e)** Repeat this comparison to next neighbors for each casting number.
  - **f)** When all casting numbers have been compared go to the beginning of the line and begin again comparing each casting to its nearest neighbor. Move the castings so that each casting is inferior to the next one closer to the beginning of the line and superior to the one next toward the tail of the line.
  - **g)** Repeat this comparison until all concur with the ranking order.

4) Record mold number by rank-order series for this cavity.

Steven M. Knight
Mgr. Process Engineering

PRE-PRODUCTION GB - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
7/13/2004											**GB CONDITIONING - RUN 1**
GB CR-1											
THC		x									
CO, CO2		X									TOTAL

PRE-PRODUCTION GB - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
7/13/2004											**GB CONDITIONING - RUN 2**
GB CR-2											
THC		x									
CO, CO2		X									TOTAL

PRE-PRODUCTION GB - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
7/13/2004											**GB CONDITIONING - RUN 3**
GB CR-3											
THC		x									
CO, CO2		X									TOTAL

PRE-PRODUCTION GB - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
7/14/2004											
RUN 1											
THC	GB001	X									TOTAL
CO, CO2	GB001	X									TOTAL
M-18	GB00101		1						60	1	Carbopak charcoal
M-18	GB00102				1				0		Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GB00103		1						500	5	100/50 mg Silica Gel (SKC 226-10)
NIOSH 2002	GB00104				1				0		100/50 mg Silica Gel (SKC 226-10)
	Excess								500	6	Excess
NIOSH 1500	GB00105		1						500	7	100/50 mg Charcoal (SKC 226-01)
NIOSH 1500	GB00106				1				0		100/50 mg Charcoal (SKC 226-01)
	Excess								500	8	Excess
TO11	GB00107		1						850	9	DNPH Silica Gel (SKC 226-119)
TO11	GB00108				1				0		DNPH Silica Gel (SKC 226-119)
	Excess								850	10	Excess
	Excess								850	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

PRE-PRODUCTION GB - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
7/14/2004											
RUN 2											
THC	GB002	X									TOTAL
CO, CO2	GB002	X									TOTAL
M-18	GB00201		1						60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GB00202		1						500	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								500	6	Excess
NIOSH 1500	GB00203		1						500	7	100/50 mg Charcoal (SKC 226-01)
	Excess								500	8	Excess
TO11	GB00204		1						850	9	DNPH Silica Gel (SKC 226-119)
	Excess								850	10	Excess
	Excess								850	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

PRE-PRODUCTION GB - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
7/14/2004											
RUN 3											
THC	GB003	X									TOTAL
CO, CO2	GB003	X									TOTAL
M-18	GB00301		1						60	1	Carbopak charcoal
M-18	GB00302			1					60	2	Carbopak charcoal
M-18 MS	GB00303			1					60	3	lost
	Excess								60	4	Excess
NIOSH 2002	GB00304		1						500	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								500	6	Excess
NIOSH 1500	GB00305		1						500	7	100/50 mg Charcoal (SKC 226-01)
	Excess								500	8	Excess
TO11	GB00306		1						850	9	DNPH Silica Gel (SKC 226-119)
	Excess								850	10	Excess
	Excess								850	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

PRE-PRODUCTION GB - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
7/15/2004											
RUN 4											
THC	GB004	X									TOTAL
CO, CO2	GB004	X									TOTAL
M-18	GB00401		1						60	1	Carbopak charcoal
M-18 MS	GB00402		1						60	2	Carbopak charcoal
M-18 MS	GB00403			1					60	3	Carbopak charcoal
	Excess								60	4	Excess
NIOSH 2002	GB00404		1						500	5	100/50 mg Silica Gel (SKC 226-10)
NIOSH 2002	GB00405			1					500	6	100/50 mg Silica Gel (SKC 226-10)
NIOSH 1500	GB00406		1						500	7	100/50 mg Charcoal (SKC 226-01)
NIOSH 1500	GB00407			1					500	8	100/50 mg Charcoal (SKC 226-01)
TO11	GB00408		1						850	9	DNPH Silica Gel (SKC 226-119)
TO11	GB00409			1					850	10	DNPH Silica Gel (SKC 226-119)
	Excess								850	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

PRE-PRODUCTION GB - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
7/15/2004											
RUN 5											
THC	GB005	X									TOTAL
CO, CO2	GB005	X									TOTAL
M-18	GB00501		1						60	1	Carbopak charcoal
M-18	GB00502					1			60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								40	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GB00503		1						500	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								500	6	Excess
NIOSH 1500	GB00504		1						500	7	100/50 mg Charcoal (SKC 226-01)
	Excess								500	8	Excess
TO11	GB00505		1						850	9	DNPH Silica Gel (SKC 226-119)
	Excess								850	10	Excess
	Excess								850	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

PRE-PRODUCTION GB - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
7/15/2004											
RUN 6											
THC	GB006	X									TOTAL
CO, CO2	GB006	X									TOTAL
M-18	GB00601		1						60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GB00602		1						500	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								500	6	Excess
NIOSH 1500	GB00603		1						500	7	lost
	Excess								500	8	Excess
TO11	GB00604		1						850	9	DNPH Silica Gel (SKC 226-119)
	Excess								850	10	Excess
	Excess								850	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

PRE-PRODUCTION GB - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
7/16/2004											
RUN 7											
THC	GB007	X									TOTAL
CO, CO2	GB007	X									TOTAL
M-18	GB00701		1						60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GB00702		1						500	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								500	6	Excess
NIOSH 1500	GB00703		1						500	7	100/50 mg Charcoal (SKC 226-01)
	Excess								500	8	Excess
TO11	GB00704		1						850	9	DNPH Silica Gel (SKC 226-119)
	Excess								850	10	Excess
	Excess								850	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

PRE-PRODUCTION GB - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
7/16/2004											
RUN 8											
THC	GB008	X									TOTAL
CO, CO2	GB008	X									TOTAL
M-18	GB00801		1						60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GB00802		1						500	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								500	6	Excess
NIOSH 1500	GB00803		1						500	7	100/50 mg Charcoal (SKC 226-01)
	Excess								500	8	Excess
TO11	GB00804		1						850	9	DNPH Silica Gel (SKC 226-119)
	Excess								850	10	Excess
	Excess								850	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

PRE-PRODUCTION GB - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
7/16/2004											
RUN 9											
THC	GB009	X									TOTAL
CO, CO2	GB009	X									TOTAL
M-18	GB00901		1						60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GB00902		1						500	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								500	6	Excess
NIOSH 1500	GB00903		1						500	7	100/50 mg Charcoal (SKC 226-01)
	Excess								500	8	Excess
TO11	GB00904		1						850	9	DNPH Silica Gel (SKC 226-119)
	Excess								850	10	Excess
	Excess								850	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

Technikon Test Plan

> **CONTRACT NUMBER**: 8011 **TASK NUMBER**: 001 **SERIES**: GC

> **SITE:** Pre-production

> **TEST TYPE:** Product: PCS Combination Greensand plus pattern release as a seacoal substitute

> **METAL TYPE:** Class-30 gray iron

> **MOLD TYPE:** Coated core in virgin greensand with 7% western bentonite from a premix also containing organic starch, cellulose, and H&G Kwik Mull ® polymer.

> **NUMBER OF MOLDS**: Three engineering & conditioning runs + 3 sampling runs. Six (6) molds total.

> **CORE TYPE:** Step: 1.4 % Ashland ISOCURE ® Phenolic Urethane LF305 part I (55%), 904GR Part II (45%), amine cured plus 5% (BOS) H&G Vein Away HT, 50-120 hrs old.

> **CORE COATING:** Test cores shall be coated with Ashland Velva Plast CWG9022SL core coating and dried at 275 F.

> **SAMPLE EVENTS:** Three (3)

> **TEST DATE:** **START:** 9 Aug 2004
> **FINISHED:** 13 Aug 2004

TEST OBJECTIVES:

Measure the airborne pouring, cooling, & shakeout emissions from seacoal free composite cored greensand mold with graphite added to the mold surface with pattern release agent as seacoal replacement. Compare emissions and surface appearance to the composite greensand baseline GB.

VARIABLES:

The pattern will be the 4-on step core. The mold will be made with Wexford W450 Lakesand, and sufficient H&G Premix containing 95.4 % western bentonite, 3.0 % cellulose, 1.0 % Starch, 0.5 % soda ash, & Kwick Mull at a rate of 240 ozs. per ton of premix to yield 7.0 +/- 0.5 % MB Clay, tempered to 45-50% compactability and mechanically compacted. The molds will be maintained at 75-85 ^{o}F prior to pouring. The sand heap will be maintained at 900 pounds. Molds will be poured with iron at 2630 +/- 10 ^{o}F. Mold cooling will be 45 minutes followed by 15 minutes of shakeout, or until no more material remains to be shaken out, followed by 15 minutes additional sampling for a total of 75 minutes. Cores will be made with Wedron 530 silica sand at 80-90 ^{o}F and made in an 80-90 F heated enclosed core machine. The cores will contain 1.4 % (BOS)

Ashland ISOCURE core binder with 5 % (BOS) H&G Vein Away HT anti-veining compound. No emission sampling will be done during core manufacture. The cores will be dip coated in Ashland Velvaplast® core coating and dried at 275^{o}F.

BRIEF OVERVIEW:

After several hundred published emission tests characterizing greensand molding materials the industry material suppliers are reformulating greensand additives and methods of adding those additives to the mold with the intent of optimizing emission reduction without sacrificing casting quality. This test is one of the first to do a full compliment of emission reduction strategies in one mold.

SPECIAL CONDITIONS:

The process will include rigorous maintenance of the size of sand heap and maintenance of the material and environmental testing temperatures to reduce seasonal and daily temperature dependent influence on the emissions. Initially a 1300 pound greensand heap will be created from a single muller batch. Nine hundred pounds will become the re-circulating heap. The balance will be used to makeup for attrition. The cores shall be maintained at 80-90^{o}F awaiting insertion in the mold. The cores shall be stabilized for 50-120 hours when tested.

Series GC

PCS product test: Coated Core with Ashland 305/904 ISOCURE® Core Binder & VeinAwayHT® Anti-Veining additive, Virgin Greensand with H&G Premix®, AQUA PART II- Graphite Pattern release, & Mechanized Molding

Process Instructions

A. Experiment:

1. Measure pouring, cooling, & shakeout emissions from coated organic cores in a greensand mold made with all virgin Wexford W450 sand, bonded with H& G premix to yield 7.0 +/- 0.5% MB Clay. The molds shall be tempered with potable water to 45-50% compactability in the mold, poured at constant weight, temperature, surface area, & shape factor. This test will recycle the same mold material, replacing burned clay with new Premix materials after each casting cycle and providing Premix for the retained core sand. Emissions & surface appearance will be compared to the greensand core composite baseline GB.

B. Materials:

1. Mold sand: Virgin mix of Wexford W450 lake sand & H&G Premix® containing Western Bentonite, Cellulose, starch, Soda ash, and H&G Kwik Mull® polymeric additive.
2. Core: Step cores made with virgin Wedron 530 sand and 1.4 % Ashland ISOCURE® LF305/52-904GR regular phenolic urethane binder in a 55/45 ratio, TEA catalyzed. H&G VEIN AWAY HT® at rate of 5% (BOS).
3. Ashland Velvaplast® CWG9022SL core coating.
4. Metal: Class-30 gray cast iron poured at 2630 +/- 10^{o}F.
5. Pattern release: H&G AQUA PART II-Graphite sprayed on 20 gm/mold half.

C. Briefing:

1. The Process Engineer, Emissions Engineer, and the area Supervisor will brief the operating personnel on the requirements of the test at least one (1) day prior to the test.

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

D. ISOCURE® regular Step Cores:

1. Klein vibratory core sand mixer.
   - **a.** Pre-weigh sand, Vein Away HT, and binder per recipe for four (4) fifty pound batches.
   - **b.** The components should be 75-85^{o}F.
   - **c.** Attach the day tanks with the intended part I and part II binder components via respective binder shut-off valves so that they gravity feed to the respective pumps. The binder components should be 80-85^{o}F.

d. On the main control panel turn the AUTO/MAN switch to MANUAL, turn on main disconnect and MASTER START push button.
e. Fill the Part I and Part II pumps and de-air the lines.
f. Calibrate the Klein mixer.
  1) Remove the mixing bowl skirt to gain access to the binder injection tubes and the bottom side of the batch hopper outlet gate.
  2) Calibrate sand. Recalibrate for each sand mixture used.
    a) Turn the AUTO/MAN switch to MANUAL on main control panel.
    b) Place one bucket of preheated sand, raw, or containing one of the iron oxides, of at least fifty-two (52) pounds net weight, into the sand hopper and manually fill batch hopper using max.and min. proximity switches.
    c) Discharge the sand from the batch hopper using the single cycle push button. Catch the sand as it leaves the batch hopper and record the net weight and the dispensing time.
    d) Repeat 3 times to determine the weight variation. The sand should be 80-85^{o}F.

  3) Calibrate the binder pumps.
    a) Adjust the part I dispensing rate by adjusting the part I pump stroke to be 55% of 1.4 % (0.77 % BOS) of the average sand batch weight dispensed in D.2.e.2).
    b) Adjust the machine's inlet air pressure to dispense the binder in about the same time as the sand is dispensed, about 10-15 seconds.
    c) Record the pressure and dispensing time, and net weight.
    d) Repeat 3 times to determine the variation in dispensing rate.
    e) Adjust the part II dispensing rate by adjusting the part II pump stroke to be 45 % of 1.4 % (.63% BOS) of the average sand rate dispensed in D.2.e.2).
    f) Repeat D.2.d.3).c), & d) for Part II pump.

  4) Turn off the mixer and replace the mixing bowl skirt.

g. Turn on the mixer and turn the AUTO/MAN switch to Auto.
h. Press the SINGLE CYCLE push button on the operators station to make a batch of sand.
i. As soon as the sand enters the mix chamber add the pre-weighed H&G Vein Away HT.
j. Make a batch of sand for every 7 core machine cycles when using the step core. About two (2) batches will be retained in the core machine sand magazine. Make three (3) batches to start the Redford Carver core machine.
k. Clean the mixer when done.

Caution: Do not make more sand than sand magazine will hold plus one (1) batch. If too much sand is made the sand will be exposed to captured TEA and significantly shorten the sand bench life.

2. Redford/Carver core machine.

a. Mount the Step-Core core box on the Carver/Redford core machine.
b. Start the core machine auxiliary equipment per the Production Foundry OSI for that equipment.
c. Set up the core machine in the cold box mode with gassing and working pressures and gas and purge time according to the core recipe sheet.
d. Core process setup
  1) Set the TEA to a nominal 5 grams per blow (gas time 0.75 sec (R/C), flow .019 lbs/sec (Luber).
  2) Set the blow pressure to 30+/-2 psi for 3 seconds (R/C).
  3) Set the max purge pressure to 45 psi on the Luber gas generator.
  4) Purge for 20 seconds(R/C) with a 10 second rise time (Luber).
  5) Total cycle time approximately 1 minute.

e. Run the core machine for three (3) cycles and discard the cores. When the cores appear good begin test core manufacture. Five (5) good cores are required for each mold. Make five (5) additional 50 pound sand batches and run the sand out making core. A minimum of 35 cores are required.
f. One half hour to 1 hour after manufacture randomly perform a scratch hardness test on the outer edge of the blow surface on 10 % of the cores and record the results on the Core Production Log. Values less than 25 shall be marked with a HOLD TAG until they can be 100 % scratch hardness tested to re-qualify. Contact the Process Engineer for disposition on all cores with values less than 15 after 1 hour. Weigh each core and log the results.
g. The sand lab will sample, at the time of manufacture, one (1) core from each row of each shelf (1 of 11) on each core rack. Those cores will be tested for LOI using the standard 1800 ^{o}F core LOI test method and reported out associated with the core rack shelf it represents. Qualified cores receiving the green **Quality Checked** tag must have **LOI** values between 1.25-1.50 %. Individual rows that qualify may have the **Quality Checked** tag affixed. Only cores with the green Quality Tag bearing the current test series and dates and signature of the lab technician and core rack/shelf/position on shelf may be taken to the mold assembly area.

Note: The core rack position from the Quality Checked tag shall be transferred to the mold assembly check list with the core weights.

h. The sand lab will sample one (1) core from the core rack for each mold produced just prior to the emission test to represent the four (4) cores placed in that mold. Those cores will be tested for LOI using the standard 1800 ^{o}F core LOI test method and reported out associated with the test mold it is to represent.

3. Core coating.
a. Ashland Velvaplast® CGW 9022 SL core coating material will be used to dip coat the cores.
b. Weigh the uncoated core and log the weight.
c. Coat the entire core up to the ½ inch from the invest side.
d. Normalize the core coating temperature to 70 -80 ^{o}F.

e. Dip the core into the core wash and hold for a count of two(2).
f. Shake the core vertically until the coating ceases to drip.
g. Place the core invest side down on the OSI oven lear (chain belt).
h. Dry the core at 275 ^{o}F for 1 hour in the OSI core drying oven.
i. Weigh the dried and cooled coated core and log the weight.

E. Sand preparation

1. Start up batch: make 1, GCCD1

a. Thoroughly clean the pre-production muller, elevator, and molding hoppers.
b. Weigh and add **1203 +/-10** pounds of new Wexford W450 lakesand, per the recipe, to the pre-production muller to make a 1300 batch.
c. Add 5 pounds of potable to the muller to suppress dust distributing it across the sand. Allow to mix for 1 minute.
d. Add **97** pounds of H&G Premix slowly to the muller to allow it to be distributed throughout the sand mass in proportion to the sand weight per the recipe for this test.
e. Dry mull for about 3 minutes to allow distribution and some grinding of the clays to occur.
f. Temper the sand-clay mixture slowly, with potable water, to allow for distribution.
g. After about 2 gallons of water have been added allow 30 seconds of mixing then start taking compactability test samples.
h. Based on each test add water incrementally to adjust the temper. Allow 1 minute of mixing. Retest. Repeat until the compactability is in the range 45-50%.
i. Discharge the sand into the mold station elevator.
j. Grab sufficient sample after the final compactability test to fill a quart zip-lock bag. Label bag with the test series and sequence number, date, and time of day and deliver it immediately to the sand lab for analysis
k. Record the total sand mixed in the batch, the total premix added to the batch, the amount of water added, the total mix time, the final compactability and sand temperature at discharge.
l. The sand will be characterized for Methylene Blue Clay, Moisture content, Compactability, Green Compression strength, 1800^{o}F loss on ignition (LOI), and 900 ^{o}F volatiles, and permeability. Each volatile and LOI test requires a separate 50 gram sample from the collected sand.
m. Empty the extra greensand from the mold hopper into a clean empty dump hopper whose tare weight is known. Set this sand aside to be used to maintain the recycled batch at 900+/-10 pounds

2. Re-mulling: GCCD2, GCCD3, & GC4-6

a. Add to the sand recovered from poured mold **GCCD1** sufficient pre-blended sand so that the sand batch weight is 900 +/- 10 pounds. Record the sand weight.
b. Return the sand to the muller and dry blend for about one minute.
c. **Add Premix**, as directed by the process engineering staff, slowly to the muller to allow them to be distributed throughout the sand mass.
d. Add 5 pounds of water to the muller to suppress dust distributing it across the sand. Allow to mix for 1 minute.
e. Follow the above procedure beginning at E.1.f.

F. Molding: Step core 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. Mount the drag pattern on one Osborne Whisper Ram molding machine and mount the cope pattern on the other Osborne machine.

b. Paint on H&G AQUA-PART II – Graphite pattern release on the pattern particularly in the corners and recesses totaling 40+/- 2 gms per mold.

1) Weigh the spray container before and after application to determine the amount applied. Record the pre and post weight and amount dispensed.

Caution: Do not pour gross amounts of parting oil on the pattern to be blown of 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.

3. Use the overhead crane to place the pre-weighed drag/cope flask on the mold machine table, parting line surface down.

4. Locate a 24 x 24 x4 inch deep wood upset on top of the flask.

5. Make the green sand mold cope or drag on the Osborn Whisper Ram Jolt-Squeeze mold machine

WARNING: Only properly trained personnel may operate this machine. Proper personal protective equipment must be worn at all times while operating this equipment, including safety glasses with side shields and a properly fitting hard hat. Industrial type boots are highly recommended.

WARNING: Stand clear of the mold machine table and swinging head during the following operation or serious injury or death could result.

a. Open the air supply to the mold machine.

WARNING: The squeeze head may suddenly swing to the outboard side or forward. Do not stand in the outer corners of the molding enclosure.

b. On the operator's panel turn the POWER switch to ON.

c. Turn the RAM-JOLT-SQUEEZE switch to ON.

d. Turn the DRAW UP switch to AUTO

e. Set the PRE-JOLT timer to 4-5 seconds.

f. Set the squeeze timer to 8 seconds.

g. Set the crow-footed gagger on the support bar. Verify that it is at least ½ inch away from any pattern parts.

h. Manually riddle a half to one inch or so of sand on the pattern using a ¼ inch mesh riddle. Source the sand from the overhead mold sand hopper by actuating the CHATTER GATE valve located under the operators panel.

- **i.** Fill the center potion of the flask.
- **j.** Manually move sand from the center portion to the outboard areas and hand tuck the sand.
- **k.** Finish filling the 24 x 24 x 10 inch flask and the upset with greensand from the overhead molding hopper.
- **l.** Manually level the sand in the upset. By experience manually adjust the sand depth so that the resulting compacted mold is fractionally above the flask only height.
- **m.** Initiate the settling of the sand in the flask by pressing the PRE-JOLT push button. Allow this cycle to stop before proceeding.
- **n.** Remove the upset and set it aside.

WARNING: Failure to stand clear of the molding table and flasks in the following operations could result in serious injury as this equipment is about to move up and down with great force.

WARNING: Stand clear of the entire mold machine during the following operations. Several of the machine parts will be moving. Failure to stand clear could result in severe injury even death.

- **o.** Using both hands initiate the automatic machine sequence by simultaneously pressing, holding for 2-3 seconds, and releasing the green push buttons on either side of the operators panel. The machine will squeeze and jolt the sand in the flask and then move the squeeze head to the side.

WARNING: Do not re-approach the machine until the squeeze head has stopped at the side of the machine.

- **p.** Screed the bottom of the drag mold flat to the bottom of the flask if required.
- **q.** Press and release the LOWER DRAW/STOP push button to separate the flask and mold from the pattern.
- **r.** Use the overhead crane to lift the mold half and remove it from the machine. If the mold half is a drag, roll it parting line side up, set it on the floor, blow it out.
- **s.** Finally, press and release the DRAW DOWN pushbutton to cause the draw frame to return to the start position.

6. Set four (4) step cores that have been weighed and logged into the drag. Verify that the cores are fully set and flush with the parting line.
7. Close the cope over the drag being careful not to crush anything.
8. Clamp the flask halves together.
9. Weigh and record the weight of the closed un-poured mold, the pre-weighed flask, the coated cores, and the sand weight by difference.
10. Measure and record the sand temperature.
11. Deliver the mold to the previously cleaned shakeout to be poured.
12. Cover the mold with the emission hood.

G. Pig molds

1. Each day make a 900 pound capacity pig mold for the following day’s use.

H. Emission hood:

1. Loading.

a. Hoist the mold onto the shakeout deck within the emission hood.
b. Close, seal, and lock the emission hood
c. Adjust the ambient air heater control so that the measured temperature of the blended air within the hood is 85-90^{o}F at the start of the test run.

2. Shakeout.

a. After the 45 minute cooling time prescribed in the emission sample plan has elapsed turn on the shakeout unit and run for it the 15 minutes prescribed in the emission sample plan or until the sand has all fallen through the grating.
b. Turn off the shakeout.
c. Sample the emissions for 30 minutes after the start of shakeout, a total of 75 minutes.

3. When the emission sampling is completed remove the flask with casting, and recover the sand from the hopper and surrounding floor.

a. Weigh and record the metal poured and the total sand weight recovered and rejoined with the left over mold sand from the molding hopper, spilled molding sand, and sand loosely adhered to the casting.
b. Add sufficient unused premixed sand to the recycled sand to return the sand heap to 900 +/- 10 pounds.

I. Melting:

1. Initial iron 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 of the steel.
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 metallics under full power until all is melted and the temperature has reached 2600 to 2700 ^{o}F.
f. Slag the furnace and add the balance of the alloys.
g. Raise the temperature of the melt to 2700 ^{o}F and take a DataCast 2000 sample. The temperature of the primary liquidus (TPL) must be in the range of 2200-2350^{o}F.
h. Hold the furnace at 2500-2550^{o}F until near ready to tap.
i. When ready to tap raise the temperature to 2700^{o}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 I.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.

J. Pouring:
1. Preheat the ladle.
  a. Tap 400 pounds more or less of 2700^{o}F iron into the cold ladle.
  b. Carefully pour the metal back to the furnace.
  c. Cover the ladle.
  d. Reheat the metal to 2780 +/- 20^{o}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 and wait until the metal temperature reaches 2630 +/- 10^{o}F.
  h. Commence pouring keeping the sprue full.
  i. Upon completion return the extra metal to the furnace, and cover the ladle.
  j. Record the pour temperature and pour time on the heat log

K. Rank order evaluation.
1. The supervisor shall select a group of five persons to make a collective subjective judgment of the casting relative surface appearance.
2. Review the general appearance of the castings and select specific casting features to compare.
3. For cavity 3 only:
  a. Place each casting initially in sequential mold number order.
  b. Beginning with casting from mold GC001 compare it to castings from mold GC002.
  c. Place the better appearing casting in the first position and the lesser appearing casting in the second position.
  d. Repeat this procedure with GC001 to its nearest neighbors until all castings closer to the beginning of the line are better appearing than GC001 and the next casting farther down the line is inferior.
  e. Repeat this comparison to next neighbors for each casting number.
  f. When all casting numbers have been compared go to the beginning of the line and begin again comparing each casting to its nearest neighbor. Move the castings so that each casting is inferior to the next one closer to the beginning of the line and superior to the one next toward the tail of the line.
  g. Repeat this comparison until all concur with the ranking order.

4. Record mold number by rank-order series for this cavity.

Steven M. Knight
Mgr. Process Engineering

PRE-PRODUCTION GC - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/9/2004											**GC CONDITIONING - RUN 1**
GC CR-1											
THC		x									
CO, CO2		x									

PRE-PRODUCTION GC - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/9/2004											**GC CONDITIONING - RUN 2**
GC CR-2											
THC		x									
CO, CO2		x									

PRE-PRODUCTION GC - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/9/2004											**GC CONDITIONING - RUN 3**
GC CR-3											
THC		x									
CO, CO2		x									

PRE-PRODUCTION GC - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/10/2004											
RUN 1											
THC	GC001	X									TOTAL
M-18	GC00101		1						60	1	Carbopak charcoal
M-18	GC00102				1				0		Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 1500	GC00103		1						1000	5	100/50 mg Charcoal (SKC 226-01)
NIOSH 1500	GC00104				1				0		100/50 mg Charcoal (SKC 226-01)
	Excess								1000	6	Excess
NIOSH 2002	GC00105		1						1000	7	100/50 mg Silica Gel (SKC 226-10)
NIOSH 2002	GC00106				1				0		100/50 mg Silica Gel (SKC 226-10)
	Excess								1000	8	Excess
TO11	GC00107		1						1000	9	DNPH Silica Gel (SKC 226-119)
TO11	GC00108				1				0		DNPH Silica Gel (SKC 226-119)
	Excess								1000	10	Excess
	Excess								1000	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

PRE-PRODUCTION GC - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/10/2004											
RUN 2											
THC	GC002	X									TOTAL
M-18	GC00201		1						60	1	Carbopak charcoal
M-18	GC00202			1					60	2	Carbopak charcoal
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 1500	GC00203		1						1000	5	100/50 mg Charcoal (SKC 226-01)
NIOSH 1500	GC00204			1					1000	6	100/50 mg Charcoal (SKC 226-01)
NIOSH 2002	GC00205		1						1000	7	100/50 mg Silica Gel (SKC 226-10)
NIOSH 2002	GC00206			1					1000	8	100/50 mg Silica Gel (SKC 226-10)
TO11	GC00207		1						1000	9	DNPH Silica Gel (SKC 226-119)
TO11	GC00208			1					1000	10	DNPH Silica Gel (SKC 226-119)
	Excess								1000	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

PRE-PRODUCTION GC - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/10/2004											
RUN 3											
THC	GC003	X									TOTAL
M-18	GC00301		1						60	1	Carbopak charcoal
M-18	GC00302					1			60	1	Carbopak charcoal
M-18 MS	GC00303		1						60	2	Carbopak charcoal
M-18 MS	GC00304			1					60	3	Carbopak charcoal
	Excess								60	4	Excess
NIOSH 1500	GC00305		1						1000	5	100/50 mg Charcoal (SKC 226-01)
	Excess								1000	6	Excess
NIOSH 2002	GC00306		1						1000	7	100/50 mg Silica Gel (SKC 226-10)
	Excess								1000	8	Excess
TO11	GC00307		1						1000	9	DNPH Silica Gel (SKC 226-119)
	Excess								1000	10	Excess
	Excess								1000	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

this page intentionally left blank

APPENDIX B TEST SERIES GB AND GC DETAILED EMISSION RESULTS

this page intentionally left blank

Test Plan GB Individual Emission Test Results – Lb/Lb Binder

HAPs	POMs	COMPOUND/SAMPLE NUMBER	GB001	GB002	GB003	GB004	GB005	GB006	GB007	GB008	GB009	Average	STDEV
		Test Dates	**7/14/04**	**7/14/04**	**7/14/04**	**7/15/04**	**7/15/04**	**7/15/04**	**7/16/04**	**7/16/04**	**7/16/04**		
		TGOC as Propane	3.26E-01	3.65E-01	3.02E-01	3.05E-01	3.60E-01	2.84E-01	3.42E-01	2.95E-01	2.82E-01	3.18E-01	3.16E-02
		HC as Hexane	1.01E-01	1.11E-01	1.04E-01	1.08E-01	1.20E-01	I	1.06E-01	1.11E-01	9.65E-02	1.07E-01	7.33E-03
		Sum of VOCs	8.66E-02	8.62E-02	8.29E-02	7.86E-02	9.17E-02	8.46E-02	8.89E-02	8.51E-02	7.62E-02	8.45E-02	4.81E-03
		Sum of HAPs	7.33E-02	7.16E-02	6.87E-02	6.68E-02	7.63E-02	6.99E-02	7.31E-02	7.04E-02	6.23E-02	7.03E-02	4.08E-03
		Sum of POMs	8.18E-03	6.51E-03	6.82E-03	5.20E-03	7.16E-03	8.35E-03	7.68E-03	6.74E-03	9.25E-03	7.32E-03	1.19E-03
			Individual Organic HAPs										
x		**Benzene**	2.30E-02	2.56E-02	2.41E-02	2.50E-02	2.77E-02	1.88E-02	2.41E-02	2.36E-02	2.05E-02	2.36E-02	2.65E-03
x		**Toluene**	1.05E-02	1.05E-02	9.82E-03	1.01E-02	1.09E-02	8.84E-03	1.03E-02	1.03E-02	I	1.01E-02	6.16E-04
x		**Phenol**	1.01E-02	8.93E-03	9.20E-03	8.16E-03	1.03E-02	1.23E-02	9.71E-03	9.71E-03	1.17E-02	1.00E-02	1.31E-03
x		**m,p-Xylene**	5.19E-03	4.93E-03	4.66E-03	4.71E-03	5.05E-03	4.45E-03	4.78E-03	4.92E-03	4.31E-03	4.78E-03	2.82E-04
x		**o-Cresol**	3.83E-03	3.19E-03	3.47E-03	3.07E-03	3.69E-03	4.67E-03	3.93E-03	3.53E-03	4.63E-03	3.78E-03	5.63E-04
x		**Aniline**	2.89E-03	2.59E-03	2.07E-03	1.89E-03	2.40E-03	3.84E-03	3.37E-03	2.63E-03	3.22E-03	2.77E-03	6.28E-04
x	z	**Naphthalene**	2.72E-03	2.30E-03	2.53E-03	2.08E-03	2.67E-03	2.93E-03	2.58E-03	2.72E-03	3.20E-03	2.64E-03	3.25E-04
x		**o-Xylene**	2.65E-03	2.56E-03	2.32E-03	2.33E-03	2.60E-03	2.25E-03	2.47E-03	2.41E-03	2.18E-03	2.42E-03	1.61E-04
x		**Hexane**	2.26E-03	2.49E-03	2.12E-03	2.03E-03	2.03E-03	1.49E-03	2.33E-03	2.17E-03	1.88E-03	2.09E-03	2.88E-04
x	z	**2-Methylnaphthalene**	2.45E-03	1.91E-03	1.92E-03	1.44E-03	2.03E-03	2.27E-03	2.23E-03	1.88E-03	2.60E-03	2.08E-03	3.48E-04
x		**Ethylbenzene**	1.36E-03	1.30E-03	1.20E-03	1.21E-03	1.32E-03	1.15E-03	1.26E-03	1.25E-03	1.11E-03	1.24E-03	8.02E-05
x	z	**1-Methylnaphthalene**	1.39E-03	1.09E-03	1.13E-03	8.60E-04	1.20E-03	1.40E-03	1.32E-03	1.14E-03	1.62E-03	1.24E-03	2.20E-04
x		**m,p-Cresol**	1.11E-03	9.34E-04	1.10E-03	8.98E-04	1.04E-03	1.36E-03	1.22E-03	9.49E-04	1.39E-03	1.11E-03	1.80E-04
x		**Acetaldehyde**	1.12E-03	1.09E-03	9.92E-04	1.08E-03	1.03E-03	1.15E-03	9.83E-04	9.97E-04	9.05E-04	1.04E-03	7.71E-05
x	z	**1,3-Dimethylnaphthalene**	6.28E-04	4.69E-04	4.81E-04	3.73E-04	4.95E-04	6.24E-04	6.10E-04	4.70E-04	7.31E-04	5.42E-04	1.11E-04
x		**Styrene**	5.10E-04	4.86E-04	4.62E-04	4.67E-04	4.90E-04	4.65E-04	4.59E-04	4.98E-04	4.34E-04	4.75E-04	2.32E-05
x	z	**1,6-Dimethylnaphthalene**	2.96E-04	2.23E-04	2.31E-04	1.77E-04	2.34E-04	2.88E-04	2.84E-04	2.20E-04	3.39E-04	2.55E-04	5.01E-05
x		**Formaldehyde**	2.46E-04	1.63E-04	2.88E-04	3.30E-04	2.12E-04	2.83E-04	1.55E-04	3.11E-04	3.00E-04	2.54E-04	6.44E-05
x		**2-Butanone**	2.41E-04	2.37E-04	I	2.57E-04	2.64E-04	2.79E-04	2.32E-04	2.87E-04	2.58E-04	2.57E-04	1.96E-05
x	z	**2,6-Dimethylnaphthalene**	2.30E-04	1.71E-04	1.75E-04	1.30E-04	1.78E-04	2.15E-04	2.16E-04	1.59E-04	2.53E-04	1.92E-04	3.88E-05
x	z	**2,7-Dimethylnaphthalene**	2.30E-04	1.71E-04	1.75E-04	1.30E-04	1.78E-04	2.15E-04	2.16E-04	1.59E-04	2.53E-04	1.92E-04	3.88E-05
x	z	**2,3-Dimethylnaphthalene**	2.35E-04	1.77E-04	1.82E-04	ND	1.85E-04	2.28E-04	2.26E-04	ND	2.66E-04	1.67E-04	9.89E-05
x		**Propionaldehyde**	1.27E-04	1.22E-04	1.14E-04	1.23E-04	1.13E-04	1.25E-04	1.05E-04	1.11E-04	9.96E-05	1.16E-04	9.42E-06
x	z	**1,5-Dimethylnaphthalene**	ND	ND	ND	ND	ND	1.75E-04	ND	ND	I	2.19E-05	6.19E-05
x		**Biphenyl**	ND	ND	ND	ND	ND	ND	ND	ND	1.81E-04	2.02E-05	6.05E-05
x	z	**Acenaphthalene**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA

Test Plan GB Individual Emission Test Results – Lb/Lb Binder

HAPs	POM	COMPOUND/SAMPLE NUMBER	GB001	GB002	GB003	GB004	GB005	GB006	GB007	GB008	GB009	Average	STDEV
		Test Dates	7/14/04	7/14/04	7/14/04	7/15/04	7/15/04	7/15/04	7/16/04	7/16/04	7/16/04		
x	z	**1,2-Dimethylnaphthalene**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
x	z	**1,8-Dimethylnaphthalene**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
x	z	**2,3,5-Trimethylnaphthalene**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
x		**Dimethylaniline**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
x		**Acrolein**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
			Other VOCs										
		Octane	2.25E-03	2.44E-03	2.37E-03	2.52E-03	2.86E-03	2.15E-03	2.57E-03	2.74E-03	2.25E-03	2.46E-03	2.36E-04
		1,2,4-Trimethylbenzene	1.93E-03	1.69E-03	1.71E-03	1.65E-03	1.82E-03	1.78E-03	1.72E-03	1.88E-03	1.66E-03	1.76E-03	9.89E-05
		Heptane	1.63E-03	1.77E-03	1.39E-03	1.35E-03	1.69E-03	1.34E-03	1.75E-03	1.41E-03	1.28E-03	1.51E-03	1.94E-04
		Undecane	1.38E-03	1.19E-03	1.23E-03	I	1.33E-03	1.28E-03	1.33E-03	1.23E-03	1.34E-03	1.29E-03	6.57E-05
		Nonane	1.10E-03	1.17E-03	9.62E-04	9.43E-04	1.17E-03	9.05E-04	1.12E-03	9.47E-04	9.19E-04	1.03E-03	1.11E-04
		Decane	9.87E-04	1.00E-03	8.64E-04	8.11E-04	1.00E-03	8.15E-04	9.50E-04	8.52E-04	8.37E-04	9.02E-04	8.18E-05
		3-Ethyltoluene	I	8.86E-04	8.56E-04	8.39E-04	9.21E-04	8.69E-04	8.76E-04	9.06E-04	8.12E-04	8.70E-04	3.52E-05
		1,2,3-Trimethylbenzene	8.58E-04	7.63E-04	7.51E-04	7.14E-04	8.15E-04	8.12E-04	7.94E-04	8.26E-04	7.74E-04	7.90E-04	4.40E-05
		Dodecane	7.21E-04	6.54E-04	7.79E-04	5.68E-04	7.20E-04	6.39E-04	6.94E-04	7.16E-04	I	6.86E-04	6.46E-05
		Indene	7.03E-04	5.94E-04	6.44E-04	6.25E-04	6.65E-04	7.42E-04	6.49E-04	7.09E-04	7.11E-04	6.71E-04	4.79E-05
		2-Ethyltoluene	I	5.70E-04	5.52E-04	5.37E-04	5.82E-04	5.62E-04	5.59E-04	5.90E-04	5.57E-04	5.64E-04	1.70E-05
		Cyclohexane	4.09E-04	6.84E-04	5.60E-04	I	6.53E-04	4.75E-04	5.83E-04	4.67E-04	4.28E-04	5.32E-04	1.03E-04
		Tetradecane	2.91E-04	2.51E-04	2.83E-04	2.40E-04	2.93E-04	3.37E-04	2.99E-04	3.17E-04	4.29E-04	3.04E-04	5.56E-05
		2,4-Dimethylphenol	ND	ND	3.04E-04	ND	ND	7.40E-04	7.77E-04	ND	8.24E-04	2.94E-04	3.78E-04
		Propylbenzene	3.06E-04	2.85E-04	2.71E-04	2.67E-04	3.03E-04	3.05E-04	3.06E-04	2.91E-04	2.85E-04	2.91E-04	1.52E-05
		Benzaldehyde	2.39E-04	2.28E-04	2.32E-04	2.49E-04	2.36E-04	2.59E-04	2.15E-04	2.65E-04	2.20E-04	2.38E-04	1.68E-05
		Crotonaldehyde	1.48E-04	1.38E-04	1.49E-04	9.08E-05	1.50E-04	2.13E-04	1.83E-04	2.30E-04	1.59E-04	1.62E-04	4.16E-05
		Butyraldehyde/Methacrolein	1.19E-04	1.20E-04	1.31E-04	1.27E-04	1.22E-04	I	1.18E-04	1.27E-04	1.11E-04	1.22E-04	6.28E-06
		1,3,5-Trimethylbenzene	ND	ND	ND	ND	ND	3.20E-04	2.99E-04	ND	2.50E-04	9.66E-05	1.46E-04
		o,m,p-Tolualdehyde	9.95E-05	1.00E-04	1.21E-04	1.02E-04	I	1.24E-04	ND	1.01E-04	ND	8.09E-05	5.09E-05
		Pentanal	6.94E-05	5.56E-05	I	5.68E-05	4.84E-05	6.28E-05	4.95E-05	5.65E-05	4.70E-05	5.57E-05	7.63E-06
		Hexaldehyde	3.75E-05	3.75E-05	3.34E-05	1.79E-05	ND	3.93E-05	ND	3.93E-05	ND	2.28E-05	1.83E-05
		1,3-Diethylbenzene	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		2,6-Dimethylphenol	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		Indan	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA

Test Plan GB Individual Emission Test Results – Lb/Lb Binder

HAPs	POMs	COMPOUND/SAMPLE NUMBER	GB001	GB002	GB003	GB004	GB005	GB006	GB007	GB008	GB009	Average	STDEV
		Test Dates	**7/14/04**	**7/14/04**	**7/14/04**	**7/15/04**	**7/15/04**	**7/15/04**	**7/16/04**	**7/16/04**	**7/16/04**		
			Other Analytes										
		Acetone	1.12E-03	1.10E-03	1.04E-03	1.12E-03	1.16E-03	1.17E-03	1.03E-03	1.14E-03	I	1.11E-03	5.23E-05
		Carbon Dioxide	1.42E+00	9.20E-01	1.37E+00	1.58E+00	9.72E-01	1.53E+00	1.00E+00	1.44E+00	1.42E+00	1.30E+00	2.57E-01
		Carbon Monoxide	5.13E-01	6.72E-01	5.00E-01	5.24E-01	6.80E-01	4.28E-01	6.36E-01	4.86E-01	4.93E-01	5.48E-01	9.08E-02

I: Data rejected based on data validation considerations.

ND: Non Detect; NA: Not Applicable

All "Other Analytes" are not included in the Sum of VOCS or HAPs.

Test Plan GB Individual Emission Test Results – Lb/Tn Metal

HAPs	POMs	COMPOUND / SAMPLE NUMBER	GB001	GB002	GB003	GB004	GB005	GB006	GB007	GB008	GB009	Average	STDEV
		Test Dates	**7/14/04**	**7/14/04**	**7/14/04**	**7/15/04**	**7/15/04**	**7/15/04**	**7/16/04**	**7/16/04**	**7/16/04**		
		TGOC as Propane	2.52E+00	2.79E+00	2.37E+00	2.34E+00	2.80E+00	2.17E+00	2.65E+00	2.25E+00	2.17E+00	2.45E+00	2.50E-01
		HC as Hexane	7.78E-01	8.53E-01	8.17E-01	8.35E-01	9.37E-01	I	8.23E-01	8.48E-01	7.42E-01	8.29E-01	5.72E-02
		Sum of VOCs	6.69E-01	6.60E-01	6.51E-01	6.04E-01	7.14E-01	6.37E-01	6.90E-01	6.48E-01	6.51E-01	6.58E-01	3.11E-02
		Sum of HAPs	5.67E-01	5.48E-01	5.39E-01	5.14E-01	5.94E-01	5.24E-01	5.67E-01	5.36E-01	5.48E-01	5.48E-01	2.44E-02
		Sum of POMs	6.32E-02	4.98E-02	5.35E-02	4.00E-02	5.58E-02	6.40E-02	5.96E-02	5.13E-02	7.11E-02	5.65E-02	9.21E-03
								Individual Organic HAPs					
x		**Benzene**	1.78E-01	1.96E-01	1.89E-01	1.92E-01	2.16E-01	1.44E-01	1.87E-01	1.80E-01	1.57E-01	1.82E-01	2.10E-02
x		**Toluene**	8.11E-02	8.00E-02	7.71E-02	7.75E-02	8.49E-02	6.77E-02	7.95E-02	7.82E-02	6.99E-02	7.73E-02	5.39E-03
x		**Phenol**	7.84E-02	6.83E-02	7.22E-02	6.27E-02	8.02E-02	9.45E-02	7.53E-02	7.39E-02	8.99E-02	7.73E-02	9.99E-03
x		**m,p-Xylene**	4.01E-02	3.77E-02	3.66E-02	3.62E-02	3.93E-02	3.41E-02	3.71E-02	3.75E-02	3.31E-02	3.69E-02	2.23E-03
x		**o-Cresol**	2.97E-02	2.44E-02	2.72E-02	2.36E-02	2.87E-02	3.58E-02	3.05E-02	2.69E-02	3.56E-02	2.92E-02	4.32E-03
x		**Aniline**	2.23E-02	1.98E-02	1.63E-02	1.46E-02	1.87E-02	2.94E-02	2.61E-02	2.00E-02	2.48E-02	2.13E-02	4.79E-03
x	z	**Naphthalene**	2.10E-02	1.76E-02	1.98E-02	1.60E-02	2.07E-02	2.25E-02	2.00E-02	2.07E-02	2.46E-02	2.03E-02	2.49E-03
x		**o-Xylene**	2.05E-02	1.96E-02	1.83E-02	1.79E-02	2.02E-02	1.73E-02	1.91E-02	1.83E-02	1.68E-02	1.87E-02	1.28E-03
x		**Hexane**	1.75E-02	1.91E-02	1.67E-02	1.56E-02	1.58E-02	I	1.81E-02	1.65E-02	1.45E-02	1.67E-02	1.47E-03
x	z	**2-Methylnaphthalene**	1.90E-02	1.46E-02	1.51E-02	1.11E-02	1.58E-02	1.74E-02	1.73E-02	1.43E-02	2.00E-02	1.60E-02	2.69E-03
x		**Ethylbenzene**	1.05E-02	9.96E-03	9.45E-03	9.29E-03	1.03E-02	8.78E-03	9.75E-03	9.51E-03	8.57E-03	9.56E-03	6.37E-04
x	z	**1-Methylnaphthalene**	1.07E-02	8.37E-03	8.88E-03	6.61E-03	9.35E-03	1.07E-02	1.02E-02	8.65E-03	1.24E-02	9.55E-03	1.69E-03
x		**m,p-Cresol**	8.56E-03	7.15E-03	8.64E-03	6.90E-03	8.08E-03	1.04E-02	9.48E-03	7.22E-03	1.07E-02	8.57E-03	1.39E-03
x		**Acetaldehyde**	8.63E-03	8.34E-03	7.79E-03	8.27E-03	8.04E-03	8.83E-03	7.63E-03	7.59E-03	6.96E-03	8.01E-03	5.80E-04
x	z	**1,3-Dimethylnaphthalene**	4.86E-03	3.59E-03	3.78E-03	2.87E-03	3.85E-03	4.78E-03	4.73E-03	3.58E-03	5.62E-03	4.18E-03	8.58E-04
x		**Styrene**	3.94E-03	3.72E-03	3.63E-03	3.59E-03	3.81E-03	3.57E-03	3.56E-03	3.79E-03	3.34E-03	3.66E-03	1.77E-04
x		**2-Butanone**	1.86E-03	1.82E-03	I	1.97E-03	2.05E-03	2.14E-03	1.80E-03	2.18E-03	1.99E-03	1.98E-03	1.44E-04
x	z	**1,6-Dimethylnaphthalene**	2.29E-03	1.71E-03	1.82E-03	1.36E-03	1.82E-03	2.21E-03	2.20E-03	1.68E-03	2.61E-03	1.97E-03	3.86E-04
x		**Formaldehyde**	1.90E-03	1.25E-03	2.26E-03	2.53E-03	1.65E-03	2.17E-03	1.20E-03	2.37E-03	2.31E-03	1.96E-03	4.93E-04
x	z	**2,6-Dimethylnaphthalene**	1.78E-03	1.31E-03	1.37E-03	1.00E-03	1.39E-03	1.65E-03	1.68E-03	1.21E-03	1.94E-03	1.48E-03	3.00E-04
x	z	**2,7-Dimethylnaphthalene**	1.78E-03	1.31E-03	1.37E-03	1.00E-03	1.39E-03	1.65E-03	1.68E-03	1.21E-03	1.94E-03	1.48E-03	3.00E-04
x	z	**2,3-Dimethylnaphthalene**	1.82E-03	1.35E-03	1.43E-03	0.00E+00	1.44E-03	1.75E-03	1.75E-03	ND	2.05E-03	1.29E-03	7.63E-04
x		**Propionaldehyde**	9.82E-04	9.31E-04	8.97E-04	9.46E-04	8.81E-04	9.61E-04	8.17E-04	8.44E-04	7.65E-04	8.91E-04	7.18E-05
x	z	**1,5-Dimethylnaphthalene**	ND	ND	ND	ND	ND	1.34E-03	ND	ND	I	1.68E-04	4.75E-04
x	z	**1,2-Dimethylnaphthalene**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
x	z	**1,8-Dimethylnaphthalene**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
x	z	**2,3,5-Trimethylnaphthalene**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA

Test Plan GB Individual Emission Test Results – Lb/Tn Metal

HAPs	POMs	COMPOUND / SAMPLE NUMBER	GB001	GB002	GB003	GB004	GB005	GB006	GB007	GB008	GB009	Average	STDEV
		Test Dates	7/14/04	7/14/04	7/14/04	7/15/04	7/15/04	7/15/04	7/16/04	7/16/04	7/16/04		
x	z	**Acenaphthalene**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
x		**Biphenyl**	ND	ND	ND	ND	ND	ND	ND	ND	I	ND	NA
x		**N,N-Dimethylaniline**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
x		**Acrolein**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
			Other VOCs										
		Octane	1.74E-02	1.87E-02	1.86E-02	1.93E-02	2.22E-02	1.65E-02	1.99E-02	2.08E-02	1.73E-02	1.90E-02	1.84E-03
		1,2,4-Trimethylbenzene	1.49E-02	1.30E-02	1.34E-02	1.27E-02	1.41E-02	1.37E-02	1.33E-02	1.43E-02	1.28E-02	1.36E-02	7.60E-04
		Heptane	1.26E-02	1.35E-02	1.09E-02	1.04E-02	1.31E-02	1.03E-02	1.36E-02	1.07E-02	9.88E-03	1.17E-02	1.52E-03
		Undecane	1.06E-02	9.09E-03	9.68E-03	I	1.04E-02	9.83E-03	1.03E-02	9.38E-03	1.03E-02	9.95E-03	5.41E-04
		Nonane	8.50E-03	8.94E-03	7.56E-03	7.25E-03	9.11E-03	6.94E-03	8.69E-03	7.21E-03	7.06E-03	7.92E-03	8.78E-04
		Decane	7.63E-03	7.65E-03	6.78E-03	6.23E-03	7.81E-03	6.25E-03	7.37E-03	6.49E-03	6.44E-03	6.96E-03	6.51E-04
		3-Ethyltoluene	I	6.78E-03	6.72E-03	6.45E-03	7.17E-03	6.66E-03	6.79E-03	6.89E-03	6.24E-03	6.71E-03	2.79E-04
		1,2,3-Trimethylbenzene	6.63E-03	5.84E-03	5.90E-03	5.48E-03	6.35E-03	6.22E-03	6.16E-03	6.29E-03	5.95E-03	6.09E-03	3.38E-04
		Dodecane	5.57E-03	5.01E-03	6.12E-03	4.36E-03	5.60E-03	4.90E-03	5.38E-03	5.45E-03	I	5.30E-03	5.33E-04
		Indene	5.44E-03	4.55E-03	5.05E-03	4.80E-03	5.17E-03	5.69E-03	5.04E-03	5.40E-03	5.46E-03	5.18E-03	3.59E-04
		2-Ethyltoluene	I	4.36E-03	4.33E-03	4.12E-03	4.53E-03	4.31E-03	4.34E-03	4.50E-03	4.29E-03	4.35E-03	1.25E-04
		Cyclohexane	3.16E-03	5.23E-03	4.40E-03	I	5.08E-03	3.64E-03	4.52E-03	3.55E-03	3.29E-03	4.11E-03	8.07E-04
		2,4-Dimethylphenol	ND	ND	2.39E-03	ND	ND	5.68E-03	6.03E-03	ND	6.33E-03	2.27E-03	2.92E-03
		n-Propylbenzene	2.37E-03	2.18E-03	2.12E-03	2.06E-03	2.36E-03	2.34E-03	2.37E-03	2.21E-03	2.19E-03	2.24E-03	1.18E-04
		Tetradecane	2.25E-03	1.92E-03	2.22E-03	1.84E-03	2.28E-03	2.58E-03	2.32E-03	2.41E-03	I	2.23E-03	2.44E-04
		Benzaldehyde	1.85E-03	1.75E-03	1.82E-03	1.91E-03	1.84E-03	1.98E-03	1.66E-03	2.02E-03	1.69E-03	1.84E-03	1.21E-04
		Crotonaldehyde	1.15E-03	1.05E-03	1.17E-03	1.11E-03	1.17E-03	1.64E-03	1.42E-03	1.75E-03	1.22E-03	1.30E-03	2.48E-04
		Butyraldehyde/Methacrolein	9.18E-04	9.22E-04	1.03E-03	9.73E-04	9.50E-04	I	9.13E-04	9.68E-04	8.54E-04	9.41E-04	5.15E-05
		1,3,5-Trimethylbenzene	ND	ND	ND	ND	ND	2.45E-03	2.32E-03	ND	1.92E-03	7.44E-04	1.12E-03
		o,m,p-Tolualdehyde	7.69E-04	7.69E-04	9.49E-04	7.80E-04	I	9.52E-04	ND	7.67E-04	ND	6.23E-04	3.93E-04
		Pentanal	5.36E-04	4.25E-04	I	4.36E-04	3.76E-04	4.81E-04	3.84E-04	4.30E-04	3.61E-04	4.29E-04	5.82E-05
		Hexaldehyde	2.90E-04	2.87E-04	2.62E-04	1.38E-04	ND	3.01E-04	ND	2.99E-04	ND	1.75E-04	1.41E-04
		1,3-Diethylbenzene	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		2,6-Dimethylphenol	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		Indan	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA

Test Plan GB Individual Emission Test Results – Lb/Tn Metal

HAPs	POMs	COMPOUND / SAMPLE NUMBER	GB001	GB002	GB003	GB004	GB005	GB006	GB007	GB008	GB009	Average	STDEV
		Test Dates	7/14/04	7/14/04	7/14/04	7/15/04	7/15/04	7/15/04	7/16/04	7/16/04	7/16/04		
			Other Analytes										
		Acetone	8.69E-03	8.45E-03	8.13E-03	8.58E-03	9.04E-03	9.00E-03	8.01E-03	8.64E-03	I	8.57E-03	3.67E-04
		Carbon Dioxide	1.10E+01	7.04E+00	1.08E+01	1.22E+01	7.57E+00	1.17E+01	7.77E+00	1.10E+01	1.09E+01	1.00E+01	1.96E+00
		Carbon Monoxide	3.96E+00	5.15E+00	3.93E+00	4.03E+00	5.30E+00	3.28E+00	4.93E+00	3.70E+00	3.79E+00	4.23E+00	7.11E-01

I: Data rejected based on data validation considerations.

ND: Non Detect; NA: Not Applicable

All "Other Analytes" are not included in the Sum of VOCS or HAPs.

Test Plan GC Individual Emission Test Results – Lb/Lb Binder

HAPs	POMs	COMPOUND/SAMPLE NUMBER	GC001	GC002	GC003	Average	STDEV
		Test Dates	**8/10/2004**	**8/10/2004**	**8/10/2004**		
		TGOC as Propane	1.77E-01	1.52E-01	1.57E-01	1.62E-01	1.33E-02
		HC as Hexane	6.23E-02	5.48E-02	5.64E-02	5.78E-02	3.95E-03
		Sum of Target Analytes	5.00E-02	4.71E-02	4.81E-02	4.84E-02	1.46E-03
		Sum of HAPs	4.51E-02	4.24E-02	4.32E-02	4.36E-02	1.42E-03
		Sum of POMs	7.24E-03	7.67E-03	6.92E-03	7.28E-03	3.79E-04
		Individual Organic HAPs					
x		**Phenol**	1.03E-02	1.02E-02	1.03E-02	1.03E-02	7.12E-05
x		**Benzene**	1.10E-02	8.72E-03	9.10E-03	9.62E-03	1.25E-03
x		**Aniline**	4.08E-03	3.99E-03	4.13E-03	4.07E-03	7.02E-05
x		**o-Cresol**	3.24E-03	3.29E-03	3.31E-03	3.28E-03	3.54E-05
x		**Toluene**	2.76E-03	2.53E-03	2.70E-03	2.66E-03	1.16E-04
x	z	**2-Methylnaphthalene**	2.34E-03	2.49E-03	2.25E-03	2.36E-03	1.19E-04
x		**Acetaldehyde**	2.38E-03	2.08E-03	2.18E-03	2.21E-03	1.54E-04
x	z	**Naphthalene**	1.78E-03	1.79E-03	1.69E-03	1.75E-03	5.68E-05
x	z	**1-Methylnaphthalene**	1.24E-03	1.35E-03	1.23E-03	1.27E-03	6.71E-05
x		**m,p-Xylene**	1.18E-03	1.19E-03	1.30E-03	1.22E-03	6.61E-05
x		**m,p-Cresol**	9.28E-04	8.96E-04	9.34E-04	9.19E-04	2.03E-05
x	z	**1,3-Dimethylnaphthalene**	5.84E-04	5.88E-04	5.27E-04	5.67E-04	3.39E-05
x		**Hexane**	3.45E-04	3.18E-04	6.53E-04	4.39E-04	1.86E-04
x		**Formaldehyde**	4.35E-04	3.79E-04	3.92E-04	4.02E-04	2.91E-05
x		**o-Xylene**	3.61E-04	3.66E-04	4.08E-04	3.79E-04	2.59E-05
x	z	**1,5-Dimethylnaphthalene**	2.72E-04	3.49E-04	2.78E-04	3.00E-04	4.34E-05
x	z	**2,3-Dimethylnaphthalene**	2.52E-04	2.58E-04	2.25E-04	2.45E-04	1.75E-05
x		**Propionaldehyde**	2.70E-04	2.15E-04	2.39E-04	2.41E-04	2.78E-05
x	z	**1,6-Dimethylnaphthalene**	2.32E-04	2.50E-04	2.21E-04	2.35E-04	1.48E-05
x		**Ethylbenzene**	2.07E-04	2.09E-04	2.35E-04	2.17E-04	1.57E-05
x	z	**2,6-Dimethylnaphthalene**	2.07E-04	2.26E-04	1.90E-04	2.07E-04	1.76E-05
x	z	**2,7-Dimethylnaphthalene**	2.07E-04	2.26E-04	1.90E-04	2.07E-04	1.76E-05
x		**2-Butanone**	1.98E-04	1.82E-04	2.04E-04	1.95E-04	1.12E-05
x		**Styrene**	1.81E-04	1.68E-04	1.84E-04	1.78E-04	8.67E-06
x	z	**1,2-Dimethylnaphthalene**	1.26E-04	1.49E-04	1.21E-04	1.32E-04	1.51E-05
x	z	**Acenaphthalene**	ND	ND	ND	ND	NA
x		**Biphenyl**	ND	ND	ND	ND	NA
x	z	**1,8-Dimethylnaphthalene**	ND	ND	ND	ND	NA
x	z	**2,3,5-Trimethylnaphthalene**	ND	ND	ND	ND	NA
x		**Dimethylaniline**	ND	ND	ND	ND	NA
x		**Acrolein**	ND	ND	ND	ND	NA

Test Plan GC Individual Emission Test Results – Lb/Lb Binder

HAPs	POMs	COMPOUND/SAMPLE NUMBER	GC001	GC002	GC003	Average	STDEV
		Test Dates	**8/10/2004**	**8/10/2004**	**8/10/2004**		
		Other VOCs					
		1,2,4-Trimethylbenzene	7.75E-04	7.20E-04	8.09E-04	7.68E-04	4.50E-05
		2,6-Dimethylphenol	6.77E-04	6.90E-04	6.33E-04	6.67E-04	3.03E-05
		2,4-Dimethylphenol	6.74E-04	6.77E-04	6.16E-04	6.56E-04	3.46E-05
		Tetradecane	4.39E-04	6.13E-04	4.72E-04	5.08E-04	9.24E-05
		Indene	3.53E-04	3.21E-04	3.43E-04	3.39E-04	1.67E-05
		3-Ethyltoluene	3.33E-04	2.98E-04	3.49E-04	3.27E-04	2.58E-05
		1,2,3-Trimethylbenzene	2.62E-04	2.49E-04	2.86E-04	2.66E-04	1.84E-05
		2-Ethyltoluene	1.95E-04	1.66E-04	1.98E-04	1.87E-04	1.76E-05
		Dodecane	1.79E-04	1.93E-04	1.62E-04	1.78E-04	1.58E-05
		Heptane	1.80E-04	1.69E-04	1.84E-04	1.78E-04	7.97E-06
		Propylbenzene	1.77E-04	1.61E-04	1.86E-04	1.75E-04	1.27E-05
		Benzaldehyde	1.74E-04	1.38E-04	1.51E-04	1.54E-04	1.82E-05
		Butyraldehyde/Methacrolein	1.61E-04	1.32E-04	1.51E-04	1.48E-04	1.48E-05
		o,m,p-Tolualdehyde	1.20E-04	1.07E-04	1.13E-04	1.14E-04	6.43E-06
		Crotonaldehyde	4.90E-05	3.80E-05	4.48E-05	4.39E-05	5.56E-06
		Decane	ND	ND	1.02E-04	3.40E-05	5.90E-05
		Pentanal	2.97E-05	2.87E-05	3.57E-05	3.14E-05	3.75E-06
		Undecane	2.80E-05	2.57E-05	2.69E-05	2.69E-05	1.12E-06
		Hexaldehyde	3.03E-05	ND	ND	1.01E-05	1.75E-05
		Cyclohexane	ND	ND	ND	ND	NA
		1,3-Diethylbenzene	ND	ND	ND	ND	NA
		Indan	ND	ND	ND	ND	NA
		Nonane	ND	ND	ND	ND	NA
		Octane	ND	ND	ND	ND	NA
		1,3,5-Trimethylbenzene	ND	ND	ND	ND	NA
		Other Analytes					
		Acetone	1.17E-03	1.06E-03	1.15E-03	1.13E-03	6.05E-05
		Carbon Dioxide	7.22E-01	9.17E-01	8.22E-01	8.21E-01	9.74E-02
		Carbon Monoxide	3.87E-01	3.58E-01	3.49E-01	3.65E-01	1.98E-02

ND: Non Detect; NA: Not Applicable

All "Other Analytes" are not included in the Sum of Target Analytes or HAPs.

Test Plan GC Individual Emission Test Results – Lb/Tn Metal

HAPs	POMs	COMPOUND / SAMPLE NUMBER	GC001	GC002	GC003	Average	STDEV
		Test Dates	**8/10/2004**	**8/10/2004**	**8/10/2004**		
		TGOC as Propane	1.28E+00	1.11E+00	1.18E+00	1.19E+00	8.68E-02
		HC as Hexane	4.51E-01	4.01E-01	4.22E-01	4.25E-01	2.52E-02
		Sum of Target Analytes	3.62E-01	3.45E-01	3.60E-01	3.56E-01	9.35E-03
		Sum of HAPs	3.27E-01	3.10E-01	3.24E-01	3.20E-01	8.83E-03
		Sum of POMs	5.25E-02	5.62E-02	5.18E-02	5.35E-02	2.36E-03
		Individual Organic HAPs					
x		**Phenol**	7.46E-02	7.46E-02	7.72E-02	7.55E-02	1.52E-03
x		**Benzene**	8.01E-02	6.38E-02	6.82E-02	7.07E-02	8.42E-03
x		**Aniline**	2.96E-02	2.92E-02	3.09E-02	2.99E-02	8.96E-04
x		**o-Cresol**	2.35E-02	2.41E-02	2.48E-02	2.41E-02	6.51E-04
x		**Toluene**	2.00E-02	1.86E-02	2.02E-02	1.96E-02	8.97E-04
x	z	**2-Methylnaphthalene**	1.70E-02	1.82E-02	1.69E-02	1.74E-02	7.51E-04
x		**Acetaldehyde**	1.73E-02	1.52E-02	1.63E-02	1.63E-02	1.02E-03
x	z	**Naphthalene**	1.29E-02	1.31E-02	1.26E-02	1.29E-02	2.43E-04
x	z	**1-Methylnaphthalene**	8.98E-03	9.89E-03	9.21E-03	9.36E-03	4.71E-04
x		**m,p-Xylene**	8.53E-03	8.74E-03	9.73E-03	9.00E-03	6.39E-04
x		**m,p-Cresol**	6.73E-03	6.56E-03	7.00E-03	6.76E-03	2.18E-04
x	z	**1,3-Dimethylnaphthalene**	4.24E-03	4.30E-03	3.95E-03	4.16E-03	1.88E-04
x		**Hexane**	2.50E-03	2.33E-03	4.89E-03	3.24E-03	1.43E-03
x		**Formaldehyde**	3.15E-03	2.78E-03	2.93E-03	2.95E-03	1.88E-04
x		**o-Xylene**	2.62E-03	2.68E-03	3.06E-03	2.79E-03	2.38E-04
x	z	**1,5-Dimethylnaphthalene**	1.97E-03	2.56E-03	2.08E-03	2.20E-03	3.14E-04
x	z	**2,3-Dimethylnaphthalene**	1.83E-03	1.89E-03	1.69E-03	1.80E-03	1.04E-04
x		**Propionaldehyde**	1.96E-03	1.57E-03	1.79E-03	1.77E-03	1.94E-04
x	z	**1,6-Dimethylnaphthalene**	1.68E-03	1.83E-03	1.66E-03	1.72E-03	9.54E-05
x		**Ethylbenzene**	1.50E-03	1.53E-03	1.76E-03	1.60E-03	1.43E-04
x	z	**2,6-Dimethylnaphthalene**	1.50E-03	1.65E-03	1.43E-03	1.53E-03	1.16E-04
x	z	**2,7-Dimethylnaphthalene**	1.50E-03	1.65E-03	1.43E-03	1.53E-03	1.16E-04
x		**2-Butanone**	1.43E-03	1.33E-03	1.53E-03	1.43E-03	9.65E-05
x		**Styrene**	1.31E-03	1.23E-03	1.38E-03	1.31E-03	7.59E-05
x	z	**1,2-Dimethylnaphthalene**	9.13E-04	1.09E-03	9.06E-04	9.71E-04	1.06E-04
x	z	**1,8-Dimethylnaphthalene**	ND	ND	ND	ND	NA
x	z	**2,3,5-Trimethylnaphthalene**	ND	ND	ND	ND	NA
x	z	**Acenaphthalene**	ND	ND	ND	ND	NA
x		**Biphenyl**	ND	ND	ND	ND	NA
x		**Acrolein**	ND	ND	ND	ND	NA
x		**N,N-Dimethylaniline**	ND	ND	ND	ND	NA

Test Plan GC Individual Emission Test Results – Lb/Tn Metal

HAPs	POMs	COMPOUND / SAMPLE NUMBER	GC001	GC002	GC003	Average	STDEV
		Test Dates	**8/10/2004**	**8/10/2004**	**8/10/2004**		
		Other VOCs					
		1,2,4-Trimethylbenzene	5.62E-03	5.27E-03	6.06E-03	5.65E-03	3.94E-04
		2,6-Dimethylphenol	4.91E-03	5.06E-03	4.74E-03	4.90E-03	1.59E-04
		2,4-Dimethylphenol	4.89E-03	4.96E-03	4.61E-03	4.82E-03	1.83E-04
		Tetradecane	3.18E-03	4.49E-03	3.54E-03	3.74E-03	6.76E-04
		Indene	2.56E-03	2.35E-03	2.57E-03	2.49E-03	1.25E-04
		3-Ethyltoluene	2.41E-03	2.18E-03	2.61E-03	2.40E-03	2.15E-04
		1,2,3-Trimethylbenzene	1.90E-03	1.83E-03	2.14E-03	1.96E-03	1.64E-04
		2-Ethyltoluene	1.41E-03	1.22E-03	1.49E-03	1.37E-03	1.38E-04
		Heptane	1.30E-03	1.24E-03	1.38E-03	1.31E-03	7.24E-05
		Dodecane	1.30E-03	1.41E-03	1.21E-03	1.31E-03	1.02E-04
		n-Propylbenzene	1.28E-03	1.18E-03	1.40E-03	1.29E-03	1.08E-04
		Benzaldehyde	1.26E-03	1.01E-03	1.13E-03	1.13E-03	1.25E-04
		Butyraldehyde/Methacrolein	1.17E-03	9.65E-04	1.13E-03	1.09E-03	1.07E-04
		o,m,p-Tolualdehyde	8.72E-04	7.87E-04	8.49E-04	8.36E-04	4.41E-05
		Crotonaldehyde	3.55E-04	2.78E-04	3.35E-04	3.23E-04	4.00E-05
		Decane	ND	ND	7.65E-04	2.55E-04	4.42E-04
		Pentanal	2.16E-04	2.10E-04	2.67E-04	2.31E-04	3.14E-05
		Undecane	2.03E-04	1.89E-04	2.01E-04	1.98E-04	7.87E-06
		Hexaldehyde	2.19E-04	ND	ND	7.32E-05	1.27E-04
		1,3,5-Trimethylbenzene	ND	ND	ND	ND	NA
		1,3-Diethylbenzene	ND	ND	ND	ND	NA
		Cyclohexane	ND	ND	ND	ND	NA
		Indan	ND	ND	ND	ND	NA
		Nonane	ND	ND	ND	ND	NA
		Octane	ND	ND	ND	ND	NA
		Other Analytes					
		Acetone	8.50E-03	7.75E-03	8.62E-03	8.29E-03	4.70E-04
		Carbon Dioxide	5.24E+00	6.72E+00	6.16E+00	6.04E+00	7.48E-01
		Carbon Monoxide	2.81E+00	2.62E+00	2.61E+00	2.68E+00	1.08E-01

ND: Non Detect; NA: Not Applicable

All "Other Analytes" are not included in the Sum of Target Analytes or HAPs.

Test GB Quantitation Limits – Lb/Lb Binder

Analytes	Lb/Lb Binder
1,2,3-Trimethylbenzene	3.40E-05
1,2,4-Trimethylbenzene	3.40E-05
1,3,5-Trimethylbenzene	3.40E-05
1,3-Dimethylnaphthalene	3.40E-05
1-Methylnaphthalene	3.40E-05
2-Ethyltoluene	3.40E-05
2-Methylnaphthalene	3.40E-05
Benzene	3.40E-05
Ethylbenzene	3.40E-05
Hexane	3.40E-05
m,p-Xylene	3.40E-05
Naphthalene	3.40E-05
o-Xylene	3.40E-05
Styrene	3.40E-05
Toluene	3.40E-05
Undecane	3.40E-05
1,2-Dimethylnaphthalene	1.70E-04
1,3-Diethylbenzene	1.70E-04
1,5-Dimethylnaphthalene	1.70E-04
1,6-Dimethylnaphthalene	1.70E-04
1,8-Dimethylnaphthalene	1.70E-04

Analytes	Lb/Lb Binder
2,3,5-Trimethylnaphthalene	1.70E-04
2,3-Dimethylnaphthalene	1.70E-04
2,4-Dimethylphenol	1.70E-04
2,6-Dimethylnaphthalene	1.70E-04
2,6-Dimethylphenol	1.70E-04
2,7- Dimethylnaphthalene	1.70E-04
3-Ethyltoluene	1.70E-04
Acenaphthalene	1.70E-04
Biphenyl	1.70E-04
Cyclohexane	1.70E-04
Decane	1.70E-04
Dodecane	1.70E-04
Heptane	1.70E-04
Indan	1.70E-04
Indene	1.70E-04
m,p-Cresol	1.70E-04
Nonane	1.70E-04
o-Cresol	1.70E-04
Octane	1.70E-04
Phenol	1.70E-04
Propylbenzene	1.70E-04

Analytes	Lb/Lb Binder
Tetradecane	1.70E-04
HC as Hexane	1.97E-03
2-Butanone (MEK)	3.45E-05
Acetaldehyde	3.45E-05
Acetone	3.45E-05
Acrolein	3.45E-05
Benzaldehyde	3.45E-05
Butyraldehyde	3.45E-05
Crotonaldehyde	3.45E-05
Formaldehyde	3.45E-05
Hexaldehyde	3.45E-05
Butyraldehyde/Methacrolein	5.75E-05
o,m,p-Tolualdehyde	9.20E-05
Pentanal (Valeraldehyde)	3.45E-05
Propionaldehyde (Propanal)	3.45E-05
Aniline	3.87E-04
Dimethylaniline	7.73E-04
Carbon Monoxide	8.15E-03
Carbon Dioxide	1.28E-02

Test GB Quantitation Limits – Lb/Tn Metal

Analytes	Lb/Tn Metal
1,2,3-Trimethylbenzene	2.62E-04
1,2,4-Trimethylbenzene	2.62E-04
1,3,5-Trimethylbenzene	2.62E-04
1,3-Dimethylnaphthalene	2.62E-04
1-Methylnaphthalene	2.62E-04
2-Ethyltoluene	2.62E-04
2-Methylnaphthalene	2.62E-04
Benzene	2.62E-04
Ethylbenzene	2.62E-04
Hexane	2.62E-04
m,p-Xylene	2.62E-04
Naphthalene	2.62E-04
o-Xylene	2.62E-04
Styrene	2.62E-04
Toluene	2.62E-04
Undecane	2.62E-04
1,2-Dimethylnaphthalene	1.31E-03
1,3-Diethylbenzene	1.31E-03
1,5-Dimethylnaphthalene	1.31E-03
1,6-Dimethylnaphthalene	1.31E-03
1,8-Dimethylnaphthalene	1.31E-03

Analytes	Lb/Tn Metal
2,3,5-Trimethylnaphthalene	1.31E-03
2,3-Dimethylnaphthalene	1.31E-03
2,4-Dimethylphenol	1.31E-03
2,6-Dimethylnaphthalene	1.31E-03
2,6-Dimethylphenol	1.31E-03
2,7- Dimethylnaphthalene	1.31E-03
3-Ethyltoluene	1.31E-03
Acenaphthalene	1.31E-03
Biphenyl	1.31E-03
Cyclohexane	1.31E-03
Decane	1.31E-03
Dodecane	1.31E-03
Heptane	1.31E-03
Indan	1.31E-03
Indene	1.31E-03
m,p-Cresol	1.31E-03
Nonane	1.31E-03
o-Cresol	1.31E-03
Octane	1.31E-03
Phenol	1.31E-03
Propylbenzene	1.31E-03

Analytes	Lb/Tn Metal
Tetradecane	1.31E-03
HC as Hexane	1.52E-02
2-Butanone (MEK)	2.66E-04
Acetaldehyde	2.66E-04
Acetone	2.66E-04
Acrolein	2.66E-04
Benzaldehyde	2.66E-04
Butyraldehyde	2.66E-04
Crotonaldehyde	2.66E-04
Formaldehyde	2.66E-04
Hexaldehyde	2.66E-04
Butyraldehyde/Methacrolein	4.44E-04
o,m,p-Tolualdehyde	7.10E-04
Pentanal (Valeraldehyde)	2.66E-04
Propionaldehyde (Propanal)	2.66E-04
Aniline	2.99E-03
Dimethylaniline	5.97E-03
Carbon Monoxide	6.29E-02
Carbon Dioxide	9.89E-02

Test GC Quantitation Limits – Lb/Lb Binder

Analytes	Lb/Lb Binder
1,2,3-Trimethylbenzene	2.05E-05
1,2,4-Trimethylbenzene	2.05E-05
1,3,5-Trimethylbenzene	2.05E-05
1,3-Dimethylnaphthalene	2.05E-05
1-Methylnaphthalene	2.05E-05
2-Ethyltoluene	2.05E-05
2-Methylnaphthalene	2.05E-05
Benzene	2.05E-05
Ethylbenzene	2.05E-05
Hexane	2.05E-05
m,p-Xylene	2.05E-05
Naphthalene	2.05E-05
o-Xylene	2.05E-05
Styrene	2.05E-05
Toluene	2.05E-05
Undecane	2.05E-05
1,2-Dimethylnaphthalene	1.02E-04
1,3-Diethylbenzene	1.02E-04
1,5-Dimethylnaphthalene	1.02E-04
1,6-Dimethylnaphthalene	1.02E-04
1,8-Dimethylnaphthalene	1.02E-04

Analytes	Lb/Lb Binder
2,3,5-Trimethylnaphthalene	1.02E-04
2,3-Dimethylnaphthalene	1.02E-04
2,4-Dimethylphenol	1.02E-04
2,6-Dimethylnaphthalene	1.02E-04
2,6-Dimethylphenol	1.02E-04
2,7- Dimethylnaphthalene	1.02E-04
3-Ethyltoluene	1.02E-04
Acenaphthalene	1.02E-04
Biphenyl	1.02E-04
Cyclohexane	1.02E-04
Decane	1.02E-04
Dodecane	1.02E-04
Heptane	1.02E-04
Indan	1.02E-04
Indene	1.02E-04
m,p-Cresol	1.02E-04
Nonane	1.02E-04
o-Cresol	1.02E-04
Octane	1.02E-04
Phenol	1.02E-04
Propylbenzene	1.02E-04

Analytes	Lb/Lb Binder
Tetradecane	1.02E-04
HC as Hexane	5.25E-04
2-Butanone (MEK)	1.79E-05
Acetaldehyde	1.79E-05
Acetone	1.79E-05
Acrolein	1.79E-05
Benzaldehyde	1.79E-05
Butyraldehyde	1.79E-05
Crotonaldehyde	1.79E-05
Formaldehyde	1.79E-05
Hexaldehyde	1.79E-05
Butyraldehyde/Methacrolein	2.98E-05
o,m,p-Tolualdehyde	4.77E-05
Pentanal (Valeraldehyde)	1.79E-05
Propionaldehyde (Propanal)	1.79E-05
Aniline	1.24E-04
Dimethylaniline	2.47E-04
Carbon Monoxide	4.96E-03
Carbon Dioxide	7.79E-03

Test GC Quantitation Limits – Lb/Tn Metal

Analytes	Lb/Tn Metal
1,2,3-Trimethylbenzene	1.49E-04
1,2,4-Trimethylbenzene	1.49E-04
1,3,5-Trimethylbenzene	1.49E-04
1,3-Dimethylnaphthalene	1.49E-04
1-Methylnaphthalene	1.49E-04
2-Ethyltoluene	1.49E-04
2-Methylnaphthalene	1.49E-04
Benzene	1.49E-04
Ethylbenzene	1.49E-04
Hexane	1.49E-04
m,p-Xylene	1.49E-04
Naphthalene	1.49E-04
o-Xylene	1.49E-04
Styrene	1.49E-04
Toluene	1.49E-04
Undecane	1.49E-04
1,2-Dimethylnaphthalene	7.47E-04
1,3-Diethylbenzene	7.47E-04
1,5-Dimethylnaphthalene	7.47E-04
1,6-Dimethylnaphthalene	7.47E-04
1,8-Dimethylnaphthalene	7.47E-04

Analytes	Lb/Tn Metal
2,3,5-Trimethylnaphthalene	7.47E-04
2,3-Dimethylnaphthalene	7.47E-04
2,4-Dimethylphenol	7.47E-04
2,6-Dimethylnaphthalene	7.47E-04
2,6-Dimethylphenol	7.47E-04
2,7- Dimethylnaphthalene	7.47E-04
3-Ethyltoluene	7.47E-04
Acenaphthalene	7.47E-04
Biphenyl	7.47E-04
Cyclohexane	7.47E-04
Decane	7.47E-04
Dodecane	7.47E-04
Heptane	7.47E-04
Indan	7.47E-04
Indene	7.47E-04
m,p-Cresol	7.47E-04
Nonane	7.47E-04
o-Cresol	7.47E-04
Octane	7.47E-04
Phenol	7.47E-04
Propylbenzene	7.47E-04

Analytes	Lb/Tn Metal
Tetradecane	7.47E-04
HC as Hexane	3.83E-03
2-Butanone (MEK)	1.31E-04
Acetaldehyde	1.31E-04
Acetone	1.31E-04
Acrolein	1.31E-04
Benzaldehyde	1.31E-04
Butyraldehyde	1.31E-04
Crotonaldehyde	1.31E-04
Formaldehyde	1.31E-04
Hexaldehyde	1.31E-04
Butyraldehyde/Methacrolein	2.18E-04
o,m,p-Tolualdehyde	3.48E-04
Pentanal (Valeraldehyde)	1.31E-04
Propionaldehyde (Propanal)	1.31E-04
Aniline	9.01E-04
Dimethylaniline	1.80E-03
Carbon Monoxide	3.61E-02
Carbon Dioxide	5.68E-02

Test Plan T-Statistics – Lb/Lb Binder

Analytes	Test GB Lb/Lb Binder	Test GC Lb/Lb Binder	T-Statistic
TGOC as Propane	0.3179	0.1621	12.0
HC as Hexane	0.1073	0.0578	14.9
Sum of Target Analytes	0.0845	0.0484	19.8
Sum of HAPs	0.0703	0.0436	16.8
Sum of POMs	0.0073	0.0073	0.0
Individual Organic HAPs			
Benzene	0.0236	0.0096	12.2
Toluene	0.0101	0.0027	35.5
Phenol	0.0100	0.0103	-0.7
o,m,p-Xylene	0.0072	0.0016	38.5
o,m,p-Cresol	0.0049	0.0042	3.0
Methylnaphthalenes	0.0033	0.0036	-1.3
Dimethylnaphthalenes	0.0033	0.0019	6.7
Aniline	0.0028	0.0041	-6.2
Naphthalene	0.0026	0.0018	6.9
Hexane	0.0021	0.0004	11.1
Ethylbenzene	0.0012	0.0002	30.0
Acetaldehyde	0.0010	0.0022	-10.0
Formaldehyde	0.0003	0.0004	-3.0
Other VOCs			
Trimethylbenzenes	0.0026	0.0010	18.1
Octane	0.0025	ND	37.5
Heptane	0.0015	0.0002	19.5
Ethyltoluenes	0.0014	0.0005	NA
Undecane	0.0013	<0.0001	39.0
Nonane	0.0010	ND	30.0
Decane	0.0009	<0.0001	13.5
Dodecane	0.0007	0.0002	15.0
Tetradecane	0.0003	0.0005	-3.0
Dimethylphenols	0.0003	0.0013	-6.9
Other Analytes			
Carbon Dioxide	1.296	0.8207	4.6
Carbon Monoxide	0.5481	0.3646	5.7

Individual results constitute >95% of mass of all detected Target Analytes.

ND: Non Detect; NA: Not Applicable

Test Plan T-Statistics – Lb/Tn Metal

Analytes	Test GB Lb/Tn Metal	Test GC Lb/Tn Metal	T-statistic
TGOC as Propane	2.454	1.191	13.0
HC as Hexane	0.8289	0.4250	16.8
Sum of Target Analytes	0.6581	0.3558	25.9
Sum of HAPs	0.5484	0.3204	23.8
Sum of POMs	0.0565	0.0535	0.9
Individual Organic HAPs			
Benzene	0.1821	0.0707	13.1
Toluene	0.0773	0.0196	30.8
Phenol	0.0773	0.0755	0.5
o,m,p-Xylene	0.0555	0.0118	34.2
o,m,p-Cresol	0.0377	0.0309	3.5
Methylnaphthalenes	0.0256	0.0267	-0.7
Aniline	0.0213	0.0299	-5.1
Naphthalene	0.0203	0.0129	8.8
Hexane	0.0167	0.0032	14.2
Dimethylnaphthalenes	0.0105	0.0139	-3.2
Ethylbenzene	0.0096	0.0016	38.4
Acetaldehyde	0.0080	0.0163	-13.6
Formaldehyde	0.0020	0.0030	-4.9
Other VOCs			
Trimethylbenzenes	0.0204	0.0076	22.0
Octane	0.0190	ND	31.7
Heptane	0.0117	0.0013	20.7
Ethyltoluenes	0.0111	0.0038	27.4
Undecane	0.0100	0.0002	58.8
Nonane	0.0079	ND	26.3
Decane	0.0070	0.0003	20.4
Dodecane	0.0053	0.0013	22.7
Dimethylphenols	0.0023	0.0097	-7.5
Tetradecane	0.0022	0.0037	-3.7
Other Analytes			
Carbon Dioxide	9.996	6.038	5.1
Carbon Monoxide	4.231	2.680	6.3

Individual results constitute >95% of mass of all detected Target Analytes.

ND: Non Detect

this page intentionally left blank

APPENDIX C TEST SERIES GB AND GC DETAILED PROCESS DATA

this page intentionally left blank

Test GB Detailed Process Data

Greensand PCS

Test Dates				7/14/04	7/14/04	7/14/04	7/15/04	7/15/04	7/15/04	7/16/04	7/16/04	7/16/04	Averages
Emissions Sample #	**GBER1**	**GBER2**	**GBER3**	**GB001**	**GB002**	**GB003**	**GB004**	**GB005**	**GB006**	**GB007**	**GB008**	**GB009**	
Production Sample #	**GB001**	**GB002**	**GB003**	**GB004**	**GB005**	**GB006**	**GB007**	**GB008**	**GB009**	**GB010**	**GB011**	**GB012**	
Cast Weight (all metal inside mold), Lbs.	110.85	88.85	108.85	105.85	106.90	105.95	106.45	105.10	106.70	107.25	107.45	106.40	**106.45**
Pouring Time, sec.	22	18	20	25	22	29	25	26	23	20	19	28	**24**
Pouring Temp ,°F	2638	2622	2634	2629	2618	2636	2640	2639	2638	2627	2640	2633	**2633**
Pour Hood Process Air Temp at Start of Pour, °F	86	86	86	85	88	86	86	86	86	86	86	86	**86**
Core Mixer Auto Dispensed Batch Weight, Lbs	49.08	49.08	49.08	49.08	49.08	49.08	49.08	49.08	49.08	49.08	49.08	49.08	**49.08**
Calibrated Auto Dispensed Core Binder Weight, Lbs	0.690	0.690	0.690	0.690	0.690	0.690	0.690	0.690	0.690	0.690	0.690	0.690	**0.690**
Core Binder Calibrated Weight, %BOS	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	1.41	**1.41**
Core Binder Calibrated Weight, %	1.39	1.39	1.39	1.39	1.39	1.39	1.39	1.39	1.39	1.39	1.39	1.39	**1.39**
Total Uncoated Core Weight in Mold, Lbs.	30	30	29.5	29.50	29.50	30.00	29.50	29.50	29.50	30.00	29.50	29.50	**29.61**
Total Binder Weight in Mold, Lbs.	0.416	0.416	0.409	0.409	0.409	0.416	0.409	0.409	0.409	0.416	0.409	0.409	**0.411**
Core LOI, % Note 2	1.19	1.23	1.21	ND	1.17	1.22	1.19	1.21	1.17	1.19	1.19	1.19	**1.19**
Total Dried Core Coating Weight in Mold, Lbs.	0.39	0.38	0.36	0.39	0.38	0.36	0.34	0.35	0.36	0.35	0.35	0.32	**0.36**
Dogbone Tensile Test (Thwing-Albert psi)	227	235	235	228	236	232	235	233	240	240	234	242	**236**
Core Age, hrs.	25	28	31	49	52	54	73	75	78	96	98	100	**75**
Muller Batch Weight, Lbs.	1303	900	900	1300	900	900	900	900	900	900	900	900	**944**
GS Mold Sand Weight, Lbs.	609	606	614	620	602	607	610	624	626	622	607	614	**615**
Mold Compactability, %	54	52	55	52	53	56	52	57	59	55	58	55	**55**
Mold Temperature, °F	77	79	86	75	85	89	74	ND	80	83	87	89	**83**
Average Green Compression , psi	19.1	13.78	19.91	19.45	21.45	22.27	22.60	22.23	21.14	21.35	21.04	21.32	**21.43**
GS Compactability, %	47	35	52	43	54	47	43	49	49	50	53	49	**49**
GS Moisture Content, %	2.46	2.08	2.94	2.26	2.81	2.54	2.60	2.31	2.37	2.22	3.04	2.40	**2.51**
GS MB Clay Content, %	7.8	7.65	7.78	7.91	7.65	7.91	7.26	7.54	7.39	7.39	7.13	7.26	**7.49**
MB Clay Reagent, ml	30.1	29.5	30.0	30.5	29.5	30.5	28.0	29.1	28.5	28.5	27.5	28.0	**28.9**
1800°F LOI - Mold Sand, %	5.07	5.05	4.85	5.08	5.07	5.18	5.39	5.33	5.2	5.40	5.48	5.59	**5.30**
900°F Volatiles , %	0.94	0.68	0.22	0.78	0.50	0.28	0.92	0.60	0.16	0.68	0.44	0.20	**0.51**

	GBER1	**GBER2**	**GBER3**	**GB001**	**GB002**	**GB003**	**GB004**	**GB005**	**GB006**	**GB007**	**GB008**	**GB009**
GS Surface Appearance Ranking 1= Best 23 = Worst	**GB001**	**GB002**	**GB003**	**GB004**	**GB005**	**GB006**	**GB007**	**GB008**	**GB009**	**GB010**	**GB011**	**GB012**
Greensand Surface Cavity 1	18	7	19	3	2	9	15	1	16	10	14	21
Greensand Surface Cavity 2	15	Note 1	8	14	17	9	23	7	10	22	6	16
Greensand Surface Cavity 3 (reference cavity)	6	14	4	5	15	9	18	10	20	19	8	16
Greensand Surface Cavity 4	9	1	2	1	6	11	7	7	20	12	13	14
Core Surface Appearance Ranking 1 = Best, 18 = Worst												
Core Surface Cavity 1	6	8	4	10	5	2	12	7	3	15	16	1
Core Surface Cavity 2	15	Note 1	2	12	4	9	16	8	11	18	13	14
Core Surface Cavity 3 (reference cavity)	12	10	2	9	1	3	16	5	7	14	6	17
Core Surface Cavity 4	8	5	3	9	6	4	10	12	13	15	11	14

Note 1: Cavity 2 run 2 misran, no casting

Note 2: Emission sample GB001 appeared incompletely cured or improperly mixed.

There were 23 GS quality levels; There were 18 core quality levels

For product test to compare to	**GBER1**	**GBER2**	**GBER3**	**GB001**	**GB002**	**GB003**	**GB004**	**GB005**	**GB006**	**GB007**	**GB008**	**GB009**
	GB001	**GB002**	**GB003**	**GB004**	**GB005**	**GB006**	**GB007**	**GB008**	**GB009**	**GB010**	**GB011**	**GB012**
Relative quality level of reference cavity 3 GS surface	2a	4a	0a	1	5	3	7	4	9	8	2	6
Relative quality level of reference cavity 3 core surface	5b	5a	1a	5	1	2	8	3	4	6	7	9

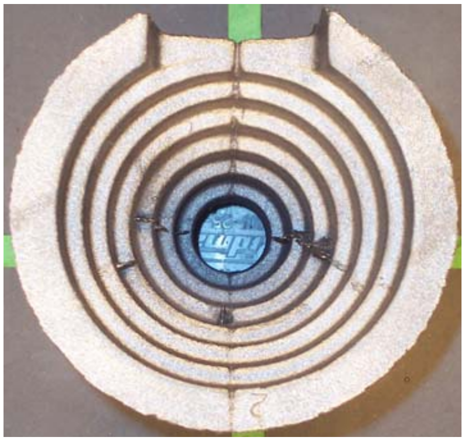
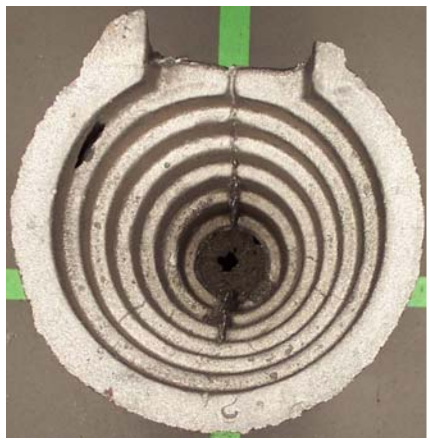
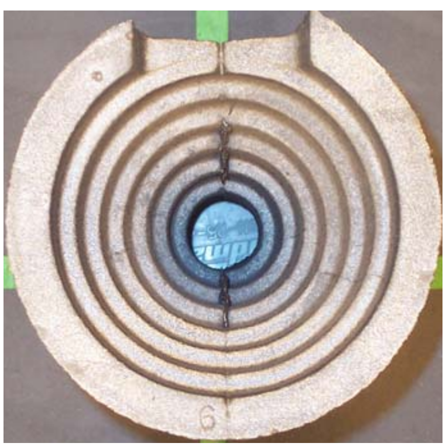
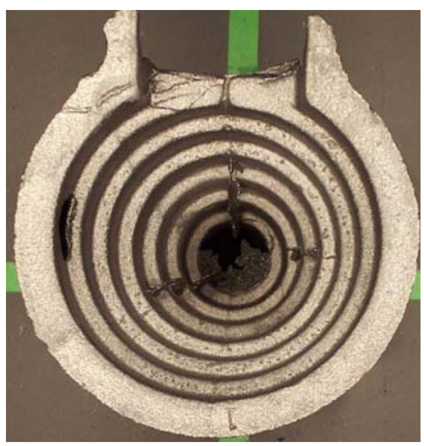
Test GC Detailed Process Data

Greensand PCS							
Test Dates	**8/9/2004**	**8/9/2004**	**8/9/2004**	**8/10/2004**	**8/10/2004**	**8/10/2004**	**Averages**
Emissions Sample #	**GCCR01**	**GCCR02**	**GCCR03**	**GC001**	**GC002**	**GC003**	
Production Sample #	**GC001**	**GC002**	**GC003**	**GC004**	**GC005**	**GC006**	
Cast Weight (all metal inside mold), Lbs.	110.50	109.00	110.40	110.90	109.50	107.60	**109.33**
Pouring Time, sec.	16	17	16	14	16	16	**15**
Pouring Temp ,°F	2633	2629	2629	2630	2631	2629	**2630**
Pour Hood Process Air Temp at Start of Pour, °F	85	86	90	89	87	88	**88**
Core Mixer Auto Dispensed Batch Weight, Lbs	49.90	49.90	49.90	49.90	49.90	49.90	**49.90**
Calibrated auto dispensed core binder weight, Lbs	0.698	0.698	0.698	0.698	0.698	0.698	**0.698**
Core Binder Calibrated Weight, %BOS	1.40	1.40	1.40	1.40	1.40	1.40	**1.40**
Core Binder Calibrated Weight, %	1.38	1.38	1.38	1.38	1.38	1.38	**1.38**
Total Uncoated Core Weight in Mold, Lbs.	29.36	29.28	29.23	29.16	29.06	29.22	**29.15**
Total Binder Weight in Mold, Lbs.	0.405	0.404	0.403	0.402	0.401	0.403	**0.40**
Core LOI, %	1.41	1.45	1.45	1.49	1.49	1.46	**1.48**
Weight of H& G VeinAway HT, Lbs.	1.38	1.38	1.38	1.37	1.37	1.38	**1.37**
Total Dried Core Coating Weight in Mold. Lbs	0.14	0.14	0.13	0.13	0.13	0.13	**0.13**
Dogbone Tensile Test (Thwing-Albert psi)	0	202	202	202	202	202	**202**
Core Age, hrs.	96	99	101	119	146	148	**138**
Muller Batch Weight, Lbs.	1307	904	904	904	904	904	**904**
Lake Sand, Lbs.	1210	0	0	0	0	0	**0**
H & G Premix. Lbs.	97.0	3.7	3.7	4.0	3.7	3.7	**3.8**
Return Sand, Lbs.	0	900	900	900	900	900	**900**
GS Mold Sand Weight, Lbs.	639.6	631.2	647.3	635.8	634.4	633.3	**634.5**
Weightof H&G AquaPart II-Graphite Mold rel., gms	39.9	40.1	40.6	39.8	41.2	40.1	**40.4**
Mold Compactability, %	57	57	59	55	56	57	**56**
Mold Temperature, °F	84	89	92	85	91	91	**89**
Average Green Compression , psi	15.13	15.64	18.16	21.19	22.75	21.63	**21.86**
GS Compactability, %	55	51	54	46	49	52	**49**
GS Moisture Content, %	2.70	2.90	2.60	2.60	2.76	2.74	**2.70**
GS MB Clay Content, %	7.54	7.65	7.39	7.65	7.91	7.78	**7.78**
MB Clay Reagent, ml	29.1	29.5	28.5	29.5	30.5	30.0	**30.0**
1800°F LOI - Mold Sand, %	1.18	1.38	1.23	1.31	1.29	1.34	**1.31**
900°F Volatiles , %	0.53	0.54	0.50	0.46	0.40	0.38	**0.41**
Appearance ranking: Greensand surface	0a	0b	3a	1	3	2	
1 = best,6 = worst Cavity 3 Coated Core surface	1a	1c	1b	3	2	1	

Cavity 3 Greensand Ranking

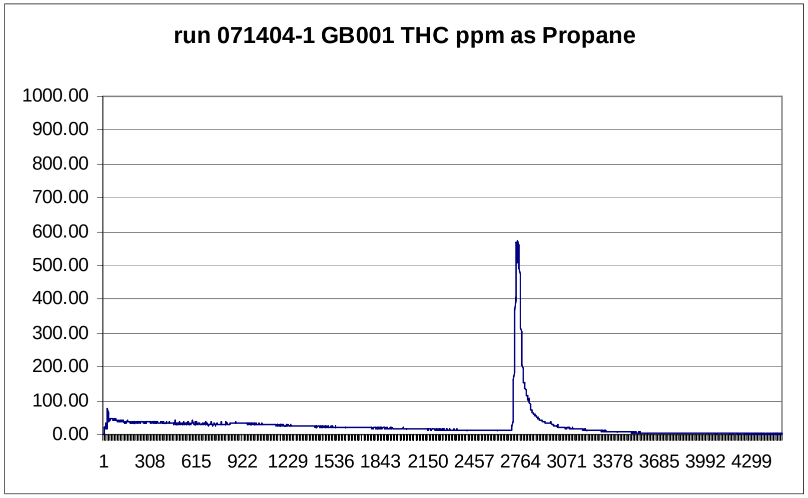
Rank	GB	GC	FQ
Best	 **GB001**	 **GC001**	 **FQ002**
Median	 **GB002**	 **GC003**	 **FQ006**
Worst	 **GB006**	 **GC002**	 **FQ003**

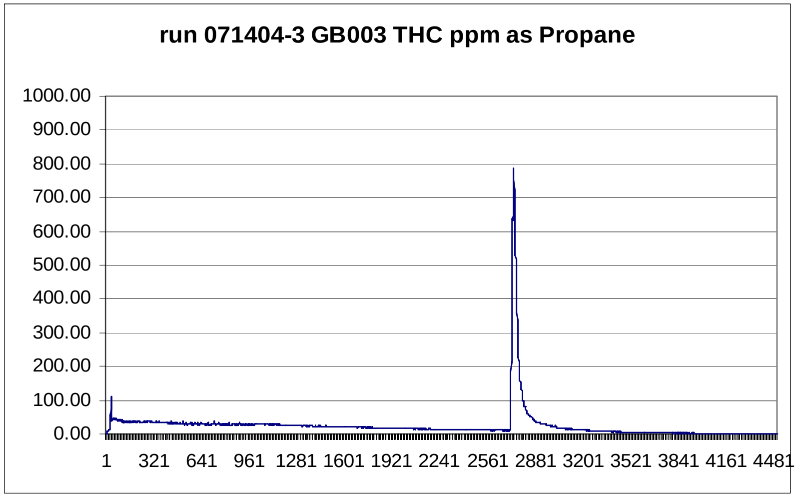
Cavity 3 Core Surface Ranking

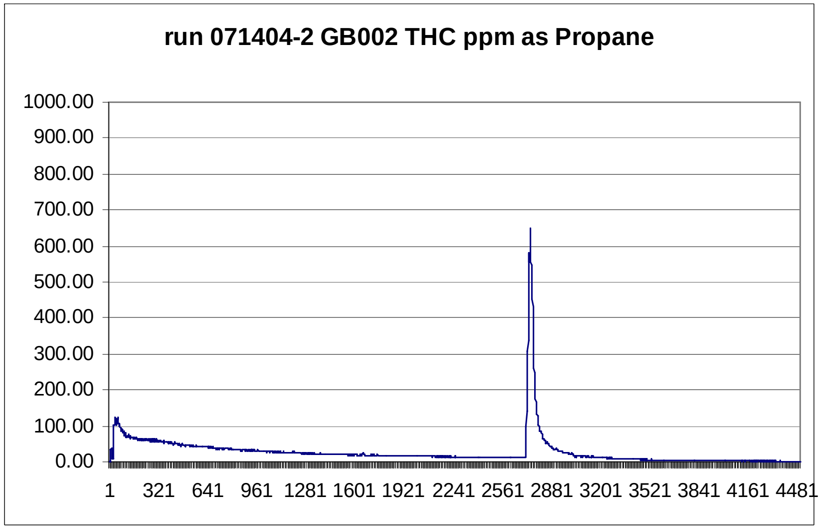
Rank	GB	GC	FQ
Best	 GB002	 GC003	 FQ007
Median	 GB006	 GC002	 FQ005
Worst	 GB009	 GC001	 FQ004

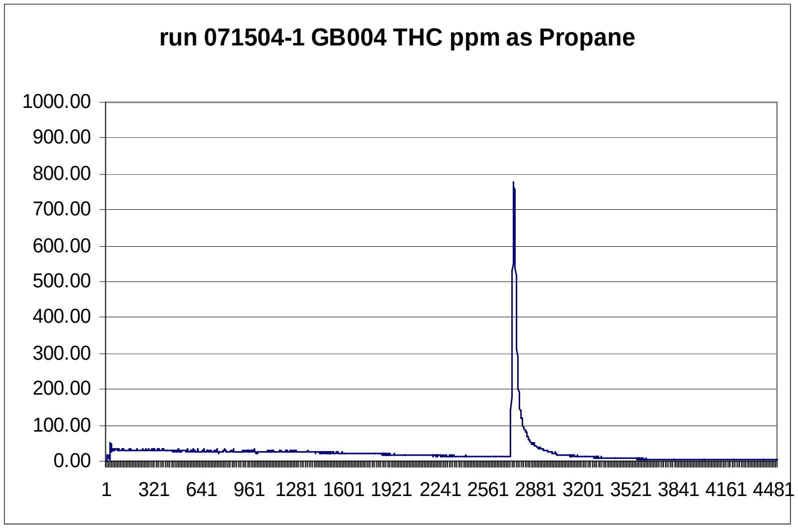
APPENDIX D METHOD 25A CHARTS

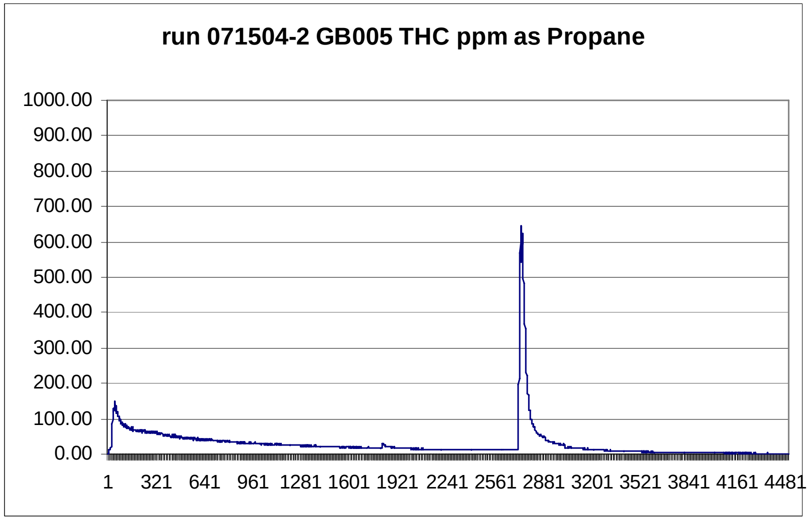
this page intentionally left blank

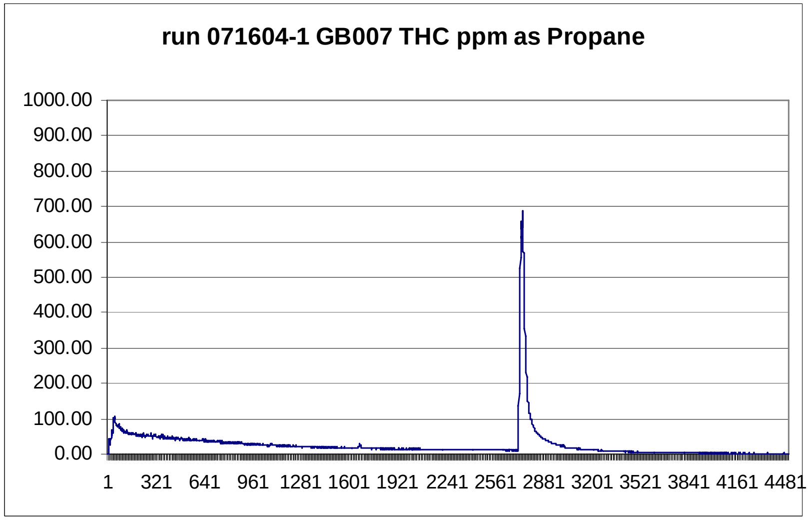

run 071404-1 GB001 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 308 615 922 1229 1536 1843 2150 2457 2764 3071 3378 3685 3992 4299

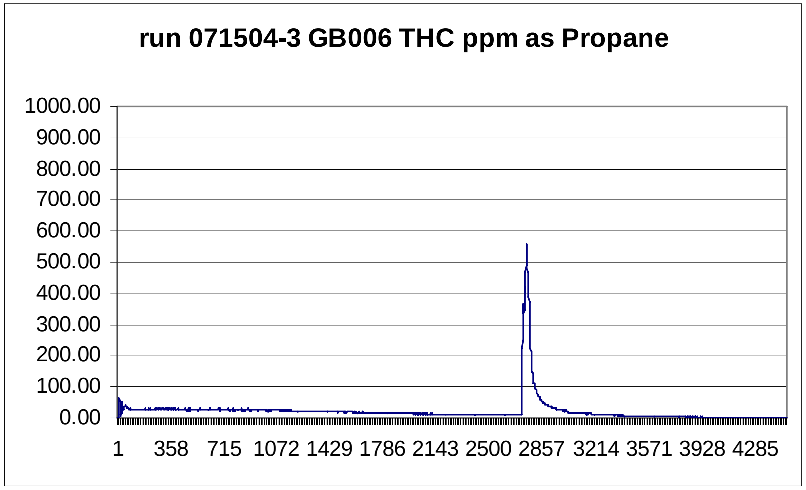

run 071404-3 GB003 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 321 641 961 1281 1601 1921 2241 2561 2881 3201 3521 3841 4161 4481

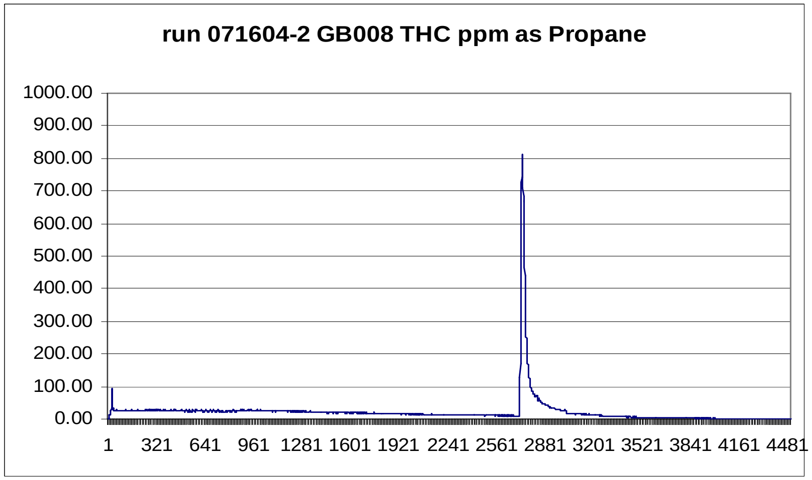

run 071404-2 GB002 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 321 641 961 1281 1601 1921 2241 2561 2881 3201 3521 3841 4161 4481

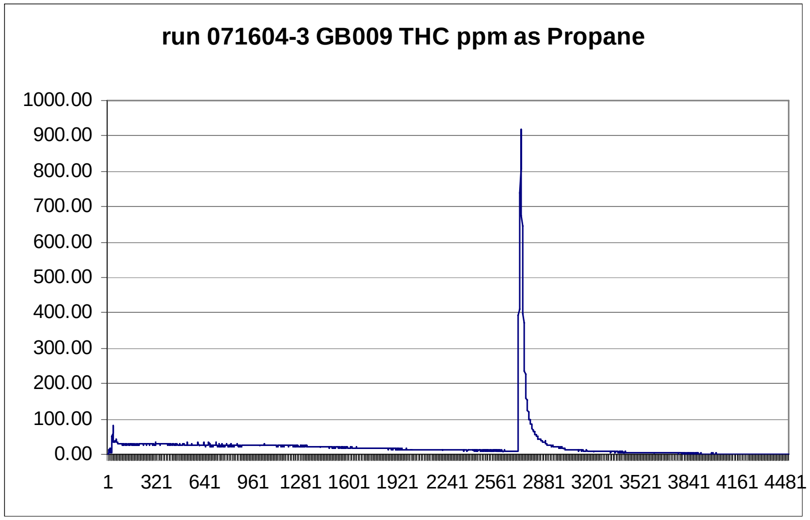

run 071504-1 GB004 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 321 641 961 1281 1601 1921 2241 2561 2881 3201 3521 3841 4161 4481

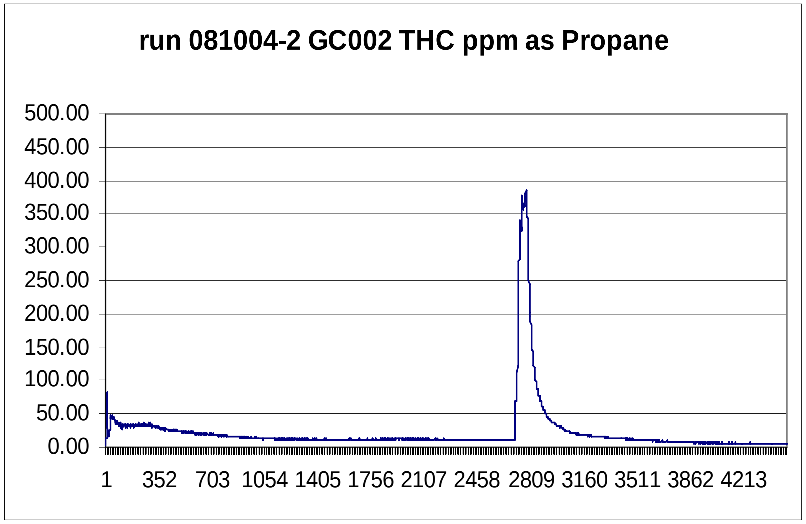

run 071504-2 GB005 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 321 641 961 1281 1601 1921 2241 2561 2881 3201 3521 3841 4161 4481

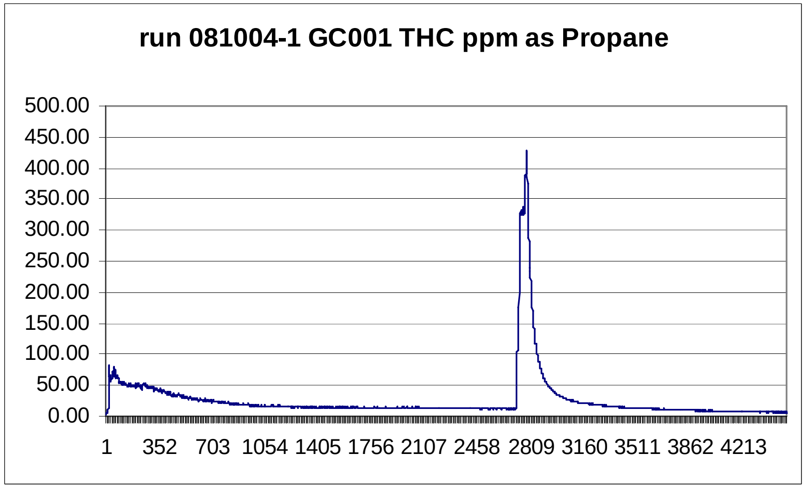

run 071604-1 GB007 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 321 641 961 1281 1601 1921 2241 2561 2881 3201 3521 3841 4161 4481

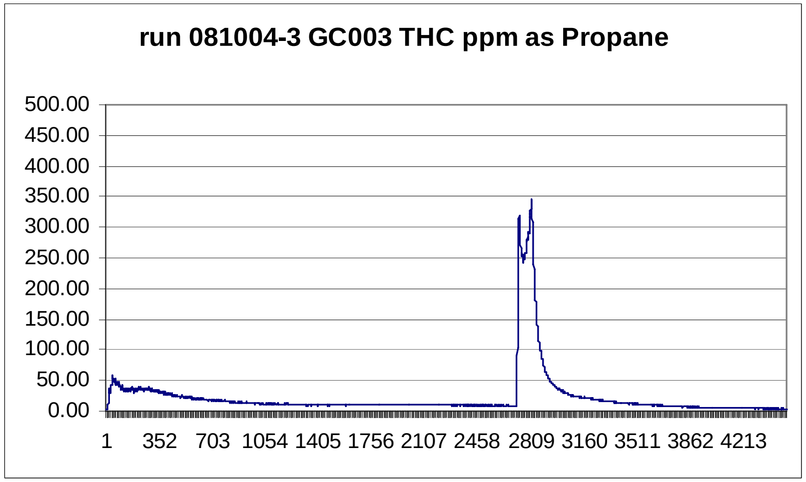

run 071504-3 GB006 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 358 715 1072 1429 1786 2143 2500 2857 3214 3571 3928 4285


run 071604-2 GB008 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 321 641 961 1281 1601 1921 2241 2561 2881 3201 3521 3841 4161 4481


run 071604-3 GB009 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 321 641 961 1281 1601 1921 2241 2561 2881 3201 3521 3841 4161 4481


run 081004-2 GC002 THC ppm as Propane
500.00
450.00
400.00
350.00
300.00
250.00
200.00
150.00
100.00
50.00
0.00
1 352 703 1054 1405 1756 2107 2458 2809 3160 3511 3862 4213


run 081004-1 GC001 THC ppm as Propane
500.00
450.00
400.00
350.00
300.00
250.00
200.00
150.00
100.00
50.00
0.00
1 352 703 1054 1405 1756 2107 2458 2809 3160 3511 3862 4213


run 081004-3 GC003 THC ppm as Propane
500.00
450.00
400.00
350.00
300.00
250.00
200.00
150.00
100.00
50.00
0.00
1 352 703 1054 1405 1756 2107 2458 2809 3160 3511 3862 4213

this page intentionally left blank

APPENDIX E GLOSSARY

this page intentionally left blank

Glossary

ACFM	Actual Cubic Feet Per Minute
BO	Based on ( ).
BOS	Based on Sand.
FPM	Feet Per Minute
HAP	Hazardous Air Pollutant defined by the 1990 Clean Air Act Amendment
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.
I	Invalid, Data rejected based on data validation considerations
NA	Not Applicable, Not Available
ND	Non-Detect
NT	Not Tested, Lab testing was not done
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.
PPMV	Parts Per Million by Volume
SCFM	Standard Cubic Feet per Minute
TGOC	Total Gaseous Organic Carbon
TGOC as Propane	Weighted to the detection of more volatile hydrocarbon species, beginning at C1 (methane), with results calibrated against a three-carbon alkane (propane).
VOC	Volatile Organic Compound