Casting Emission Reduction Program
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Product Test: Phenolic Urethane Cores with Anti-Vein Additives in Greensand, Iron, PCS

Technikon #1411-112 GG

December 2004
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United States Environmental Protection Agency

UNITED STATES COUNCIL FOR AUTOMOTIVE RESEARCH

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Product Test: Phenolic Urethane Cores with Anti-Vein Additives in Greensand, Iron, PCS

1411-112 GG

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

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

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Table of Contents

Executive Summary 1
1.0 Introduction 3
1.1 Background 3
1.2 Technikon Objectives 3
1.3 Report Organization 4
1.4 Specific Test Plan and Objectives 4
2.0 Test Methodology 7
2.1 Description of Process and Testing Equipment 7
2.2 Description of Testing Program 7
2.3 Quality Assurance and Quality Control (QA/QC) Procedures 10
3.0 Test Results 13
4.0 Discussion of Results 23

List of Figures

Figure 2-1 Pre-Production Foundry Layout Diagram 7
Figure 3-1 Emission Indicators from Test Series FR and GG – Lb/Lb Binder 17
Figure 3-2 Selected HAP Emissions from Test Series FR and GG– Lb/Lb Binder 18
Figure 3-3 Selected VOC Emissions from Test Series FR and GG – Lb/Lb Binder 18
Figure 3-4 Selected Criteria Pollutants Lb/Lb Binder 19
Figure 3-5 Emissions Indicators from Test Series FR and GG – Lb/Tn Metal 19
Figure 3-6 Selected HAP Emissions from Test Series FR and GG – Lb/Tn Metal 20
Figure 3-7 Selected VOC Emissions from Test Series FR and GG – Lb/Tn Metal 20
Figure 3-8 Criteria Pollutants Lb/Tn Metal 21

List of Tables

Table 1-1 Test Plan Summary 4
Table 2-1 Process Parameters Measured 9
Table 2-2 Sampling and Analytical Methods 9
Table 3-1 Summary of Test Series FR and GG Average Results – Lb/Lb Binder 14
Table 3-2 Summary of Test Series FR and GG Average Results – Lb/Tn Metal 15
Table 3-3 Summary of Test Series FR and GG Average Process Parameters 16
Table 3-4 Casting Quality Data for Test Plan FR and Test Plan GG 17

Appendices

Appendix A Approved Test Plan and Sample Plan for Test Series FR and GG 25
Appendix B Test Series FR and GG Detailed Emission Results 57
Appendix C Test Series FR and GG Detailed Process Data 75
Appendix D Method 25A Charts 83
Appendix E Glossary 89

Executive Summary

This report contains the results of emission testing to evaluate the pouring, cooling, and shakeout emissions from Test GG, a phenolic urethane cored greensand system without seacoal. The testing was conducted to evaluate Hill and Griffith's Vein Away HT® anti-veining additive compared to the results from Test FR, a standard phenolic urethane cored coal-less greensand system without anti-veining additives. 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. These tests were conducted at 1.4% binder (BOS). Use of some of these additives in a working foundry may require increased binder levels to obtain a useable core with a corresponding emissions increase.

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, carbon dioxide, and nitrogen oxides were monitored according to US EPA Methods 10, 3A, and 7E respectively.

The mass emission rate of each parameter or target compound was calculated using the continuous monitoring data or the laboratory analytical results, the measured source data and the appropriate process data. 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 separate 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 VOCs measured and includes the 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 FR and GG Emissions Indicators – Lb/Lb Binder

Analytes	TGOC as Propane	HC as Hexane	Sum of Target Analytes	Sum of HAPs	Sum of POMs
Test FR Lb/Lb Binder	0.1480	0.0482	0.0591	0.0554	0.0169
Test GG Lb/Lb Binder	0.1428	NA	0.0570	0.0523	0.0152

Test Plan FR and GG Emissions Indicators – Lb/Tn Metal

Analytes	TGOC as Propane	HC as Hexane	Sum of Target Analytes	Sum of HAPs	Sum of POMs
Test FR Lb/Tn Metal	0.9259	0.3016	0.3705	0.3474	0.1059
Test GG Lb/Tn Metal	0.9960	NA	0.3975	0.3647	0.1059

A pictorial casting record was made of the cavity 3 from each mold. The pictures are shown in emission run number in Appendix C. Both series exhibited similar magnitude of veining and penetration core-surface defects.

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

1.0 Introduction

1.1 BACKGROUND

Technikon LLC is a privately held contract research organization located in McClellan, California, a suburb of Sacramento. Technikon offers emissions 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 Research, Development, and Engineering Command (RDECOM-ARDEC), a laboratory of the United States Army; the American Foundry Society; and the Casting Industry Suppliers Association.

1.2 TECHNIKON OBJECTIVES

The primary objective 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's principal testing arena is designed to measure airborne emissions from individually poured molds. This testing arena has been specially designed to facilitate the repeatable collection and evaluation of airborne emissions and associated process data.

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

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 target analyte 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 Number	1410 114 FR	1411 112 GG
Type of Process Tested	• Phenolic Urethane Core without Anti-Veining Compounds • Greensand without Seacoal, Iron PCS Baseline	• Phenolic Urethane Core with Anti-Veining Compound • Greensand without Seacoal, Iron PCS Product Test
Greensand System	• Wexford W450 Lakesand • Western and Southern Bentonite in a 5:2 ratio • No Seacoal	• Wexford W450 Lakesand • Western and Southern Bentonite in a 5:2 ratio • No Seacoal
Metal Poured	Iron	Iron
Casting Type	4-on Step Core	4-on Step Core
Core Binder	1.4% Ashland ISOCURE® 305/904	1.4% Ashland ISOCURE® 305/904
Core Sand	Amador A-70 Silica Sand	Wedron 530 Silica Sand
Anti-Veining Materials	No anti veining products	5% BOS H&G Vein Away HT®

Table 1-1 Test Plan Summary

Test Plan Number	**1410 114 FR**	**1411 112 GG**
Number of Molds Poured	3 Conditioning and 9 Sampling	3 Conditioning and 9 Sampling
Test Dates	1/15/04 > 1/29/04	9/21/04 > 9/23/04
Emissions Measured	• TGOC as Propane • HC as Hexane • Carbon Monoxide • Carbon Dioxide • 68 Organic HAPs and VOCs	• TGOC as Propane • HC as Hexane • Carbon Monoxide • Carbon Dioxide • Nitrogen Oxides • 68 Organic HAPs and VOCs
Process Parameters Measured	• Total Casting & Mold Weights • Binder Weights; • Metallurgical data • % LOI • Stack Temperature • Moisture Content • Sand Temperature • Pressure • Volumetric Flow Rate	• Total Casting & Mold Weights • Binder Weights • Metallurgical data, • % LOI • Stack Temperature • Moisture Content • Sand Temperature • Pressure • Volumetric Flow Rate

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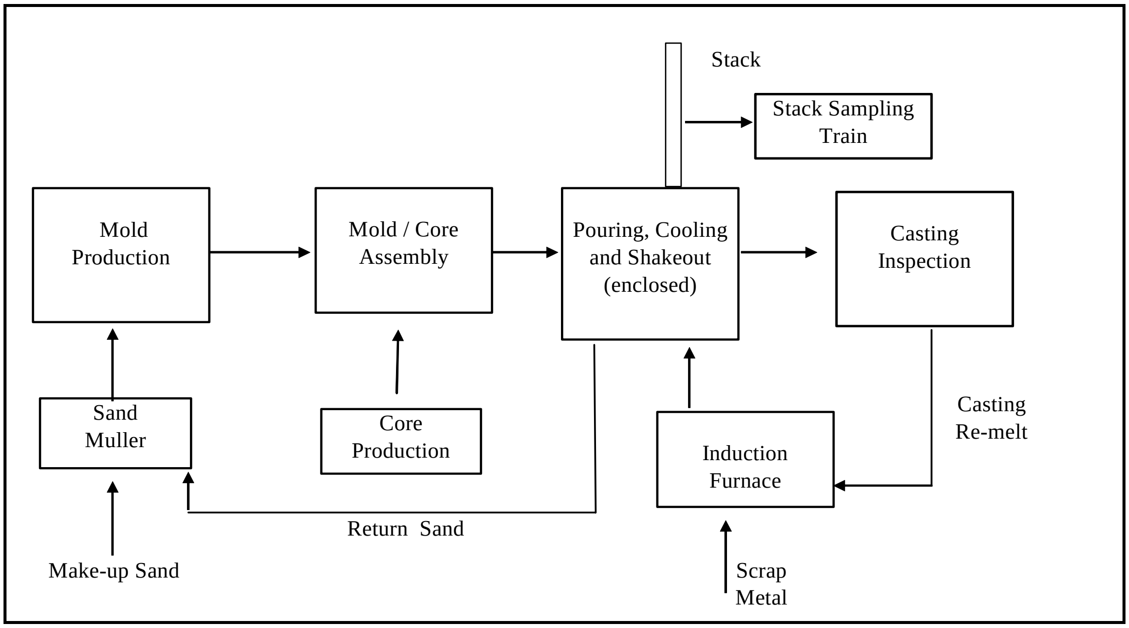
2.0 Test Methodology

2.1 DESCRIPTION OF PROCESS AND TESTING EQUIPMENT

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

Figure 2-1 Pre-Production Foundry Layout Diagram

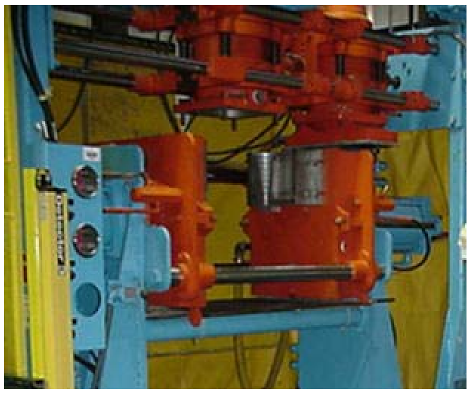


2.2 DESCRIPTION OF TESTING PROGRAM

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

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

2. **<u>Mold, Core and Metal Preparation</u>**: The molds and cores were prepared to a standard



Step Core Machine

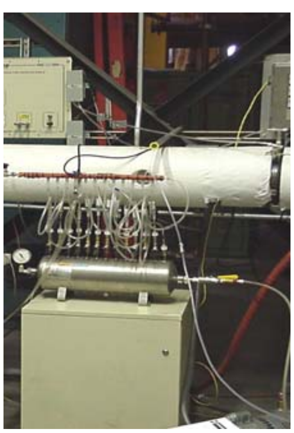
composition by the Technikon production team. The cores were blown in a Redford/Carver core blower. Relevant process data was collected and recorded. Iron was melted in a 1000 lb. Ajax induction furnace. The amount of metal melted was determined from the poured weight of the casting and the number of molds to be poured. The metal composition was Class-30 Gray Iron as prescribed by a metal composition work-sheet. The weight of metal poured into each mold was recorded on the process data summary sheet.

Total Enclosure Test Stand

3. **<u>Individual Sampling Events:</u>** Replicate tests were performed on nine mold packages after conditioning. 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 and Step Cores



Method 18 Sampling Train

Continuous Monitoring Instruments

4. **<u>Process Parameter Measurements:</u>** 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, Core 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 (Gravimetric)
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
Nitrogen Oxides*	EPA Method 7E

* Criteria Pollutants

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

6. **<u>Data Reduction, Tabulation and Preliminary Report Preparation</u>:** 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 binder and 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 3-2.

7. **<u>Report Preparation and Review:</u>** 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.

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3.0 Test Results

The average emission results for Test FR and Test GG 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 VOCs measured, along with the corresponding Sum of Target Analytes, Sum of HAPs, and Sum of POMs. The tables also include TGOC as propane, and HC as hexane, carbon monoxide, carbon dioxide, and nitrogen oxides.

Table 3-3 includes the averages of the key process parameters. Detailed process data are presented in Appendix C.

Figures 3-1 to 3-4 present the five emissions indicators, selected HAP and VOC emissions, and criteria pollutants data from Table 3-1 in graphical form based on binder weight.

Figures 3-5 to 3-8 present the five emissions indicators, selected HAP and VOC emissions, and criteria pollutants 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.

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

Casting quality pictures are shown in Appendix C.

The ranking of casting appearance is in Table 3-4.

Table 3-1 Summary of Test Series FR and GG Average Results – Lb/Lb Binder

Analytes	Test FR Lb/Lb Binder	Test GG Lb/Lb Binder	% Change from Baseline
TGOC as Propane	0.1480	0.1428	-4
HC as Hexane	0.0482	NA	NA
Sum of Target Analytes	0.0591	0.0570	-4
Sum of HAPs	0.0554	0.0523	-6
Sum of POMs	0.0169	0.0152	-10
Individual Organic HAPs			
Benzene	0.0174	0.0120	**-31**
Phenol	0.0113	0.0123	9
Methylnaphthalenes	0.0085	0.0081	-5
Naphthalene	0.0062	0.0043	**-31**
o,m,p-Cresol	0.0030	0.0046	**53**
Toluene	0.0026	0.0026	0
Dimethylnaphthalenes	0.0022	0.0028	**27**
Aniline	0.0021	0.0029	**38**
o,m,p-Xylene	0.0010	0.0012	**20**
Acetaldehyde	0.0005	0.0008	**60**
Other VOCs			
Trimethylbenzenes	0.0013	0.0013	0
Ethyltoluenes	0.0005	0.0007	**40**
Dimethylphenols	0.0003	0.0013	**333**
Other Analytes			
Carbon Dioxide	2.996	0.6789	**-77**
Carbon Monoxide	ND	0.2521	**NA**
Nitrogen Oxides	NT	0.0012	NA

Individual results constitute >95% of mass of all detected target analytes.
ND: Non Detect; NA: Not Applicable; NT: Not Tested.
The carbon dioxide and carbon monoxide results were generated via the collection of bag samples for Test FR. These results do not have the accuracy of the continuous monitoring results in Test GG.

Table 3-2 Summary of Test Series FR and GG Average Results – Lb/Tn Metal

Analytes	Test FR Lb/Tn Metal	Test GG Lb/Tn Metal	% Change from Baseline
TGOC as Propane	0.9259	0.9960	8
HC as Hexane	0.3016	NA	NA
Sum of Target Analytes	0.3705	0.3975	7
Sum of HAPs	0.3474	0.3647	5
Sum of POMs	0.1059	0.1059	0
Individual Organic HAPs			
Benzene	0.1088	0.0839	**-23**
Phenol	0.0707	0.0857	21
Methylnaphthalenes	0.0533	0.0566	6
Naphthalene	0.0389	0.0300	**-23**
o,m,p-Cresol	0.0187	0.0324	**73**
Toluene	0.0161	0.0180	**12**
Dimethylnaphthalenes	0.0137	0.0193	**41**
Aniline	0.0130	0.0205	**58**
o,m,p-Xylene	0.0064	0.0086	**34**
Acetaldehyde	0.0034	0.0059	**74**
Other VOCs			
Trimethylbenzenes	0.0079	0.0094	**19**
Ethyltoluenes	0.0028	0.0047	**68**
Dimethylphenols	0.0017	0.0093	**447**
Other Analytes			
Carbon Dioxide	18.53	4.735	**-74**
Carbon Monoxide	ND	1.758	**NA**
Nitrogen Oxides	NT	0.0084	**NA**

Individual results constitute >95% of mass of all detected target analytes.
ND: Non Detect; NA: Not Applicable; NT: Not Tested.
The carbon dioxide and carbon monoxide results were generated via the collection of bag samples for Test FR. These results do not have the accuracy of the continuous monitoring results in Test GG.

Table 3-3 Summary of Test Series FR and GG Average Process Parameters

Greensand PCS with Anti-Veining Core Additive		
Test GG	**Test FR Reference No additions**	**Test GG H&G VeinAwayHT®**
Test Dates	01/15-16/04	09/20-23/04
Cast weight (all metal inside mold), Lbs.	111.1	112.4
Pouring time, sec.	28	15.3
Pouring temp ,°F	2632	2635
Pour hood process air temp at start of pour, ^{o}F	87	88
Mixer auto dispensed batch weight, Lbs	45.4	50.4
Weighed binder weight, Lbs	0.633	0.713
Core binder calculated weight, %BOS	1.39	1.42
Core binder calculated weight, %	1.38	1.40
Total uncoated core weight in mold, Lbs.	25.3	28.1
Total binder weight in mold, Lbs.	0.347	0.392
Core LOI, % [1]	1.26	1.61
Core dogbone 2 hour average tensile, psi [2]	40	175
Core age, hours [3]	61	196
Muller batch weight, Lbs.	900	900
GS mold sand weight, Lbs.	620	635
Mold compactability, %	56	56
Mold temperature, ^{o}F	70	81
Average green compression , psi	11.0	24.2
GS compactability, %	53	46
GS moisture content, %	2.27	2.26
GS MB clay content, %	6.02	8.62
MB clay reagent, ml	26.0	33.2
1800°F LOI - mold sand, %	0.71	0.98
900°F volatiles , %	0.24	0.28

[1] Measured LOI was inexplicably high. The customary range is 1.3 – 15%. The base sand for FR was Amador 70, for GG was Wedron 530: Raw sands have LOIs independent of the binders added. Denser aggregate leads to more binder in the mold.

[2] FR used Universal 405, GG used Thwing-Albert tensile tester: Expected value for FR from Thwing-Albert tensile tester would have been 104 psi..

[3] Core age contributed to tensile strength.

Table 3-4 Casting Quality Data for Test Plan FR and Test Plan GG

Overall Casting Appearance	**Emission Mold Number**	
Best 1	FR003	
2		GG008
3		GG001
4		GG002
5		GG007
6	FR001	GG005
7		GG004
8	FR002	GG006
9		GG009
10		GG003
Worst 11	FR004	

Figure 3-1 Emission Indicators from Test Series FR and GG – Lb/Lb Binder

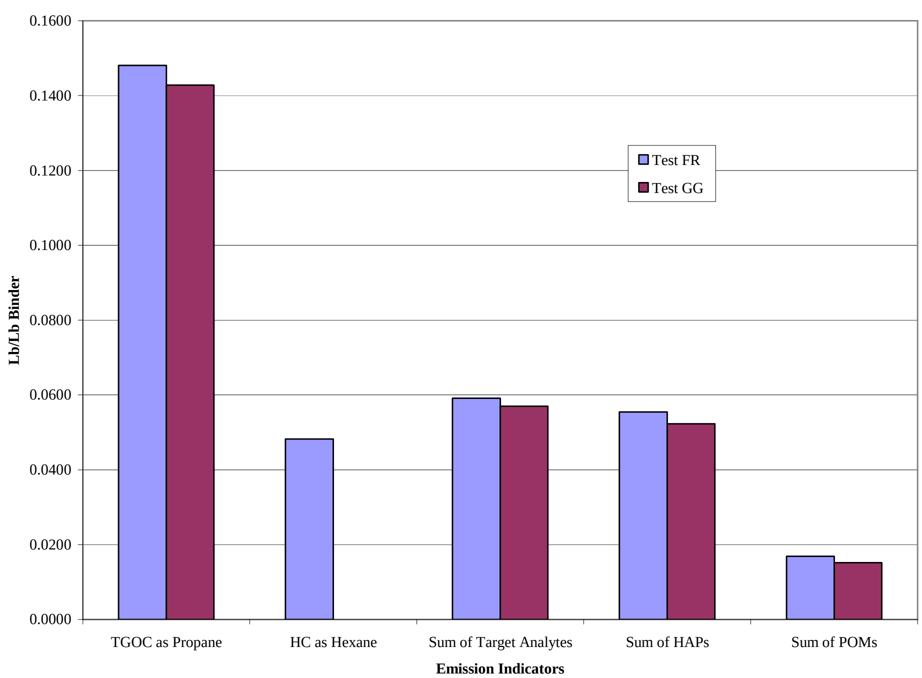


Figure 3-2 Selected HAP Emissions from Test Series FR and GG– Lb/Lb Binder

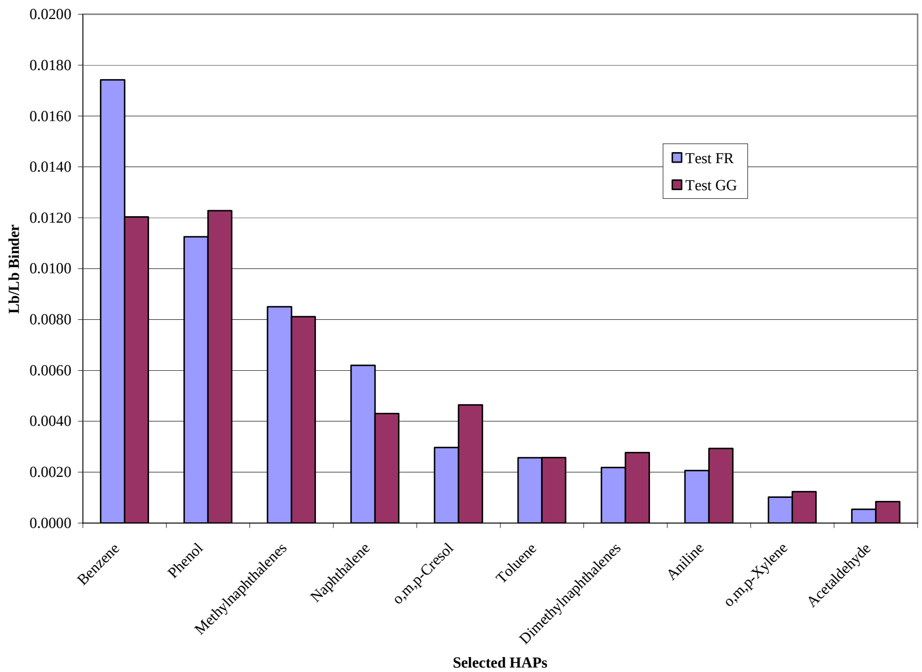


Figure 3-3 Selected VOC Emissions from Test Series FR and GG – Lb/Lb Binder

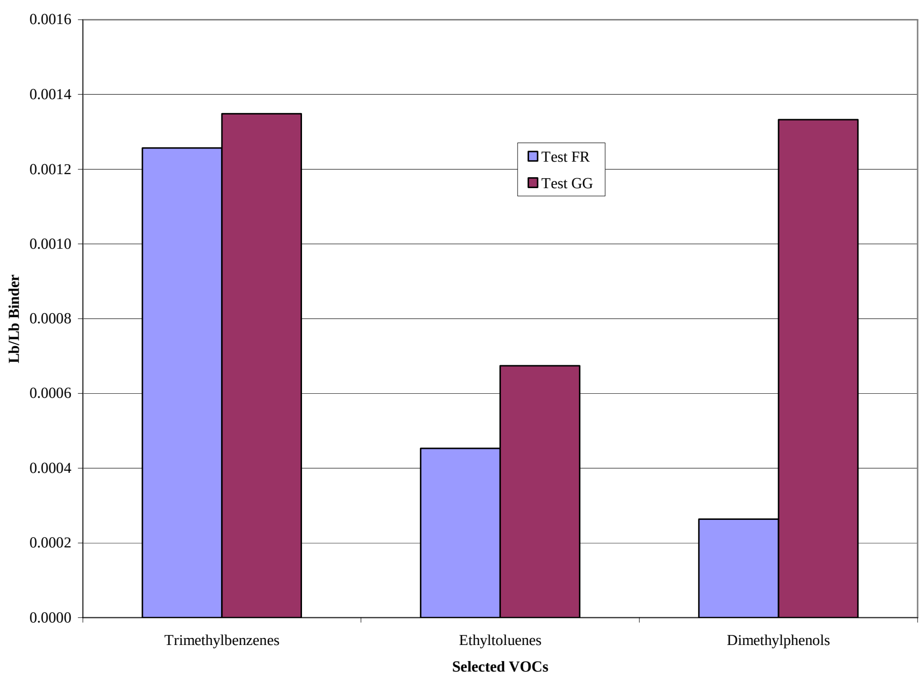


Figure 3-4 Selected Criteria Pollutants Lb/Lb Binder

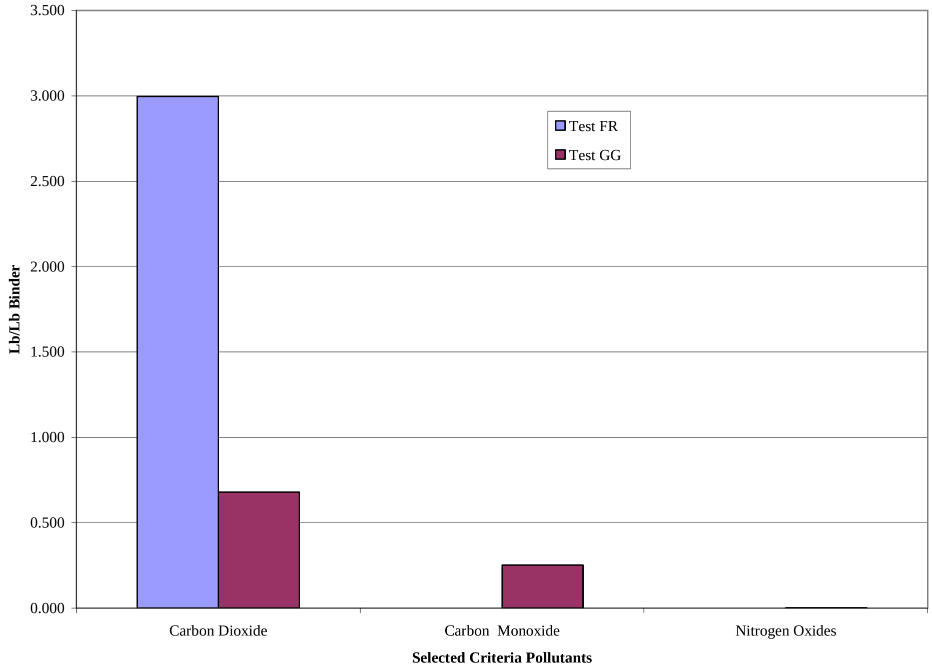


Figure 3-5 Emissions Indicators from Test Series FR and GG – Lb/Tn Metal

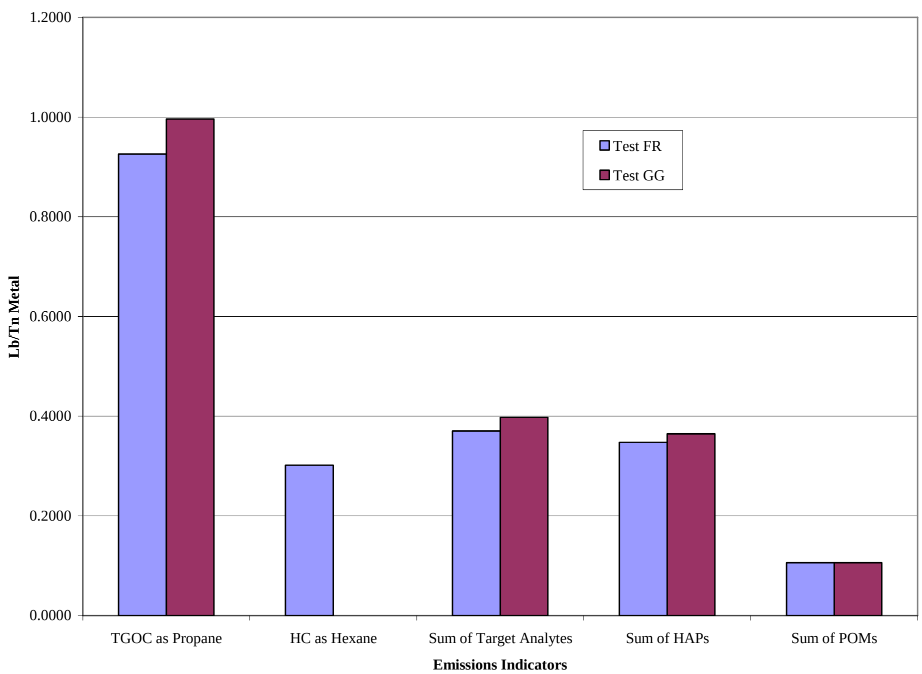


Figure 3-6 Selected HAP Emissions from Test Series FR and GG – Lb/Tn Metal

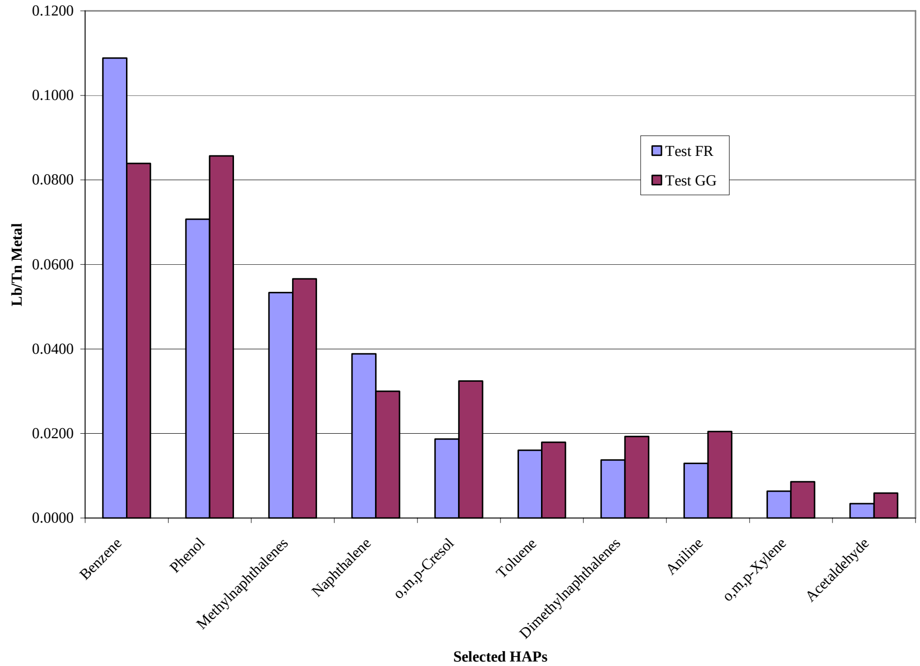


Figure 3-7 Selected VOC Emissions from Test Series FR and GG – Lb/Tn Metal

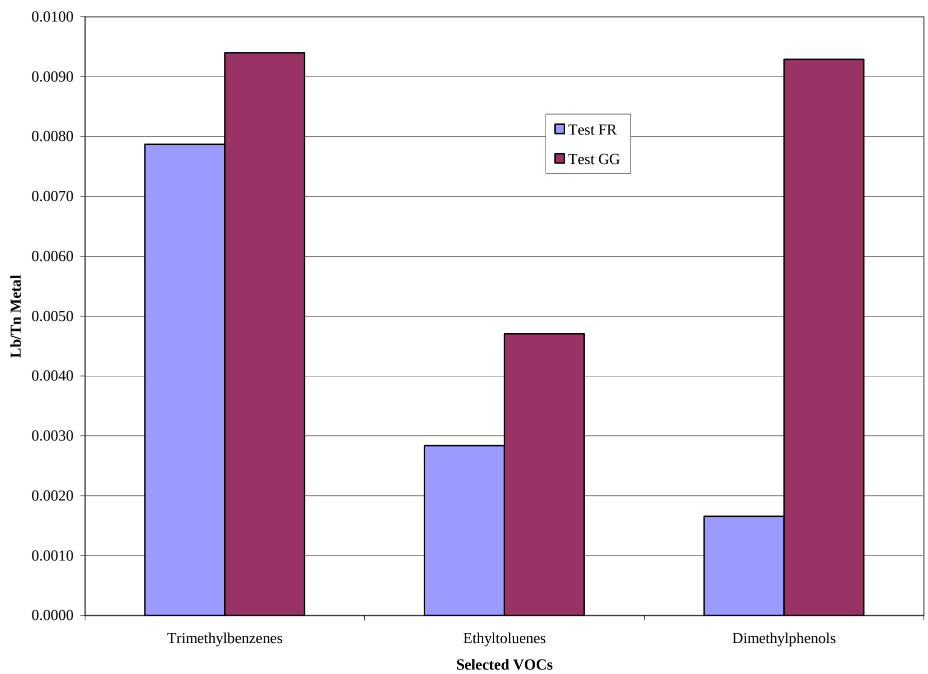
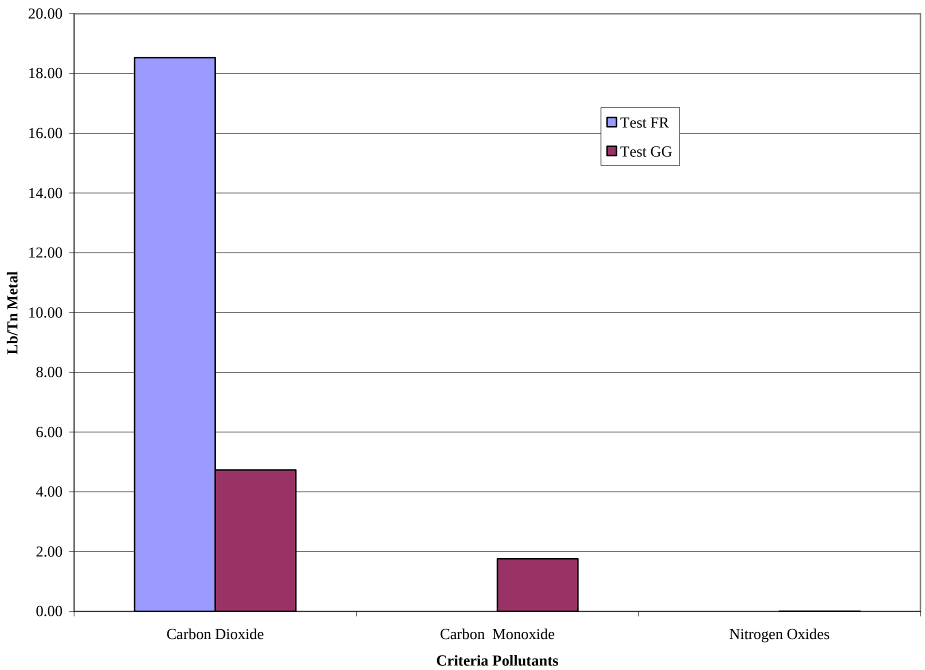


Figure 3-8 Criteria Pollutants Lb/Tn Metal



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4.0 Discussion of Results

The sampling and analytical methodologies were the same for Test Plans FR and GG except for the determination of carbon monoxide and carbon dioxide. These analytes were collected in a Tedlar bag for offsite analysis on Test FR and were determined on-line with NIST traceable monitors for Test GG. The on-line monitors provide significantly more accurate data than the bag samples. Similarly, the nitrogen oxides were not tested for under Test FR, but were determined on-line for Test GG.

Observation of measured process parameters indicates that the tests were run within an acceptable range. However, the apparent differences in measured core tensile strengths and LOI can be substantially accounted for by the fact that the tensile strength as measured in the baseline and product test were performed on different equipment. The Thwing-Albert tensile tester generates values typically 64 psi higher than the Deitert 405 Universal tensile tester. The Amador 70 sand used in test FR was of a different character (grain fineness) than the Wedron 530 sand used the current test. The Wedron sand creates a denser core carrying a greater amount of binder to the mold. This leads to a higher LOI; which is not an issue with air emission results since they are reported as lb. of emission per lb. of binder.

In Tables 3-1 and 3-2, the "% Change from Baseline" emissions values presented in **bold** letters have a greater than 95% probability that the differences in the average values were not the result of variability in the test protocol 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 GG to Test FR show an 8% increase in TGOC (THC) as propane, a 7% increase in Sum of target analytes, an increase in Sum of HAPs, and no change in the Sum of POMs when expressed in pounds per ton of metal. The HC as hexane results for all tests were invalidated for Test GG due to data validation considerations. When expressed in pounds per pound of binder, the results for the above analytes were less in Test GG than in Test FR. See Tables 3-1 and 3-2.

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).

Carbon dioxide and methane were detected in the ambient sample for Test FR. No samples were background corrected. Carbon dioxide and carbon monoxide (a criteria pollutant) were detected in the ambient samples for test GG and all samples were background corrected. The carbon dioxide and carbon monoxide results were generated via the collection of bag samples for Test FR These results do not have the accuracy of the continuous monitoring results in Test GG.

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 core surface finish was similar in both test series exhibiting variations in both veining and penetration defects.

APPENDIX A APPROVED TEST PLAN AND SAMPLE PLAN FOR TEST SERIES FR AND GG

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TECHNIKON TEST PLAN

- > **CONTRACT NUMBER:** 1410 **TASK NUMBER:** 1.1.4 **Series:** FR
- > **SITE:** Pre-production
- > **TEST TYPE:** Product Test: Pouring, cooling, & shakeout of uncoated Phenolic urethane step cores with anti-veining compounds.
- > **METAL TYPE:** Class-30 gray iron
- > **MOLD TYPE:** Virgin, no seacoal, greensand with 4-on PU step-cores recycled after each pour.
- > **NUMBER OF MOLDS:** Three engineering & conditioning runs + 4 sampling runs each from reference cores w/o anti-veining additive and two (2) anti-veining compounds. Twenty-one (21) runs total.
- > **CORE TYPE:** Step: 1.4% Ashland ISOCURE® Phenolic Urethane LF305 part I (55%), 904GR Part II (45%), amine cured. 50-120 hrs old. Reference cores shall not contain anti-veining material. Test cores shall contain 1% (BOS) Ashland 070359 red iron oxide fine or 2% (BOS) Chesapeake Specialty Products SpherOX® black iron oxide fine.
- > **CORE COATING:** Cores shall be uncoated.
- > **SAMPLE EVENTS:** 4 runs each for reference cores and two core sets containing different anti-veining materials, total twelve sample runs (12).
- > **TEST DATE: START:** 12 Jan 2004

  FINISHED: 30 Jan 2004

TEST OBJECTIVES:

Measure the airborne pouring, cooling, & shakeout emissions for organic step cores containing anti-veining compounds in a mechanically-produced clay, water, coal-less 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, no seacoal, 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 Amador-70 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.

BRIEF OVERVIEW:

This is the first test to include materials contained in the core in addition to the binder. The purpose of the included core additives is to reduce the veining defect common to silica sand cores poured with iron. This test and test FT, using different anti-veining materials, are intended to determine if the anti-veining compounds impact the emissions from the base binder in an uncoated core poured with iron.

The greensand molds will be produced on the mechanically assisted Osborne 716 molding machines.

The emission results will be compared to an internal baseline of uncoated step cores of the same binder content. 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. Cores will be produced with Amador A-70 silica sand at 85-90^{o}F. The core 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 FR

PCS Core Product Test in Greensand with Ashland 305/904 Core Binder, anti-veining compound, & Mechanized Molding

Process Instructions

A. Experiment:

1. Measure pouring, cooling, & shakeout emissions from uncoated organic cores, containing an anti-veining compound, 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, & no 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

B. Materials:

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

2. Core: Step cores made with virgin Amador A-70 sand and 1.4% Ashland ISOCURE® LF305/52-904GR regular phenolic urethane binder in a 55/45 ratio, TEA catalyzed. Reference cores shall be made without any anti-veining compound and the test cores shall include an anti-veining compound.

3. Anti Vein Compounds: To the test core sand mixes shall be added:

a. 1% (BOS) Ashland (070359) Red Iron Oxide Fine (Fe_2O_3) or

b. 2% (BOS) of Chesapeake Specialty Products SpherOX® Black Iron Oxide Fine (Fe_3O_4).

4. Metal: Class-30 gray cast iron poured at 2630 +/- 10^{o}F.

5. Pattern Spray: Black Diamond, hand wiped.

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. Premix anti-veining compound in blue R/C mixer.

a. Make 2 batches of sand. The first containing 1% (BOS) Ashland red iron oxide fine anti-veining compound, and the other 2% (BOS) Chesapeake Specialty Products' black iron oxide fine anti-veining compound.

b. For each batch add 400 pounds of dry A-70 sand to the R/C mixer.

- **c.** Distribute 4.00 pounds of Ashland red iron oxide to one batch and 8.00 pounds of black iron oxide to the remaining batch. Clean the mixer with 50 pounds of clean sand between batches.
- **d.** Mix each batch for 10 minutes.
- **e.** Place the respective batches in clean containers to be heated to 85-90^{o}F degrees prior to mixing with the core binder.

2. 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 disconnects and MASTER START push button.
- **c.** Fill the Part I and Part II pumps and de-air the lines.
- **d.** 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.
    - **g)** Turn off the mixer and replace the mixing bowl skirt.

  - **4)** Turn on the mixer and turn the AUTO/MAN switch to AUTO.
    - **a)** Press the SINGLE CYCLE push button on the operator's station to make a batch of sand. Make three (3) batches to start the Redford Carver core machine.
    - **b)** 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.

c) Clean the mixer after each material.
d) Approximately 7 batches will be needed for each core material type.
e) Mix the sand without anti-veining compound first, then the material containing the 1% red iron oxide, and finally the material containing the 2% black iron oxide.

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

3. 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 oF 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.

E. Sand preparation

1. Start up batch: make 3, FRCD1, FRCD4, & FRCD7. One batch is for each type of core material.

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: FRCD2, FRCD5, & FRCD8

a. Add to the sand recovered from poured mold FRCD1, FRCD4, or FRCD 7 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.

3. **3.** Re-mulling: FRCD3, FRCD6, FRCD9 & FR001-FR0XX
   - **a.** Add to the sand recovered from the previous poured mold, mold machine spill sand, the residual mold hopper sand and sufficient pre-blended sand to total 900 +/- 10 pounds.
   - **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.

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

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

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 on top.
   d. Bring the furnace contents to the point of beginning to melt over a period of 1 hour at reduced power.
   e. Add the balance of the 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°F and slag the furnace.
   - **j.** Record all metallic and alloy additions to the furnace, tap temperature, and pour temperature.
   - **k.** 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°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°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°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 FN001, compare it to castings from mold FN002.
   - **c.** Place the better appearing casting in the first position and the lesser appearing casting in the second position.
   - **d.** Repeat this procedure with FN001 to its nearest neighbors until all castings closer to the beginning of the line are better appearing than FN001 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 FR - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
1/14/2004											FR CONDITIONING - RUN 1
FR CR-1											
THC		X									

PRE-PRODUCTION FR - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
1/14/2004											FR CONDITIONING - RUN 2
FR CR-2											
THC		X									

PRE-PRODUCTION FR - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
1/15/2004											FR CONDITIONING - RUN 3
FR CR-3											
THC		X									

PRE-PRODUCTION FR - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
1/15/2004											
RUN 1											
THC	FR001	X									TOTAL
M-18	FR00101		1						60	1	Carbopak charcoal
M-18 MS	FR00102		1						60	2	Carbopak charcoal
M-18 MS	FR00103			1					60	3	Carbopak charcoal
Gas, CO, CO2	FR00104		1						60	4	Tedlar Bag
Gas, CO, CO2	FR00105				1				0		Tedlar Bag
NIOSH 1500	FR00106		1						1000	5	100/50 mg Charcoal (SKC 226-01)
NIOSH 1500	FR00107				1				0		100/50 mg Charcoal (SKC 226-01)
	Excess								1000	6	Excess
NIOSH 2002	FR00108		1						1000	7	100/50 mg Silica Gel (SKC 226-10)
NIOSH 2002	FR00109				1				0		100/50 mg Silica Gel (SKC 226-10)
	Excess								1000	8	Excess
TO11	FR00110		1						1000	9	DNPH Silica Gel (SKC 226-119)
TO11	FR00111				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 FR - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
1/15/2004											
RUN 2											
THC	FR002	X									TOTAL
M-18	FR00201		1						60	1	Carbopak charcoal
M-18	FR00202			1					60	2	Carbopak charcoal
M-18	FR00203				1				0		Carbopak charcoal
	Excess								60	3	Excess
Gas, CO, CO2	FR00204		1						60	4	Tedlar Bag
NIOSH 1500	FR00205		1						1000	5	100/50 mg Charcoal (SKC 226-01)
NIOSH 1500	FR00206			1					1000	6	100/50 mg Charcoal (SKC 226-01)
NIOSH 2002	FR00207		1						1000	7	100/50 mg Silica Gel (SKC 226-10)
NIOSH 2002	FR00208			1					1000	8	100/50 mg Silica Gel (SKC 226-10)
TO11	FR00209		1						1000	9	DNPH Silica Gel (SKC 226-119)
TO11	FR00210			1					1000	10	DNPH Silica Gel (SKC 226-119)
	Excess								1000	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

PRE-PRODUCTION FR - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
1/16/2004											
RUN 3											
THC	FR003	X									TOTAL
M-18	FR00301		1						60	1	Carbopak charcoal
M-18	FR00302					1			60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
Gas, CO, CO2	FR00303		1						60	4	Tedlar Bag
NIOSH 1500	FR00304		1						1000	5	100/50 mg Charcoal (SKC 226-01)
	Excess								1000	6	Excess
NIOSH 2002	FR00305		1						1000	7	100/50 mg Silica Gel (SKC 226-10)
	Excess								1000	8	Excess
TO11	FR00306		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

PRE-PRODUCTION FR - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
1/16/2004											
RUN 4											
THC	FR004	X									TOTAL
M-18	FR00401		1						60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
Gas, CO, CO2	FR00402		1						60	4	Tedlar Bag
NIOSH 1500	FR00403		1						1000	5	100/50 mg Charcoal (SKC 226-01)
	Excess								1000	6	Excess
NIOSH 2002	FR00404		1						1000	7	100/50 mg Silica Gel (SKC 226-10)
	Excess								1000	8	Excess
TO11	FR00405		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

TECHNIKON TEST PLAN

CONTRACT NUMBER: 1411 **TASK NUMBER:** 112 **SERIES:** GG

SITE: Research Foundry

TEST TYPE: Step Core - Pour, cool, & shakeout in greensand with no coal

METAL TYPE: Class 30 Gray Iron poured at 2630^{o}F

MOLD TYPE: 4-on step core greensand with no coal

NUMBER OF MOLDS: 12 (3 engineering/conditioning + 9 sampling)

CORE TYPE: Step Core at 1.4% - Phenolic Urethane Ashland Cold Box LF305 part 1 @ (55%) and 904GR Part II (45%). Test Cores to contain 5% (BOS)Hill & Griffiths Vein Away HT® anti-viening compound.

CORE COATING: Cores to be uncoated

SAMPLE EVENTS: 9

TEST DATE(S): **Start:** 13 Sept 2004

Finish: 17 Sept 2004

TEST OBJECTIVES:

Measure selected PCS HAP & VOC emissions, CO, CO_2, NOx, & TGOC from H&G Vein Away HT® anti-veining compound. Use Analyte list A

VARIABLES:

The pattern will be the 4-on step core. The mold will be made with Wexford W450 Lake Sand, western and southern bentonite in a 5:2 ratio to yield 7.0 +/- 0.5% MB Clay, no seacoal, and tempered to 40-50% 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.

BRIEF OVERVIEW:

This is a product test of anti-veining core additive. The purpose of this core additive is to reduce the veining defect common to silica sand cores poured with iron. This test and tests FR& FT, using different anti-veining materials, are intended to determine if the anti-veining compounds impact the emissions from the base binder in an uncoated core poured with iron. The greensand molds will be produced on the mechanically assisted Osborne 716 molding machines. The emission results will be compared to an internal baseline of uncoated step cores of the same binder and binder content but without anti-veining compounds from test FR. In addition to a suite of selected emission analytes TGOC, CO, CO_2, & NOx 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. Cores will be produced with Wedron 530 silica sand at 85-90^{o}F then bagged in vapor proof containers until insertion into the mold. The cores shall be stabilized for 50-120 hours when tested. The sampling environment will be maintained at 85-90^{o}F.

Series GG

PCS product test: Un-Coated Core with Ashland 305/904 ISOCURE® Core Binder & Hill & Griffiths Vein Away HT® Anti Veining additive, Virgin Greensand with No Coal & Mechanized Molding

Process Instructions

A. Experiment:

1. Measure pouring, cooling, & shakeout emissions from un-coated organic cores in a greensand mold made with all virgin Wexford W450 sand, bonded with Western & Southern Bentonite in a 5:2 ratio 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 clay materials after each casting cycle and providing clay for the retained core sand. Emissions & surface appearance will be compared to the greensand uncoated core baseline FR.

B. Materials:

1. Mold sand:
   - **a.** Virgin mix of Wexford W450 lake sand, western and southern bentonites in the ratio of 5:2, and potable water per recipe.
2. 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.
3. Anti Vein Compounds:
   - **a.** To the test core sand mixes shall be added:
     - **1)** % (BOS) H&G VeinAwayHT®
4. Metal:
   - **a.** Class-30 gray cast iron poured at 2630 +/- 10^{o}F.
5. Pattern release:
   - **a.** Black Diamond, hand wiped.

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.** The binder components should be 75-85^{o}F.
   - **b.** Calibrate the Klein mixer sand batch size.

1) Remove the mixing bowl skirt to gain access to the bottom side of the batch hopper outlet gate. Install a skirt on the back half of the mixing bowl
2) Calibrate sand.
    a) Turn the AUTO/MAN switch to MANUAL on main control panel.
    b) Place one bucket of preheated raw sand, 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 75-85^{o}F.

c. Pre-weigh 1.4% (BOS) of the two part binder into two non-absorbing containers for addition to the mixer: 55% Part I shall be in one container, 45% Part II in the other.
d. Turn on the mixer and turn the AUTO/MAN switch to AUTO.
e. Press the SINGLE CYCLE push button on the operator's station to make a batch of sand. As soon as the sand enters the mixer chamber pour the pre-weighed binder through the open top front half of the mixing chamber.
f. Make three (3) batches to start the Redford Carver core machine.
g. 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.
h. Clean the mixer bowl 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^oF 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^oF core LOI test method and reported out associated with the test mold it is to represent.

E. Sand preparation

1. Start up batch: make 1, GGCD1

- **a.** Thoroughly clean the pre-production muller, elevator, and molding hoppers.
- **b.** Weigh and add 1209 +/-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 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 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 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°F loss on ignition (LOI), and 900°F volatiles. Each greensand volatile test requires a 50 gram sample, each greensand LOI test requires a 30 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: GGCD2, GGCD3, & GG4-12

- **a.** Add to the sand recovered from poured mold GGCD1 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.

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.

Caution: Before making test molds verify that the mold machine is running correctly and there are no supply air leaks that would lead to soft molds ad metal penetration.

- **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.

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. Casting cleaning.

1. Spin blast set up.
- **a.** Load the spin blast shot storage bin with 460 steel shot.
- **b.** Turn on the spin blast bag house.
- **c.** Turn on the spin blast machine.

- **d.** Increase the magnetic feeder so that the motor amperage just turns to 12 amps from 11 amps.
- **e.** Record the shot flow and the motor amperage for each wheel

2. Cleaning castings.
- **a.** Place the four (4) castings from a single mold on one (1) casting basket.
- **b.** Process each rotating basket for eight (8) minutes.
- **c.** Remove and remark casting ID on each casting.

L. Rank order evaluation.

1. The supervisor shall select a group of three 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 GG001, compare it to castings from mold GG002.
- **c.** Place the better appearing casting in the first position and the lesser appearing casting in the second position.
- **d.** Repeat this procedure with GG001 to its nearest neighbors until all castings closer to the beginning of the line are better appearing than GG001 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 GG - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/20/2004											**GG CONDITIONING - RUN 1**
GG CR-1											
THC, CO,CO2, NOX		x									

PRE-PRODUCTION GG - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/20/2004											**GG CONDITIONING - RUN 2**
GG CR-2											
THC, CO,CO2, NOX		x									

PRE-PRODUCTION GG - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/20/2004											**GG CONDITIONING - RUN 3**
GG CR-3											
THC, CO,CO2, NOX		x									

PRE-PRODUCTION GG - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/21/2004											
RUN 1											
THC, CO,CO2, NOX	GG001	X									TOTAL
M-18	GG00101		1						60	1	Carbopak charcoal
M-18	GG00102				1				0		Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GG00103		1						850	5	100/50 mg Silica Gel (SKC 226-10)
NIOSH 2002	GG00104				1				0		100/50 mg Silica Gel (SKC 226-10)
	Excess								850	6	Excess
NIOSH 1500	GG00105		1						850	7	100/50 mg Charcoal (SKC 226-01)
NIOSH 1500	GG00106				1				0		100/50 mg Charcoal (SKC 226-01)
	Excess								850	8	Excess
TO11	GG00107		1						850	9	DNPH Silica Gel (SKC 226-119)
TO11	GG00108				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 GG - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/21/2004											
RUN 2											
THC, CO,CO2, NOX	GG002	X									TOTAL
M-18	GG00201		1						60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GG00202		1						850	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								850	6	Excess
NIOSH 1500	GG00203		1						850	7	100/50 mg Charcoal (SKC 226-01)
	Excess								850	8	Excess
TO11	GG00204		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 GG - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/21/2004											
RUN 3											
THC, CO,CO2, NOX	GG003	X									TOTAL
M-18	GG00301		1						60	1	Carbopak charcoal
M-18	GG00302			1					60	2	Carbopak charcoal
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GG00303		1						850	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								850	6	Excess
NIOSH 1500	GG00304		1						850	7	100/50 mg Charcoal (SKC 226-01)
	Excess								850	8	Excess
TO11	GG00305		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 GG - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/22/2004											
RUN 4											
THC, CO,CO2, NOX	GG004	X									TOTAL
M-18	GG00401		1						60	1	Carbopak charcoal
M-18 MS	GG00402		1						60	2	Carbopak charcoal
M-18 MS	GG00403			1					60	3	Carbopak charcoal
	Excess								60	4	Excess
NIOSH 2002	GG00404		1						850	5	100/50 mg Silica Gel (SKC 226-10)
NIOSH 2002	GG00405			1					850	6	100/50 mg Silica Gel (SKC 226-10)
NIOSH 1500	GG00406		1						850	7	100/50 mg Charcoal (SKC 226-01)
NIOSH 1500	GG00407			1					850	8	100/50 mg Charcoal (SKC 226-01)
TO11	GG00408		1						850	9	DNPH Silica Gel (SKC 226-119)
TO11	GG00409			1					850	10	DNPH Silica Gel (SKC 226-119)
	Excess								850	11	Excess
	Moisture		1						500	12	TOTAL
	Excess								5000	13	Excess

PRE-PRODUCTION GG - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/22/2004											
RUN 5											
THC, CO,CO2, NOX	GG005	X									TOTAL
M-18	GG00501		1						60	1	Carbopak charcoal
M-18	GG00502					1			60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								40	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GG00503		1						850	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								850	6	Excess
NIOSH 1500	GG00504		1						850	7	100/50 mg Charcoal (SKC 226-01)
	Excess								850	8	Excess
TO11	GG00505		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 GG - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/22/2004											
RUN 6											
THC, CO,CO2, NOX	GG006	X									TOTAL
M-18	GG00601		1						60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GG00602		1						850	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								850	6	Excess
NIOSH 1500	GG00603		1						850	7	lost
	Excess								850	8	Excess
TO11	GG00604		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 GG - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/23/2004											
RUN 7											
THC, CO,CO2, NOX	GG007	X									TOTAL
M-18	GG00701		1						60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GG00702		1						850	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								850	6	Excess
NIOSH 1500	GG00703		1						850	7	100/50 mg Charcoal (SKC 226-01)
	Excess								850	8	Excess
TO11	GG00704		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 GG - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/23/2004											
RUN 8											
THC, CO,CO2, NOX	GG008	X									TOTAL
M-18	GG00801		1						60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GG00802		1						850	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								850	6	Excess
NIOSH 1500	GG00803		1						850	7	100/50 mg Charcoal (SKC 226-01)
	Excess								850	8	Excess
TO11	GG00804		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 GG - SERIES SAMPLE PLAN

Method	Sample #	Data	Sample	Duplicate	Blank	Breakthrough	Spike	Spike Duplicate	Flow (ml/min)	Train Channel	Comments
9/23/2004											
RUN 9											
THC, CO,CO2, NOX	GG009	X									TOTAL
M-18	GG00901		1						60	1	Carbopak charcoal
	Excess								60	2	Excess
	Excess								60	3	Excess
	Excess								60	4	Excess
NIOSH 2002	GG00902		1						850	5	100/50 mg Silica Gel (SKC 226-10)
	Excess								850	6	Excess
NIOSH 1500	GG00903		1						850	7	100/50 mg Charcoal (SKC 226-01)
	Excess								850	8	Excess
TO11	GG00904		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

APPENDIX B TEST SERIES FR AND GG DETAILED EMISSION RESULTS

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

HAPs	POMs	Compound/Sample Number	FR001	FR002	FR003	FR004	Average	STDEV
		Test Dates	**1/15/04**	**1/15/04**	**1/16/04**	**1/16/04**		
		TGOC as Propane	1.55E-01	1.41E-01	1.57E-01	1.39E-01	1.48E-01	9.38E-03
		HC as Hexane	4.88E-02	5.06E-02	5.04E-02	4.30E-02	4.82E-02	3.54E-03
		Sum of VOCs	5.77E-02	5.84E-02	6.13E-02	I	5.91E-02	1.92E-03
		Sum of HAPs	5.37E-02	5.44E-02	5.82E-02	I	5.54E-02	2.44E-03
		Sum of POMs	1.47E-02	1.71E-02	1.88E-02	I	1.69E-02	2.06E-03
		Individual Organic HAPs						
x		**Benzene**	1.93E-02	1.45E-02	1.85E-02	I	1.74E-02	2.60E-03
x		**Phenol**	1.02E-02	1.25E-02	1.11E-02	I	1.13E-02	1.18E-03
x	z	**Naphthalene**	5.89E-03	6.21E-03	6.50E-03	I	6.20E-03	3.04E-04
x	z	**2-Methylnaphthalene**	4.72E-03	5.70E-03	6.26E-03	I	5.56E-03	7.77E-04
x	z	**1-Methylnaphthalene**	2.48E-03	3.02E-03	3.30E-03	I	2.94E-03	4.17E-04
x		**Toluene**	2.75E-03	2.29E-03	2.66E-03	I	2.57E-03	2.48E-04
x		**o-Cresol**	2.18E-03	2.67E-03	2.56E-03	I	2.47E-03	2.52E-04
x		**Aniline**	1.80E-03	2.26E-03	1.88E-03	2.34E-03	2.07E-03	2.73E-04
x	z	**1,3-Dimethylnaphthalene**	7.16E-04	9.11E-04	1.02E-03	I	8.84E-04	1.56E-04
x		**m,p-Xylene**	8.81E-04	7.83E-04	8.23E-04	I	8.29E-04	4.93E-05
x		**Acetaldehyde**	4.97E-04	5.86E-04	5.20E-04	5.81E-04	5.46E-04	4.43E-05
x		**m,p-Cresol**	4.20E-04	5.58E-04	5.33E-04	I	5.04E-04	7.35E-05
x	z	**1,6-Dimethylnaphthalene**	2.88E-04	3.65E-04	4.14E-04	I	3.55E-04	6.35E-05
x	z	**2,6-Dimethylnaphthalene**	2.56E-04	3.27E-04	3.72E-04	I	3.18E-04	5.86E-05
x	z	**2,7-Dimethylnaphthalene**	2.56E-04	3.27E-04	3.72E-04	I	3.18E-04	5.86E-05
x		**Styrene**	1.64E-04	4.94E-04	1.56E-04	I	2.71E-04	1.93E-04
x		**o-Xylene**	1.97E-04	1.83E-04	1.81E-04	I	1.87E-04	8.82E-06
x	z	**1,2-Dimethylnaphthalene**	1.24E-04	1.65E-04	1.84E-04	I	1.58E-04	3.04E-05
x		**Formaldehyde**	1.61E-04	1.12E-04	1.15E-04	1.10E-04	1.24E-04	2.46E-05
x	z	**2,3-Dimethylnaphthalene**	ND	5.29E-05	3.15E-04	I	1.23E-04	1.69E-04
x		**Biphenyl**	9.52E-05	1.20E-04	1.43E-04	I	1.19E-04	2.39E-05
x		**Ethylbenzene**	1.11E-04	1.27E-04	1.08E-04	I	1.15E-04	9.96E-06
x		**Hexane**	8.21E-05	9.70E-05	9.69E-05	I	9.20E-05	8.58E-06
x		**Propionaldehyde**	3.85E-05	3.63E-05	3.51E-05	3.85E-05	3.71E-05	1.73E-06
x		**2-Butanone**	3.94E-05	4.46E-05	3.45E-05	2.61E-05	3.61E-05	7.85E-06
x	z	**1,5-Dimethylnaphthalene**	ND	ND	9.79E-05	I	3.26E-05	5.65E-05
x	z	**Acenaphthalene**	ND	ND	ND	I	ND	NA
x	z	**1,8-Dimethylnaphthalene**	ND	ND	ND	I	ND	NA
x	z	**2,3,5-Trimethylnaphthalene**	ND	ND	ND	I	ND	NA
x		**Dimethylaniline**	ND	ND	ND	ND	ND	NA
x		**Acrolein**	ND	ND	ND	ND	ND	NA
		Other VOCs						
		1,2,4-Trimethylbenzene	1.04E-03	8.72E-04	7.74E-04	I	8.94E-04	1.33E-04
		Indene	4.72E-04	4.18E-04	4.23E-04	I	4.38E-04	2.95E-05
		Dodecane	4.12E-04	4.40E-04	2.68E-04	I	3.73E-04	9.24E-05
		1,2,3-Trimethylbenzene	4.16E-04	3.56E-04	3.17E-04	I	3.63E-04	5.03E-05
		2,4-Dimethylphenol	2.19E-04	2.95E-04	2.76E-04	I	2.64E-04	3.94E-05
		3-Ethyltoluene	2.86E-04	2.58E-04	2.22E-04	I	2.55E-04	3.22E-05

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

HAPs	POMs	Compound/Sample Number	FR001	FR002	FR003	FR004	Average	STDEV
		Test Dates	**1/15/04**	**1/15/04**	**1/16/04**	**1/16/04**		
		Other VOCs						
		1,3-Diethylbenzene	3.95E-04	3.25E-04	ND	I	2.40E-04	2.11E-04
		Undecane	1.89E-04	2.54E-04	2.08E-04	I	2.17E-04	3.34E-05
		2-Ethyltoluene	1.99E-04	1.98E-04	1.97E-04	I	1.98E-04	1.13E-06
		Propylbenzene	1.44E-04	1.85E-04	1.42E-04	I	1.57E-04	2.40E-05
		Tetradecane	1.19E-04	1.47E-04	1.74E-04	I	1.47E-04	2.79E-05
		Butyraldehyde/Methacrolein	9.17E-05	6.72E-05	5.53E-05	6.35E-05	6.94E-05	1.56E-05
		Benzaldehyde	4.86E-05	4.04E-05	3.04E-05	3.34E-05	3.82E-05	8.13E-06
		Heptane	ND	1.06E-04	ND	I	3.54E-05	6.14E-05
		Cyclohexane	ND	ND	ND	I	ND	NA
		Decane	ND	ND	ND	I	ND	NA
		2,6-Dimethylphenol	ND	ND	ND	I	ND	NA
		Indan	ND	ND	ND	I	ND	NA
		Nonane	ND	ND	ND	I	ND	NA
		Octane	ND	ND	ND	I	ND	NA
		1,3,5-Trimethylbenzene	ND	ND	ND	I	ND	NA
		Crotonaldehyde	ND	ND	ND	ND	ND	NA
		Hexaldehyde	ND	ND	ND	ND	ND	NA
		o,m,p-Tolualdehyde	ND	ND	ND	ND	ND	NA
		Pentanal	ND	ND	ND	ND	ND	NA
		Other Analytes						
		Acetone	2.78E-04	3.43E-04	3.00E-04	2.87E-04	3.02E-04	2.87E-05
		Carbon Dioxide	2.97E+00	NA	3.13E+00	2.89E+00	3.00E+00	1.22E-01
		Methane	3.52E-03	NA	6.18E-03	5.62E-03	5.11E-03	1.40E-03
		Carbon Monoxide	ND	NA	ND	ND	ND	NA
		Ethane	ND	NA	ND	ND	ND	NA
		Propane	ND	NA	ND	ND	ND	NA
		Isobutane	ND	NA	ND	ND	ND	NA
		Butane	ND	NA	ND	ND	ND	NA
		Neopentane	ND	NA	ND	ND	ND	NA
		Isopentane	ND	NA	ND	ND	ND	NA
		Pentane	ND	NA	ND	ND	ND	NA

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 FR Individual Emission Test Results – Lb/Tn Metal

HAPs	POMs	COMPOUND / SAMPLE NUMBER	FR001	FR002	FR003	FR004	Average	STDEV
		Test Dates	**1/15/04**	**1/15/04**	**1/16/04**	**1/16/04**		
		TGOC as Propane	9.52E-01	9.14E-01	9.71E-01	8.66E-01	9.26E-01	4.67E-02
		HC as Hexane	2.99E-01	3.28E-01	3.12E-01	2.68E-01	3.02E-01	2.53E-02
		Sum of VOCs	3.54E-01	3.78E-01	3.80E-01	I	3.71E-01	1.47E-02
		Sum of HAPs	3.29E-01	3.52E-01	3.61E-01	I	3.47E-01	1.65E-02
		Sum of POMs	9.03E-02	1.11E-01	1.17E-01	I	1.06E-01	1.38E-02
		Individual Organic HAPs						
x		**Benzene**	1.18E-01	9.36E-02	1.14E-01	I	1.09E-01	1.33E-02
x		**Phenol**	6.24E-02	8.11E-02	6.86E-02	I	7.07E-02	9.53E-03
x	z	**Naphthalene**	3.61E-02	4.02E-02	4.03E-02	I	3.89E-02	2.39E-03
x	z	**2-Methylnaphthalene**	2.90E-02	3.69E-02	3.88E-02	I	3.49E-02	5.22E-03
x	z	**1-Methylnaphthalene**	1.52E-02	1.95E-02	2.05E-02	I	1.84E-02	2.80E-03
x		**Toluene**	1.69E-02	1.48E-02	1.65E-02	I	1.61E-02	1.10E-03
x		**o-Cresol**	1.34E-02	1.73E-02	1.58E-02	I	1.55E-02	1.96E-03
x		**Aniline**	1.10E-02	1.47E-02	1.16E-02	1.46E-02	1.30E-02	1.93E-03
x	z	**1,3-Dimethylnaphthalene**	4.39E-03	5.90E-03	6.35E-03	I	5.55E-03	1.03E-03
x		**m,p-Xylene**	5.40E-03	5.07E-03	5.10E-03	I	5.19E-03	1.82E-04
x		**Acetaldehyde**	3.04E-03	3.79E-03	3.22E-03	3.62E-03	3.42E-03	3.46E-04
x		**m,p-Cresol**	2.58E-03	3.62E-03	3.30E-03	I	3.16E-03	5.34E-04
x	z	**1,6-Dimethylnaphthalene**	1.76E-03	2.36E-03	2.56E-03	I	2.23E-03	4.16E-04
x	z	**2,6-Dimethylnaphthalene**	1.57E-03	2.12E-03	2.30E-03	I	2.00E-03	3.83E-04
x	z	**2,7-Dimethylnaphthalene**	1.57E-03	2.12E-03	2.30E-03	I	2.00E-03	3.83E-04
x		**Styrene**	1.01E-03	3.20E-03	9.67E-04	I	1.72E-03	1.28E-03
x		**o-Xylene**	1.21E-03	1.18E-03	1.12E-03	I	1.17E-03	4.46E-05
x	z	**1,2-Dimethylnaphthalene**	7.61E-04	1.07E-03	1.14E-03	I	9.89E-04	2.01E-04
x		**Formaldehyde**	9.87E-04	7.23E-04	7.13E-04	6.84E-04	7.77E-04	1.41E-04
x	z	**2,3-Dimethylnaphthalene**	ND	3.43E-04	1.95E-03	I	7.64E-04	1.04E-03
x		**Biphenyl**	5.84E-04	7.78E-04	8.87E-04	I	7.50E-04	1.53E-04
x		**Ethylbenzene**	6.81E-04	8.20E-04	6.69E-04	I	7.23E-04	8.39E-05
x		**Hexane**	5.03E-04	6.28E-04	6.01E-04	I	5.77E-04	6.57E-05
x		**Propionaldehyde**	2.36E-04	2.35E-04	2.17E-04	2.40E-04	2.32E-04	1.01E-05
x		**2-Butanone**	2.41E-04	2.89E-04	2.13E-04	1.63E-04	2.27E-04	5.27E-05
x	z	**1,5-Dimethylnaphthalene**	ND	ND	6.06E-04	I	2.02E-04	3.50E-04
x	z	**1,8-Dimethylnaphthalene**	ND	ND	ND	I	ND	NA
x	z	**2,3,5-Trimethylnaphthalene**	ND	ND	ND	I	ND	NA
x	z	**Acenaphthalene**	ND	ND	ND	I	ND	NA
x		**Acrolein**	ND	ND	ND	ND	ND	NA
x		**N,N-Dimethylaniline**	ND	ND	ND	ND	ND	NA
		Other VOCs						
		1,2,4-Trimethylbenzene	6.35E-03	5.65E-03	4.79E-03	I	5.60E-03	7.81E-04
		Indene	2.89E-03	2.71E-03	2.62E-03	I	2.74E-03	1.38E-04
		Dodecane	2.52E-03	2.85E-03	1.66E-03	I	2.34E-03	6.16E-04
		1,2,3-Trimethylbenzene	2.55E-03	2.31E-03	1.96E-03	I	2.27E-03	2.97E-04
		2,4-Dimethylphenol	1.34E-03	1.91E-03	1.71E-03	I	1.66E-03	2.87E-04
		3-Ethyltoluene	1.75E-03	1.67E-03	1.37E-03	I	1.60E-03	1.99E-04

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

HAPs	POMs	COMPOUND / SAMPLE NUMBER	FR001	FR002	FR003	FR004	Average	STDEV
		Test Dates	**1/15/04**	**1/15/04**	**1/16/04**	**1/16/04**		
		Other VOCs						
		1,3-Diethylbenzene	2.42E-03	2.11E-03	ND	I	1.51E-03	1.32E-03
		Undecane	1.16E-03	1.64E-03	1.29E-03	I	1.36E-03	2.52E-04
		2-Ethyltoluene	1.22E-03	1.28E-03	1.22E-03	I	1.24E-03	3.66E-05
		n-Propylbenzene	8.81E-04	1.20E-03	8.81E-04	I	9.86E-04	1.81E-04
		Tetradecane	7.27E-04	9.50E-04	1.08E-03	I	9.19E-04	1.79E-04
		Butyraldehyde/Methacrolein	5.61E-04	4.35E-04	3.43E-04	3.95E-04	4.34E-04	9.31E-05
		Benzaldehyde	2.98E-04	2.62E-04	1.88E-04	2.08E-04	2.39E-04	5.01E-05
		Heptane	ND	6.89E-04	ND	I	2.30E-04	3.98E-04
		1,3,5-Trimethylbenzene	ND	ND	ND	I	ND	NA
		2,6-Dimethylphenol	ND	ND	ND	I	ND	NA
		Cyclohexane	ND	ND	ND	I	ND	NA
		Decane	ND	ND	ND	I	ND	NA
		Indan	ND	ND	ND	I	ND	NA
		Nonane	ND	ND	ND	I	ND	NA
		Octane	ND	ND	ND	I	ND	NA
		Crotonaldehyde	ND	ND	ND	ND	ND	NA
		Hexaldehyde	ND	ND	ND	ND	ND	NA
		Pentanal	ND	ND	ND	ND	ND	NA
		o,m,p-Tolualdehyde	ND	ND	ND	ND	ND	NA
		Other Analytes						
		Acetone	1.70E-03	2.22E-03	1.86E-03	1.79E-03	1.89E-03	2.27E-04
		Carbon Dioxide	1.82E+01	NA	1.94E+01	1.80E+01	1.85E+01	7.38E-01
		Methane	2.16E-02	NA	3.83E-02	3.50E-02	3.16E-02	8.87E-03
		Carbon Monoxide	ND	NA	ND	ND	ND	NA
		Ethane	ND	NA	ND	ND	ND	NA
		Propane	ND	NA	ND	ND	ND	NA
		Isobutane	ND	NA	ND	ND	ND	NA
		Butane	ND	NA	ND	ND	ND	NA
		Neopentane	ND	NA	ND	ND	ND	NA
		Isopentane	ND	NA	ND	ND	ND	NA
		Pentane	ND	NA	ND	ND	ND	NA

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 GG Individual Emission Test Results – Lb/Lb Binder

HAPs	POMs	COMPOUND / SAMPLE NUMBER	GG001	GG002	GG003	GG004	GG005	GG006	GG007	GG008	GG009	Average	STDEV
		Test Dates	**09/21/04**	**09/21/04**	**09/21/04**	**09/22/04**	**09/22/04**	**09/22/04**	**09/23/04**	**09/23/04**	**09/23/04**		
		TGOC as Propane	1.29E-01	1.31E-01	1.53E-01	1.33E-01	1.48E-01	1.50E-01	1.30E-01	1.58E-01	1.54E-01	1.43E-01	1.18E-02
		HC as Hexane	I	I	I	I	I	I	I	I	I	NA	NA
		Sum of Target Analytes	4.67E-02	4.99E-02	6.27E-02	5.11E-02	6.00E-02	5.99E-02	5.55E-02	6.71E-02	6.00E-02	5.70E-02	6.65E-03
		Sum of HAPs	4.29E-02	4.56E-02	5.72E-02	4.67E-02	5.53E-02	5.48E-02	5.11E-02	6.18E-02	5.52E-02	5.23E-02	6.15E-03
		Sum of POMs	1.26E-02	1.44E-02	1.71E-02	1.18E-02	1.47E-02	1.75E-02	1.48E-02	1.69E-02	1.68E-02	1.52E-02	2.06E-03
			Individual Organic HAPs										
x		**Phenol**	8.73E-03	1.01E-02	1.30E-02	9.31E-03	1.28E-02	1.37E-02	1.20E-02	1.48E-02	1.61E-02	1.23E-02	2.50E-03
x		**Benzene**	1.13E-02	9.39E-03	1.28E-02	1.38E-02	1.42E-02	9.25E-03	1.18E-02	1.44E-02	1.13E-02	1.20E-02	1.93E-03
x	z	**2-Methylnaphthalene**	4.42E-03	5.01E-03	5.99E-03	4.06E-03	5.15E-03	6.19E-03	5.19E-03	6.04E-03	6.02E-03	5.34E-03	7.70E-04
x	z	**Naphthalene**	3.83E-03	4.28E-03	5.00E-03	3.52E-03	4.27E-03	4.80E-03	4.06E-03	4.54E-03	4.44E-03	4.30E-03	4.63E-04
x		**o-Cresol**	2.73E-03	3.23E-03	4.12E-03	2.77E-03	3.80E-03	4.24E-03	3.57E-03	4.50E-03	4.75E-03	3.75E-03	7.29E-04
x		**Aniline**	2.45E-03	2.35E-03	2.96E-03	2.27E-03	3.36E-03	3.26E-03	2.81E-03	4.04E-03	I	2.94E-03	6.01E-04
x	z	**1-Methylnaphthalene**	2.29E-03	2.62E-03	3.10E-03	2.10E-03	2.65E-03	3.22E-03	2.73E-03	3.11E-03	3.12E-03	2.77E-03	3.98E-04
x		**Toluene**	2.19E-03	2.65E-03	2.93E-03	2.71E-03	2.65E-03	2.69E-03	2.42E-03	2.69E-03	2.24E-03	2.58E-03	2.42E-04
x		**m,p-Xylene**	8.42E-04	9.22E-04	1.21E-03	1.16E-03	1.03E-03	1.01E-03	9.41E-04	1.06E-03	8.61E-04	1.01E-03	1.28E-04
x	z	**1,3-Dimethylnaphthalene**	7.53E-04	8.63E-04	1.05E-03	7.42E-04	9.13E-04	1.15E-03	1.01E-03	1.12E-03	1.15E-03	9.72E-04	1.62E-04
x		**m,p-Cresol**	5.86E-04	7.07E-04	9.72E-04	6.49E-04	8.62E-04	1.04E-03	9.49E-04	1.16E-03	1.17E-03	9.00E-04	2.15E-04
x		**Acetaldehyde**	7.48E-04	7.83E-04	8.59E-04	8.00E-04	8.39E-04	8.49E-04	9.10E-04	9.24E-04	8.89E-04	8.45E-04	5.92E-05
x	z	**1,6-Dimethylnaphthalene**	3.18E-04	3.62E-04	4.37E-04	3.08E-04	3.80E-04	4.80E-04	4.14E-04	4.65E-04	4.72E-04	4.04E-04	6.54E-05
x	z	**2,7-Dimethylnaphthalene**	2.89E-04	3.90E-04	4.03E-04	2.80E-04	3.52E-04	5.37E-04	3.76E-04	4.89E-04	4.93E-04	4.01E-04	9.02E-05
x	z	**2,6-Dimethylnaphthalene**	2.89E-04	2.81E-04	4.03E-04	2.80E-04	3.52E-04	3.75E-04	3.76E-04	3.98E-04	4.10E-04	3.52E-04	5.39E-05
x	z	**2,3-Dimethylnaphthalene**	2.83E-04	3.05E-04	3.85E-04	2.74E-04	3.36E-04	4.03E-04	3.50E-04	4.06E-04	4.00E-04	3.49E-04	5.28E-05
x		**Hexane**	I	2.84E-04	2.12E-04	4.77E-04	2.13E-04	2.47E-04	1.24E-04	3.66E-04	1.33E-04	2.57E-04	1.18E-04
x		**o-Xylene**	1.93E-04	2.03E-04	2.84E-04	2.58E-04	2.37E-04	2.31E-04	2.13E-04	2.24E-04	1.99E-04	2.27E-04	2.96E-05
x	z	**1,2-Dimethylnaphthalene**	1.48E-04	1.64E-04	2.06E-04	1.44E-04	1.77E-04	2.27E-04	1.94E-04	2.14E-04	2.21E-04	1.88E-04	3.13E-05
x		**Ethylbenzene**	1.27E-04	1.38E-04	1.92E-04	1.74E-04	1.64E-04	1.59E-04	1.55E-04	1.55E-04	1.41E-04	1.56E-04	1.96E-05
x		**Styrene**	1.22E-04	1.41E-04	1.58E-04	1.38E-04	1.30E-04	1.36E-04	1.10E-04	1.41E-04	1.23E-04	1.33E-04	1.39E-05
x		**Formaldehyde**	1.28E-04	1.22E-04	1.24E-04	1.32E-04	1.11E-04	1.19E-04	I	1.19E-04	1.19E-04	1.22E-04	6.64E-06
x		**Biphenyl**	I	1.02E-04	1.22E-04	8.62E-05	1.12E-04	1.38E-04	1.23E-04	1.42E-04	1.44E-04	1.21E-04	2.05E-05
x	z	**1,5-Dimethylnaphthalene**	I	9.56E-05	1.18E-04	8.62E-05	1.02E-04	1.33E-04	1.08E-04	1.24E-04	1.28E-04	1.12E-04	1.65E-05
x		**2-Butanone**	7.00E-05	7.31E-05	8.14E-05	8.08E-05	8.51E-05	8.55E-05	8.29E-05	9.98E-05	9.00E-05	8.32E-05	8.78E-06

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

HAPs	POMs	COMPOUND / SAMPLE NUMBER	GG001	GG002	GG003	GG004	GG005	GG006	GG007	GG008	GG009	Average	STDEV
		Test Dates	**09/21/04**	**09/21/04**	**09/21/04**	**09/22/04**	**09/22/04**	**09/22/04**	**09/23/04**	**09/23/04**	**09/23/04**		
x		**Propionaldehyde**	4.23E-05	4.52E-05	5.93E-05	5.89E-05	6.14E-05	6.30E-05	6.16E-05	6.56E-05	6.88E-05	5.85E-05	8.90E-06
x		**Acrolein**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
x		**N,N-Dimethylaniline**	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
x	z	**Acenaphthalene**	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
			Other VOCs										
		1,2,4-Trimethylbenzene	9.33E-04	1.03E-03	1.22E-03	1.06E-03	1.03E-03	1.05E-03	8.99E-04	1.06E-03	9.26E-04	1.02E-03	9.61E-05
		2,6-Dimethylphenol	5.50E-04	6.42E-04	8.87E-04	5.34E-04	6.57E-04	7.55E-04	6.12E-04	8.06E-04	7.99E-04	6.94E-04	1.23E-04
		2,4-Dimethylphenol	4.56E-04	5.75E-04	7.53E-04	4.10E-04	6.00E-04	7.14E-04	6.27E-04	7.92E-04	8.21E-04	6.39E-04	1.44E-04
		3-Ethyltoluene	4.53E-04	5.08E-04	5.94E-04	5.22E-04	4.95E-04	5.25E-04	4.47E-04	5.21E-04	5.01E-04	5.07E-04	4.33E-05
		Indene	3.55E-04	4.03E-04	4.65E-04	3.88E-04	3.94E-04	4.21E-04	3.59E-04	4.36E-04	3.83E-04	4.01E-04	3.58E-05
		1,2,3-Trimethylbenzene	2.83E-04	3.13E-04	3.77E-04	3.30E-04	3.28E-04	3.35E-04	3.18E-04	3.49E-04	2.99E-04	3.26E-04	2.74E-05
		Propylbenzene	1.39E-04	1.62E-04	2.33E-04	1.83E-04	2.18E-04	2.37E-04	2.26E-04	2.97E-04	1.48E-04	2.05E-04	5.11E-05
		Dodecane	1.99E-04	1.94E-04	2.29E-04	1.92E-04	1.97E-04	2.05E-04	2.09E-04	2.10E-04	2.02E-04	2.04E-04	1.12E-05
		Heptane	1.41E-04	1.58E-04	3.11E-04	2.82E-04	2.45E-04	2.19E-04	1.42E-04	1.60E-04	1.40E-04	2.00E-04	6.64E-05
		2-Ethyltoluene	ND	ND	1.22E-04	2.19E-04	2.22E-04	2.47E-04	2.05E-04	2.45E-04	2.42E-04	1.67E-04	1.02E-04
		Tetradecane	1.04E-04	1.38E-04	1.56E-04	1.08E-04	1.31E-04	1.64E-04	1.37E-04	1.60E-04	1.50E-04	1.39E-04	2.14E-05
		Butyraldehyde/Methacrolein	7.12E-05	7.37E-05	8.42E-05	7.28E-05	8.51E-05	8.55E-05	8.64E-05	9.87E-05	9.62E-05	8.37E-05	9.79E-06
		Benzaldehyde	3.86E-05	3.82E-05	4.25E-05	4.36E-05	4.28E-05	4.39E-05	4.80E-05	4.84E-05	4.80E-05	4.38E-05	3.86E-06
		Undecane	3.97E-05	4.28E-05	5.08E-05	4.07E-05	4.38E-05	4.66E-05	4.34E-05	4.65E-05	3.93E-05	4.37E-05	3.72E-06
		Pentanal	1.94E-05	2.13E-05	2.54E-05	2.26E-05	2.54E-05	2.69E-05	2.52E-05	3.00E-05	3.10E-05	2.52E-05	3.80E-06
		Hexaldehyde	ND	ND	1.91E-05	1.84E-05	1.89E-05	2.00E-05	1.90E-05	2.32E-05	2.33E-05	1.58E-05	9.11E-06
		Crotonaldehyde	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		o,m,p-Tolualdehyde	ND	ND	ND	ND	ND	ND	ND	ND	I	ND	NA
		Cyclohexane	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		Decane	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		1,3-Diethylbenzene	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		Indan	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		Nonane	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		Octane	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		1,3,5-Trimethylbenzene	ND	ND	ND	I	ND	ND	ND	ND	ND	ND	NA

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

HAPs	POMs	COMPOUND / SAMPLE NUMBER	GG001	GG002	GG003	GG004	GG005	GG006	GG007	GG008	GG009	Average	STDEV
		Test Dates	09/21/04	09/21/04	09/21/04	09/22/04	09/22/04	09/22/04	09/23/04	09/23/04	09/23/04		
			Other Analytes										
		Acetone	2.90E-04	3.12E-04	I	4.42E-04	4.01E-04	4.30E-04	4.17E-04	4.70E-04	4.49E-04	4.01E-04	6.55E-05
		Carbon Dioxide	6.92E-01	6.65E-01	6.47E-01	7.49E-01	6.65E-01	6.13E-01	6.70E-01	6.42E-01	7.69E-01	6.79E-01	5.04E-02
		Carbon Monoxide	2.15E-01	2.36E-01	2.45E-01	2.47E-01	2.52E-01	2.52E-01	2.72E-01	2.83E-01	2.68E-01	2.52E-01	2.04E-02
		Nitrogen Oxides	1.32E-03	1.08E-03	1.14E-03	1.40E-03	1.08E-03	1.10E-03	1.34E-03	1.07E-03	1.26E-03	1.20E-03	1.30E-04

I: Data rejected based on data validation considerations.

ND: Non Detect; NA: Not Applicable

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

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

HAPs	POMs	COMPOUND / SAMPLE NUMBER	GG001	GG002	GG003	GG004	GG005	GG006	GG007	GG008	GG009	Average	STDEV
		Test Dates	**09/21/04**	**09/21/04**	**09/21/04**	**09/22/04**	**09/22/04**	**09/22/04**	**09/23/04**	**09/23/04**	**09/23/04**		
		TGOC as Propane	8.96E-01	8.94E-01	1.06E+00	9.28E-01	1.04E+00	1.06E+00	9.08E-01	1.09E+00	1.08E+00	9.96E-01	8.67E-02
		HC as Hexane	I	I	I	I	I	I	I	I	I	NA	NA
		Sum of Target Analytes	3.25E-01	3.40E-01	4.32E-01	3.58E-01	4.24E-01	4.24E-01	3.87E-01	4.65E-01	4.22E-01	3.98E-01	4.75E-02
		Sum of HAPs	2.98E-01	3.11E-01	3.94E-01	3.27E-01	3.91E-01	3.88E-01	3.57E-01	4.29E-01	3.88E-01	3.65E-01	4.40E-02
		Sum of POMs	8.78E-02	9.79E-02	1.18E-01	8.26E-02	1.04E-01	1.24E-01	1.03E-01	1.17E-01	1.19E-01	1.06E-01	1.46E-02
			Individual Organic HAPs										
x		**Phenol**	6.08E-02	6.86E-02	8.93E-02	6.51E-02	9.04E-02	9.74E-02	8.38E-02	1.03E-01	1.13E-01	8.57E-02	1.79E-02
x		**Benzene**	7.87E-02	6.40E-02	8.84E-02	9.68E-02	1.00E-01	6.55E-02	8.26E-02	9.97E-02	7.95E-02	8.39E-02	1.36E-02
x	z	**2-Methylnaphthalene**	3.08E-02	3.41E-02	4.13E-02	2.84E-02	3.64E-02	4.38E-02	3.62E-02	4.19E-02	4.24E-02	3.73E-02	5.46E-03
x		**o-Cresol**	1.90E-02	2.20E-02	2.84E-02	1.94E-02	2.68E-02	3.00E-02	2.49E-02	3.13E-02	3.34E-02	2.61E-02	5.18E-03
x		**Aniline**	1.70E-02	1.60E-02	2.04E-02	1.59E-02	2.37E-02	2.31E-02	1.96E-02	2.80E-02	I	2.05E-02	4.26E-03
x	z	**Naphthalene**	2.66E-02	2.92E-02	3.45E-02	2.46E-02	3.01E-02	3.40E-02	2.83E-02	3.15E-02	3.12E-02	3.00E-02	3.23E-03
x	z	**1-Methylnaphthalene**	1.59E-02	1.79E-02	2.14E-02	1.47E-02	1.87E-02	2.28E-02	1.90E-02	2.16E-02	2.20E-02	1.93E-02	2.82E-03
x		**Toluene**	1.53E-02	1.80E-02	2.02E-02	1.90E-02	1.87E-02	1.91E-02	1.69E-02	1.87E-02	1.58E-02	1.80E-02	1.65E-03
x		**m,p-Cresol**	4.08E-03	4.81E-03	6.70E-03	4.54E-03	6.09E-03	7.36E-03	6.62E-03	8.07E-03	8.23E-03	6.28E-03	1.52E-03
x	z	**1,3-Dimethylnaphthalene**	5.24E-03	5.88E-03	7.23E-03	5.19E-03	6.45E-03	8.17E-03	7.03E-03	7.78E-03	8.06E-03	6.78E-03	1.15E-03
x		**m,p-Xylene**	5.86E-03	6.28E-03	8.37E-03	8.13E-03	7.29E-03	7.19E-03	6.56E-03	7.38E-03	6.06E-03	7.01E-03	8.87E-04
x		**Hexane**	I	1.94E-03	1.46E-03	3.34E-03	1.51E-03	1.75E-03	8.67E-04	2.54E-03	9.38E-04	1.79E-03	8.24E-04
x	z	**2,7-Dimethylnaphthalene**	2.01E-03	2.66E-03	2.78E-03	1.96E-03	2.49E-03	3.80E-03	2.62E-03	3.40E-03	3.47E-03	2.80E-03	6.40E-04
x	z	**1,6-Dimethylnaphthalene**	2.22E-03	2.47E-03	3.01E-03	2.16E-03	2.69E-03	3.40E-03	2.89E-03	3.23E-03	3.32E-03	2.82E-03	4.67E-04
x		**Acetaldehyde**	5.20E-03	5.33E-03	5.92E-03	5.60E-03	5.93E-03	6.01E-03	6.34E-03	6.41E-03	6.26E-03	5.89E-03	4.32E-04
x	z	**2,6-Dimethylnaphthalene**	2.01E-03	1.91E-03	2.78E-03	1.96E-03	2.49E-03	2.65E-03	2.62E-03	2.76E-03	2.88E-03	2.45E-03	3.84E-04
x	z	**2,3-Dimethylnaphthalene**	1.97E-03	2.08E-03	2.65E-03	1.92E-03	2.37E-03	2.86E-03	2.44E-03	2.82E-03	2.81E-03	2.44E-03	3.77E-04
x	z	**1,2-Dimethylnaphthalene**	1.03E-03	1.12E-03	1.42E-03	1.01E-03	1.25E-03	1.61E-03	1.35E-03	1.49E-03	1.55E-03	1.31E-03	2.24E-04
x		**o-Xylene**	1.34E-03	1.38E-03	1.96E-03	1.80E-03	1.68E-03	1.63E-03	1.49E-03	1.55E-03	1.40E-03	1.58E-03	2.07E-04
x		**Biphenyl**	I	6.92E-04	8.42E-04	6.04E-04	7.89E-04	9.79E-04	8.55E-04	9.86E-04	1.01E-03	8.45E-04	1.47E-04
x		**Ethylbenzene**	8.82E-04	9.40E-04	1.32E-03	1.22E-03	1.16E-03	1.12E-03	1.08E-03	1.07E-03	9.95E-04	1.09E-03	1.38E-04
x	z	**1,5-Dimethylnaphthalene**	I	6.51E-04	8.14E-04	6.04E-04	7.17E-04	9.39E-04	7.56E-04	8.59E-04	8.98E-04	7.80E-04	1.19E-04
x		**Styrene**	8.52E-04	9.63E-04	1.09E-03	9.68E-04	9.16E-04	9.62E-04	7.67E-04	9.80E-04	8.63E-04	9.29E-04	9.22E-05
x		**Propionaldehyde**	2.95E-04	3.08E-04	4.09E-04	4.12E-04	4.33E-04	4.46E-04	4.30E-04	4.55E-04	4.84E-04	4.08E-04	6.47E-05
x		**2-Butanone**	4.88E-04	4.98E-04	5.61E-04	5.66E-04	6.01E-04	6.05E-04	5.78E-04	6.92E-04	6.33E-04	5.80E-04	6.37E-05

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

HAPs	POMs	COMPOUND / SAMPLE NUMBER	GG001	GG002	GG003	GG004	GG005	GG006	GG007	GG008	GG009	Average	STDEV
		Test Dates	**09/21/04**	**09/21/04**	**09/21/04**	**09/22/04**	**09/22/04**	**09/22/04**	**09/23/04**	**09/23/04**	**09/23/04**		
x		**Formaldehyde**	8.93E-04	8.30E-04	8.53E-04	9.25E-04	7.81E-04	8.40E-04	I	8.23E-04	8.34E-04	8.47E-04	4.42E-05
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	z	**Acenaphthalene**	ND	ND	ND	ND	ND	ND	ND	ND	ND	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										
		2,4-Dimethylphenol	3.18E-03	3.92E-03	5.19E-03	2.87E-03	4.24E-03	5.06E-03	4.37E-03	5.49E-03	5.77E-03	4.46E-03	1.01E-03
		2,6-Dimethylphenol	3.83E-03	4.37E-03	6.11E-03	3.74E-03	4.64E-03	5.35E-03	4.27E-03	5.59E-03	5.62E-03	4.84E-03	8.57E-04
		2-Ethyltoluene	ND	ND	8.40E-04	1.54E-03	1.57E-03	1.75E-03	1.43E-03	1.70E-03	1.70E-03	1.17E-03	7.17E-04
		1,2,4-Trimethylbenzene	6.50E-03	7.03E-03	8.40E-03	7.41E-03	7.29E-03	7.42E-03	6.27E-03	7.32E-03	6.52E-03	7.13E-03	6.49E-04
		Heptane	9.83E-04	1.08E-03	2.15E-03	1.97E-03	1.73E-03	1.55E-03	9.90E-04	1.11E-03	9.83E-04	1.39E-03	4.64E-04
		n-Propylbenzene	9.65E-04	1.11E-03	1.61E-03	1.28E-03	1.54E-03	1.68E-03	1.58E-03	2.06E-03	1.04E-03	1.43E-03	3.58E-04
		3-Ethyltoluene	3.15E-03	3.46E-03	4.09E-03	3.65E-03	3.50E-03	3.71E-03	3.12E-03	3.61E-03	3.52E-03	3.54E-03	2.95E-04
		Indene	2.47E-03	2.74E-03	3.21E-03	2.71E-03	2.78E-03	2.98E-03	2.50E-03	3.03E-03	2.69E-03	2.79E-03	2.43E-04
		1,2,3-Trimethylbenzene	1.97E-03	2.13E-03	2.60E-03	2.31E-03	2.31E-03	2.37E-03	2.22E-03	2.42E-03	2.10E-03	2.27E-03	1.88E-04
		Tetradecane	7.27E-04	9.40E-04	1.08E-03	7.59E-04	9.22E-04	1.16E-03	9.55E-04	1.11E-03	1.05E-03	9.67E-04	1.50E-04
		Butyraldehyde/Methacrolein	4.96E-04	5.02E-04	5.81E-04	5.10E-04	6.01E-04	6.05E-04	6.02E-04	6.85E-04	6.77E-04	5.84E-04	7.06E-05
		Hexaldehyde	ND	ND	1.32E-04	1.29E-04	1.33E-04	1.41E-04	1.32E-04	1.61E-04	1.64E-04	1.10E-04	6.38E-05
		Dodecane	1.38E-03	1.32E-03	1.49E-03	1.34E-03	1.39E-03	1.45E-03	1.46E-03	1.46E-03	1.42E-03	1.41E-03	5.66E-05
		Benzaldehyde	2.68E-04	2.60E-04	2.93E-04	3.05E-04	3.02E-04	3.11E-04	3.35E-04	3.36E-04	3.38E-04	3.05E-04	2.85E-05
		Pentanal	1.35E-04	1.45E-04	1.75E-04	1.58E-04	1.79E-04	1.90E-04	1.75E-04	2.08E-04	2.18E-04	1.76E-04	2.74E-05
		Undecane	2.77E-04	2.92E-04	3.28E-04	2.85E-04	3.09E-04	3.30E-04	3.03E-04	3.23E-04	2.77E-04	3.03E-04	2.13E-05
		1,3,5-Trimethylbenzene	ND	ND	ND	I	ND	ND	ND	ND	ND	ND	NA
		1,3-Diethylbenzene	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		Cyclohexane	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		Decane	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		Indan	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		Nonane	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		Octane	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		Crotonaldehyde	ND	ND	ND	ND	ND	ND	ND	ND	ND	ND	NA
		o,m,p-Tolualdehyde	ND	ND	ND	ND	ND	ND	ND	ND	I	ND	NA

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

HAPs	POMs	COMPOUND / SAMPLE NUMBER	GG001	GG002	GG003	GG004	GG005	GG006	GG007	GG008	GG009	Average	STDEV
		Test Dates	**09/21/04**	**09/21/04**	**09/21/04**	**09/22/04**	**09/22/04**	**09/22/04**	**09/23/04**	**09/23/04**	**09/23/04**		
			Other Analytes										
		Acetone	2.02E-03	2.13E-03	I	3.10E-03	2.83E-03	3.04E-03	2.91E-03	3.26E-03	3.16E-03	2.81E-03	4.72E-04
		Carbon Dioxide	4.81E+00	4.53E+00	4.46E+00	5.24E+00	4.70E+00	4.34E+00	4.67E+00	4.45E+00	5.41E+00	4.73E+00	3.66E-01
		Carbon Monoxide	1.49E+00	1.61E+00	1.69E+00	1.73E+00	1.78E+00	1.79E+00	1.89E+00	1.96E+00	1.89E+00	1.76E+00	1.48E-01
		Nitrogen Oxides	9.16E-03	7.38E-03	7.87E-03	9.80E-03	7.65E-03	7.77E-03	9.32E-03	7.42E-03	8.88E-03	8.36E-03	9.26E-04

I: Data rejected based on data validation considerations.

ND: Non Detect; NA: Not Applicable

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

Test Plan T-Statistics – Lb/Lb Binder

Analytes	Test FR Lb/Lb Binder	Test GG Lb/Lb Binder	T-Statistic
TGOC as Propane	0.1480	0.1428	0.85
HC as Hexane	0.0482	NA	NA
Sum of Target Analytes	0.0591	0.0570	0.87
Sum of HAPs	0.0554	0.0523	1.30
Sum of POMs	0.0169	0.0152	1.35
Individual Organic HAPs			
Benzene	0.0174	0.0120	3.73
Phenol	0.0113	0.0123	-0.97
Methylnaphthalenes	0.0085	0.0081	0.55
Naphthalene	0.0062	0.0043	8.47
o,m,p-Cresol	0.0030	0.0046	-4.77
Toluene	0.0026	0.0026	0.00
Dimethylnaphthalenes	0.0022	0.0028	-1.75
Aniline	0.0021	0.0029	-3.20
o,m,p-Xylene	0.0010	0.0012	-2.40
Acetaldehyde	0.0005	0.0008	-9.00
Other VOCs			
Trimethylbenzenes	0.0013	0.0013	0.00
Ethyltoluenes	0.0005	0.0007	-6.00
Dimethylphenols	0.0003	0.0013	-10.00
Other Analytes			
Carbon Dioxide	2.996	0.6789	36.76
Carbon Monoxide	ND	0.2521	-37.07
Nitrogen Oxides	NT	0.0012	NA

Individual results constitute >95% of mass of all detected target analytes.

ND: Non Detect; NA: Not Applicable; NT: Not Tested

Test Plan T-Statistics – Lb/Tn Metal

Analytes	Test FR Lb/Tn Metal	Test GG Lb/Tn Metal	T-Statistic
TGOC as Propane	0.9259	0.9960	-1.89
HC as Hexane	0.3016	NA	NA
Sum of Target Analytes	0.3705	0.3975	-1.55
Sum of HAPs	0.3474	0.3647	-1.03
Sum of POMs	0.1059	0.1059	0.00
Individual Organic HAPs			
Benzene	0.1088	0.0839	3.09
Phenol	0.0707	0.0857	-1.97
Methylnaphthalenes	0.0533	0.0566	-0.68
Naphthalene	0.0389	0.0300	5.54
o,m,p-Cresol	0.0187	0.0324	-5.35
Toluene	0.0161	0.0180	-2.48
Dimethylnaphthalenes	0.0137	0.0193	-2.63
Aniline	0.0130	0.0205	-4.36
o,m,p-Xylene	0.0064	0.0086	-5.79
Acetaldehyde	0.0034	0.0059	-12.46
Other VOCs			
Trimethylbenzenes	0.0079	0.0094	-2.45
Ethyltoluenes	0.0028	0.0047	-6.67
Dimethylphenols	0.0017	0.0093	-12.29
Other Analytes			
Carbon Dioxide	18.53	4.735	35.50
Carbon Monoxide	ND	1.758	-35.52
Nitrogen Oxides	NT	0.0084	NA

Individual results constitute >95% of mass of all detected target analytes.

ND: Non Detect; NA: Not Applicable

Test FR Quantitation Limits – Lb/Lb Binder

Analytes	Lb/Lb Binder
1,2,3-Trimethylbenzene	1.87E-05
1,2,4-Trimethylbenzene	1.87E-05
1,3,5-Trimethylbenzene	1.87E-05
1,3-Dimethylnaphthalene	1.87E-05
1-Methylnaphthalene	1.87E-05
2-Ethyltoluene	1.87E-05
2-Methylnaphthalene	1.87E-05
Benzene	1.87E-05
Ethylbenzene	1.87E-05
Hexane	1.87E-05
m,p-Xylene	1.87E-05
Naphthalene	1.87E-05
o-Xylene	1.87E-05
Styrene	1.87E-05
Toluene	1.87E-05
Undecane	1.87E-05
1,2-Dimethylnaphthalene	9.33E-05
1,3-Diethylbenzene	9.33E-05
1,5-Dimethylnaphthalene	9.33E-05
1,6-Dimethylnaphthalene	9.33E-05
1,8-Dimethylnaphthalene	9.33E-05
2,3,5-Trimethylnaphthalene	9.33E-05
2,3-Dimethylnaphthalene	9.33E-05
2,4-Dimethylphenol	9.33E-05

Analytes	Lb/Lb Binder
2,6-Dimethylnaphthalene	9.33E-05
2,6-Dimethylphenol	9.33E-05
2,7- Dimethylnaphthalene	9.33E-05
3-Ethyltoluene	9.33E-05
Acenaphthalene	9.33E-05
Biphenyl	9.33E-05
Cyclohexane	9.33E-05
Decane	9.33E-05
Dodecane	9.33E-05
Heptane	9.33E-05
Indan	9.33E-05
Indene	9.33E-05
m,p-Cresol	9.33E-05
Nonane	9.33E-05
o-Cresol	9.33E-05
Octane	9.33E-05
Phenol	9.33E-05
Propylbenzene	9.33E-05
Tetradecane	9.33E-05
HC as Hexane	5.65E-04
2-Butanone (MEK)	1.67E-05
Acetaldehyde	1.67E-05
Acetone	1.67E-05
Acrolein	1.67E-05

Analytes	Lb/Lb Binder
Benzaldehyde	1.67E-05
Butyraldehyde	1.67E-05
Crotonaldehyde	1.67E-05
Formaldehyde	1.67E-05
Hexaldehyde	1.67E-05
Butyraldehyde/Methacrolein	2.78E-05
o,m,p-Tolualdehyde	4.45E-05
Pentanal (Valeraldehyde)	1.67E-05
Propionaldehyde (Propanal)	1.67E-05
Aniline	1.12E-04
Dimethylaniline	1.12E-04
Carbon Monoxide	4.40E-02
Methane	2.51E-03
Carbon Dioxide	6.91E-02
Ethane	4.71E-02
Propane	6.91E-02
Isobutane	9.11E-02
Butane	9.11E-02
Neopentane	1.13E-01
Isopentane	1.13E-01
Pentane	1.13E-01

Test FR Quantitation Limits – Lb/Tn Metal

Analytes	Lb/Tn Metal
1,2,3-Trimethylbenzene	6.42E-03
1,2,4-Trimethylbenzene	6.42E-03
1,3,5-Trimethylbenzene	6.42E-03
1,3-Dimethylnaphthalene	6.42E-03
1-Methylnaphthalene	6.42E-03
2-Ethyltoluene	6.42E-03
2-Methylnaphthalene	6.42E-03
Benzene	6.42E-03
Ethylbenzene	6.42E-03
Hexane	6.42E-03
m,p-Xylene	6.42E-03
Naphthalene	6.42E-03
o-Xylene	6.42E-03
Styrene	6.42E-03
Toluene	6.42E-03
Undecane	6.42E-03
1,2-Dimethylnaphthalene	3.21E-02
1,3-Diethylbenzene	3.21E-02
1,5-Dimethylnaphthalene	3.21E-02
1,6-Dimethylnaphthalene	3.21E-02
1,8-Dimethylnaphthalene	3.21E-02
2,3,5-Trimethylnaphthalene	3.21E-02
2,3-Dimethylnaphthalene	3.21E-02
2,4-Dimethylphenol	3.21E-02

Analytes	Lb/Tn Metal
2,6-Dimethylnaphthalene	3.21E-02
2,6-Dimethylphenol	3.21E-02
2,7- Dimethylnaphthalene	3.21E-02
3-Ethyltoluene	3.21E-02
Acenaphthalene	3.21E-02
Biphenyl	3.21E-02
Cyclohexane	3.21E-02
Decane	3.21E-02
Dodecane	3.21E-02
Heptane	3.21E-02
Indan	3.21E-02
Indene	3.21E-02
m,p-Cresol	3.21E-02
Nonane	3.21E-02
o-Cresol	3.21E-02
Octane	3.21E-02
Phenol	3.21E-02
Propylbenzene	3.21E-02
Tetradecane	3.21E-02
HC as Hexane	3.54E-03
2-Butanone (MEK)	1.05E-04
Acetaldehyde	1.05E-04
Acetone	1.05E-04
Acrolein	1.05E-04

Analytes	Lb/Tn Metal
Benzaldehyde	1.05E-04
Butyraldehyde	1.05E-04
Crotonaldehyde	1.05E-04
Formaldehyde	1.05E-04
Hexaldehyde	1.05E-04
Butyraldehyde/Methacrolein	1.74E-04
o,m,p-Tolualdehyde	2.79E-04
Pentanal (Valeraldehyde)	1.05E-04
Propionaldehyde (Propanal)	1.05E-04
Aniline	7.04E-04
Dimethylaniline	7.04E-04
Carbon Monoxide	2.76E-01
Methane	1.58E-02
Carbon Dioxide	4.33E-01
Ethane	4.18E-02
Propane	4.33E-01
Isobutane	5.71E-01
Butane	5.71E-01
Neopentane	7.09E-01
Isopentane	7.09E-01
Pentane	7.09E-01

Test GG Quantitation Limits – Lb/Lb Binder

Analytes	Lb/Lb Binder
1,2,3-Trimethylbenzene	1.67E-05
1,2,4-Trimethylbenzene	1.67E-05
1,3,5-Trimethylbenzene	1.67E-05
1,3-Dimethylnaphthalene	1.67E-05
1-Methylnaphthalene	1.67E-05
2-Ethyltoluene	1.67E-05
2-Methylnaphthalene	1.67E-05
Benzene	1.67E-05
Ethylbenzene	1.67E-05
Hexane	1.67E-05
m,p-Xylene	1.67E-05
Naphthalene	1.67E-05
o-Xylene	1.67E-05
Styrene	1.67E-05
Toluene	1.67E-05
Undecane	1.67E-05
1,2-Dimethylnaphthalene	8.37E-05
1,3-Diethylbenzene	8.37E-05
1,5-Dimethylnaphthalene	8.37E-05
1,6-Dimethylnaphthalene	8.37E-05
1,8-Dimethylnaphthalene	8.37E-05

Analytes	Lb/Lb Binder
2,3,5-Trimethylnaphthalene	8.37E-05
2,3-Dimethylnaphthalene	8.37E-05
2,4-Dimethylphenol	8.37E-05
2,6-Dimethylnaphthalene	8.37E-05
2,6-Dimethylphenol	8.37E-05
2,7- Dimethylnaphthalene	8.37E-05
3-Ethyltoluene	8.37E-05
Acenaphthalene	8.37E-05
Biphenyl	8.37E-05
Cyclohexane	8.37E-05
Decane	8.37E-05
Dodecane	8.37E-05
Heptane	8.37E-05
Indan	8.37E-05
Indene	8.37E-05
m,p-Cresol	8.37E-05
Nonane	8.37E-05
o-Cresol	8.37E-05
Octane	8.37E-05
Phenol	8.37E-05
Propylbenzene	8.37E-05

Analytes	Lb/Lb Binder
Tetradecane	8.37E-05
HC as Hexane	5.44E-04
2-Butanone (MEK)	1.72E-05
Acetaldehyde	1.72E-05
Acetone	1.72E-05
Acrolein	1.72E-05
Benzaldehyde	1.72E-05
Butyraldehyde	1.72E-05
Crotonaldehyde	1.72E-05
Formaldehyde	1.72E-05
Hexaldehyde	1.72E-05
Butyraldehyde/Methacrolein	2.87E-05
o,m,p-Tolualdehyde	4.59E-05
Pentanal (Valeraldehyde)	1.72E-05
Propionaldehyde (Propanal)	1.72E-05
Aniline	1.08E-04
Dimethylaniline	2.16E-04
Carbon Monoxide	4.01E-03
Carbon Dioxide	6.30E-03
Nitrogen Oxides	4.29E-03

Test GG Quantitation Limits – Lb/Tn Metal

Analytes	Lb/Tn Metal
1,2,3-Trimethylbenzene	1.17E-04
1,2,4-Trimethylbenzene	1.17E-04
1,3,5-Trimethylbenzene	1.17E-04
1,3-Dimethylnaphthalene	1.17E-04
1-Methylnaphthalene	1.17E-04
2-Ethyltoluene	1.17E-04
2-Methylnaphthalene	1.17E-04
Benzene	1.17E-04
Ethylbenzene	1.17E-04
Hexane	1.17E-04
m,p-Xylene	1.17E-04
Naphthalene	1.17E-04
o-Xylene	1.17E-04
Styrene	1.17E-04
Toluene	1.17E-04
Undecane	1.17E-04
1,2-Dimethylnaphthalene	5.84E-04
1,3-Diethylbenzene	5.84E-04
1,5-Dimethylnaphthalene	5.84E-04
1,6-Dimethylnaphthalene	5.84E-04
1,8-Dimethylnaphthalene	5.84E-04

Analytes	Lb/Tn Metal
2,3,5-Trimethylnaphthalene	5.84E-04
2,3-Dimethylnaphthalene	5.84E-04
2,4-Dimethylphenol	5.84E-04
2,6-Dimethylnaphthalene	5.84E-04
2,6-Dimethylphenol	5.84E-04
2,7- Dimethylnaphthalene	5.84E-04
3-Ethyltoluene	5.84E-04
Acenaphthalene	5.84E-04
Biphenyl	5.84E-04
Cyclohexane	5.84E-04
Decane	5.84E-04
Dodecane	5.84E-04
Heptane	5.84E-04
Indan	5.84E-04
Indene	5.84E-04
m,p-Cresol	5.84E-04
Nonane	5.84E-04
o-Cresol	5.84E-04
Octane	5.84E-04
Phenol	5.84E-04
Propylbenzene	5.84E-04

Analytes	Lb/Tn Metal
Tetradecane	5.84E-04
HC as Hexane	5.84E-02
2-Butanone (MEK)	1.75E-03
Acetaldehyde	1.75E-03
Acetone	1.75E-03
Acrolein	1.75E-03
Benzaldehyde	1.75E-03
Butyraldehyde	1.75E-03
Crotonaldehyde	1.75E-03
Formaldehyde	1.75E-03
Hexaldehyde	1.75E-03
Butyraldehyde/Methacrolein	2.92E-03
o,m,p-Tolualdehyde	4.67E-03
Pentanal (Valeraldehyde)	1.75E-03
Propionaldehyde (Propanal)	1.75E-03
Aniline	1.17E-02
Dimethylaniline	2.34E-02
Carbon Monoxide	2.80E-02
Carbon Dioxide	4.39E-02
Nitrogen Oxides	3.00E-02

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APPENDIX C TEST SERIES FR AND GG DETAILED PROCESS DATA

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Test FR Detailed Process Data

Test Dates	1/15/2004	1/15/2004	1/16/2004	1/16/2004	Averages
Emissions/ Production Sample #	FR 01	FR 02	FR 03	FR 04	
Core Additive	Reference w/o Additive				
Cast Weight (all metal inside mold), Lbs.	110.95	108.35	112.35	112.60	111.1
Pouring Time, sec.	36	26	24	24	28
Pouring Temp ,°F	2636	2632	2630	2631	2632
Pour Hood Process Air Temp at Start of Pour, ^{o}F	88	89	85	87	87
Mixer auto dispensed batch weight, Lbs	45.35	45.35	45.35	45.35	45.35
Calibrated auto dispensed binder weight, Lbs	0.633	0.633	0.633	0.633	0.633
Core binder calibrated weight, %BOS	1.39	1.39	1.39	1.39	1.39
Core binder calibrated weight, %	1.38	1.38	1.38	1.38	1.38
Total uncoated core weight in mold, Lbs.	24.70	25.50	25.30	25.50	25.25
Total binder weight in mold, Lbs.	0.340	0.351	0.348	0.351	0.347
Core LOI, %	1.19	1.25	1.37	1.23	1.26
Core dogbone tensile, psi	39.5	39.5	39.5	39.5	39.5
Core age, hrs.	41	55	73	76	61
Muller Batch Weight, Lbs.	900	900	900	900	900
GS Mold Sand Weight, Lbs.	613	622	619	626	620
Mold compactability, %	55	54	57	57	56
Mold Temperature, ^{o}F	72	70	67	69	70
Average Green Compression , psi	11.30	12.16	10.44	10.08	11.00
GS Compactability, %	53	47	55	55	53
GS Moisture Content, %	1.86	2.28	2.36	2.56	2.27
GS MB Clay Content, %	5.58	6.20	6.20	6.08	6.02
MB Clay reagent, ml	25.0	26.5	26.5	26.0	26.0
1800°F LOI - Mold Sand, %	0.71	0.68	0.74	0.72	0.71
900°F Volatiles , %	0.20	0.24	0.30	0.20	0.24
Appearance within group	Median		Best	Worst	
Overall appearance ranking: 1 = best, 9 = worst	6		4	9	

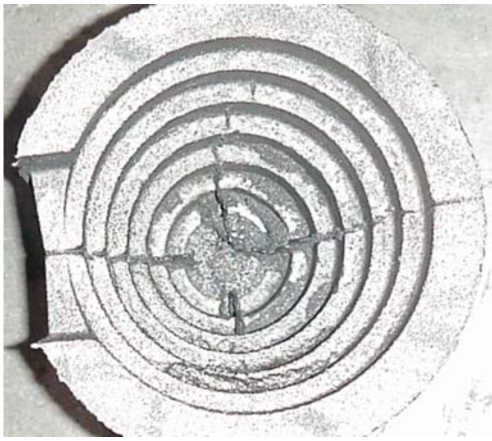
Test GG Detailed Process Data

Greensand PCS													
Test Dates	9/20/04	9/20/04	9/20/04	9/21/04	9/21/04	9/21/04	9/22/04	9/22/04	9/22/04	9/23/04	9/23/04	9/23/04	Averages
Emissions Sample #	**GGER1**	**GGER2**	**GGER3**	**GG001**	**GG002**	**GG003**	**GG004**	**GG005**	**GG006**	**GG007**	**GG008**	**GG009**	
Production Sample #	**GG001**	**GG002**	**GG003**	**GG004**	**GG005**	**GG006**	**GG007**	**GG008**	**GG009**	**GG010**	**GG011**	**GG012**	
Core Additive	H&G VeinAway HT ®												
Cast Weight (all metal inside mold), Lbs.	120.0	116.3	115.5	113.2	114.8	113.4	111.7	110.7	111.0	113.0	113.0	110.6	**112.4**
Pouring Time, sec.	19	14	15	16	14	15	16	16	16	14	15	16	**15**
Pouring Temp ,°F	2622	2636	2627	2637	2636	2633	2638	2630	2640	2629	2640	2633	**2635**
Pour Hood Process Air Temp at Start of Pour, °F	87	80	87	87	87	89	87	88	90	87	87	87	**88**
Mixer auto dispensed batch weight, Lbs	50.35	50.35	50.35	50.35	50.35	50.35	50.35	50.35	50.35	50.35	50.35	50.35	**50.4**
Average weighed binder weight, Lbs	0.7128	0.7128	0.7128	0.7126	0.7126	0.7126	0.7126	0.7126	0.7126	0.7126	0.7126	0.7126	**0.713**
Core binder calculated weight, %BOS	1.42	1.42	1.42	1.42	1.42	1.42	1.42	1.42	1.42	1.42	1.42	1.42	**1.42**
Core binder calculated weight, %	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	1.40	**1.40**
Total uncoated core weight in mold, Lbs.	27.55	27.76	27.71	28.21	28.03	28.04	28.04	27.98	28.16	28.25	28.11	27.85	**28.1**
Total binder weight in mold, Lbs.	0.385	0.387	0.387	0.394	0.391	0.391	0.391	0.391	0.393	0.394	0.392	0.389	**0.392**
Core LOI, %	1.49	1.45	1.52	1.58	1.61	1.64	1.64	1.60	1.61	1.64	1.58	1.61	**1.61**
Core dogbone 2 hour average tensile, psi	175.2	175.2	175.2	175.2	175.2	175.2	175.2	175.2	175.2	175.2	175.2	175.2	**175**
Core age, hrs.	162.08	164.55	167.50	169	172	175	193	195	198	217	220	223	**196**
Muller Batch Weight, Lbs.	1300	900	900	900	900	900	900	900	900	900	900	900	**900**
GS Mold Sand Weight, Lbs.	649	649	645	651	643	638	638	627	628	630	631	633	**635**
Mold compactability, %	60	54	56	52	51	58	52	58	57	58	59	59	**56**
Mold Temperature, °F	73	75	81	73	75	81	79	97	81	76	80	84	**81**
Average Green Compression , psi	16.9	15.3	16.5	18.1	20.5	25.2	23.2	27.1	27.7	25.0	25.3	26.0	**24.2**
GS Compactability, %	56	44	43	38	38	42	33	48	47	47	60	58	**46**
GS Moisture Content, %	2.56	2.22	2.00	2.50	2.00	1.96	1.80	2.14	2.68	2.34	2.68	2.24	**2.26**
GS MB Clay Content, %	7.78	8.43	8.17	8.17	8.56	8.56	8.69	8.56	8.69	8.81	8.94	8.56	**8.62**
MB Clay reagent, ml	30	32.5	31.5	31.5	33.0	33.0	33.5	33.0	33.5	34.0	34.5	33.0	**33.2**
1800°F LOI - Mold Sand, %	0.88	0.84	0.9	0.91	0.9	0.92	1.02	1.00	0.96	0.96	1.15	1.03	**0.98**
900°F Volatiles , %	0.28	0.26	0.28	0.34	0.28	0.26	0.28	0.22	0.22	0.28	0.40	0.28	**0.28**
Appearance within group B:best, M:median, W: worst						Worst		Median			Best		
Overall appearance ranking: 1 = best, 8 = worst	8a	7a	7b	2	3	9	6	5	7	4	1	8	

Note: Sand for mold GG006 had to be remulled.

Test FR Cavity 3 Castings

FR001



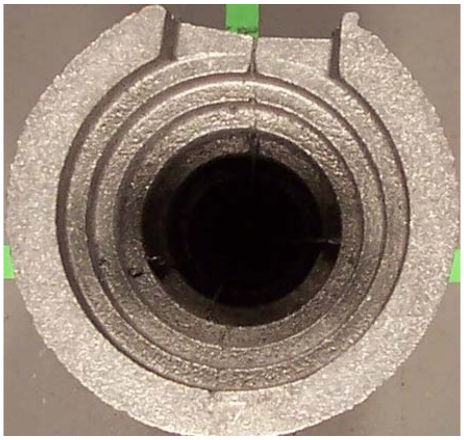
FR002

FR003

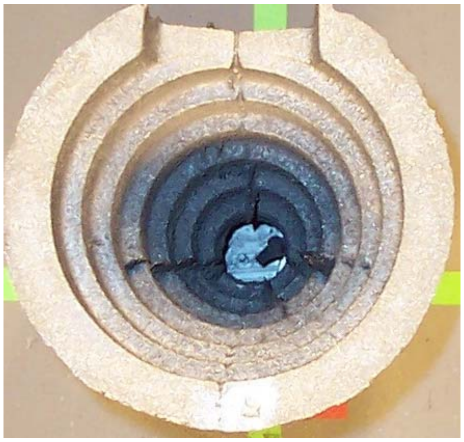
FR004

Test GG Cavity 3 Castings

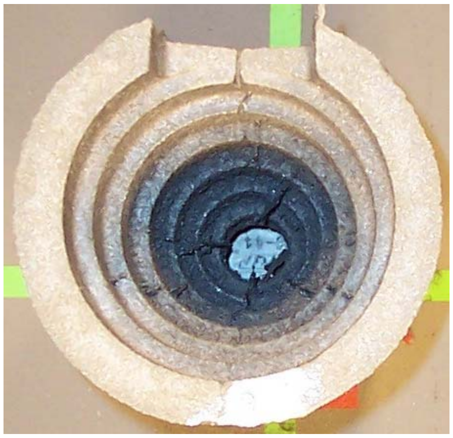
GG001



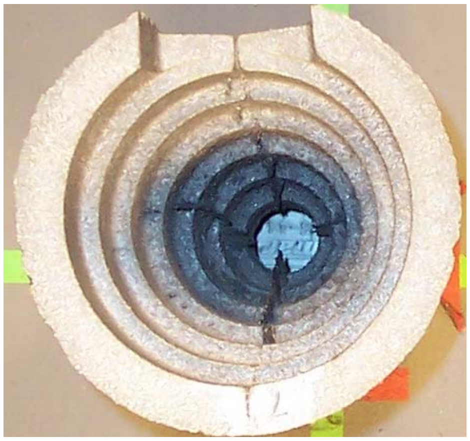
GG002



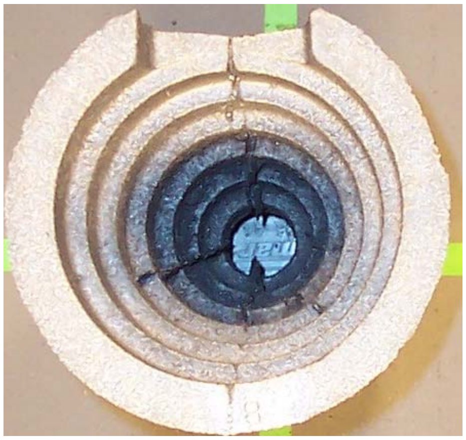
GG003



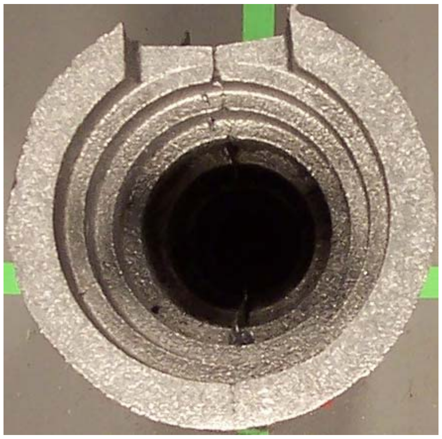
GG004



GG005



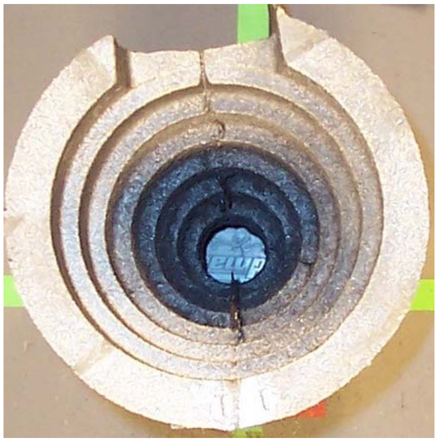
GG006



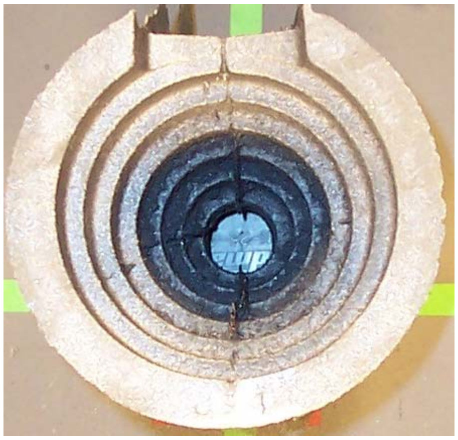
Test GG Cavity 3 Castings

GG007

GG008



GG009



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APPENDIX D METHOD 25A CHARTS

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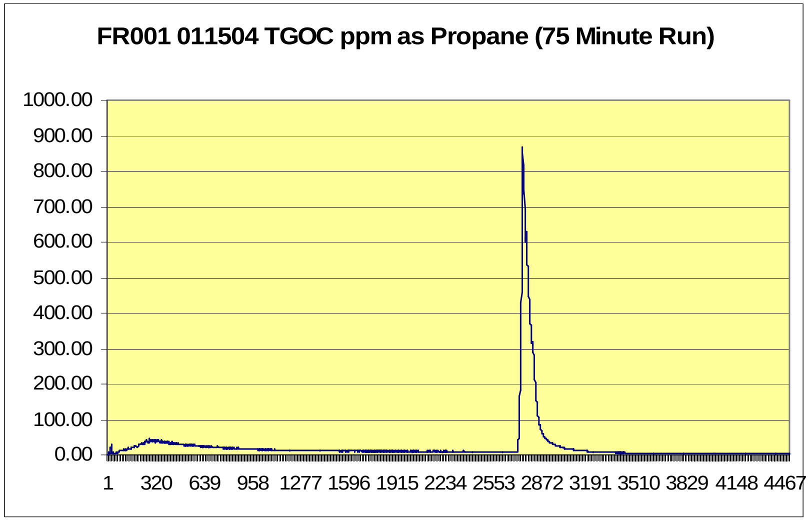
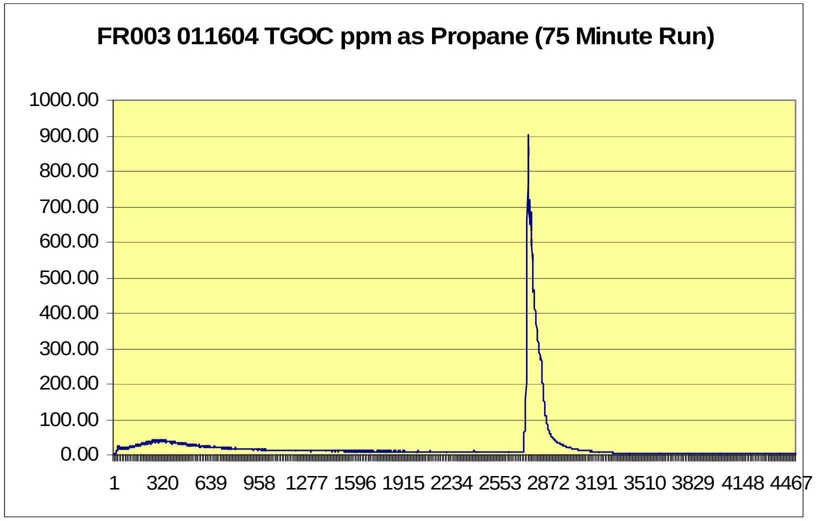
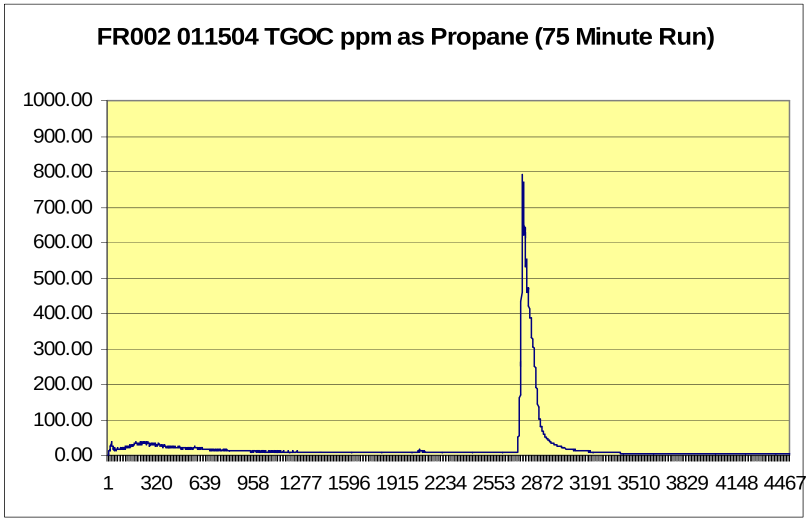
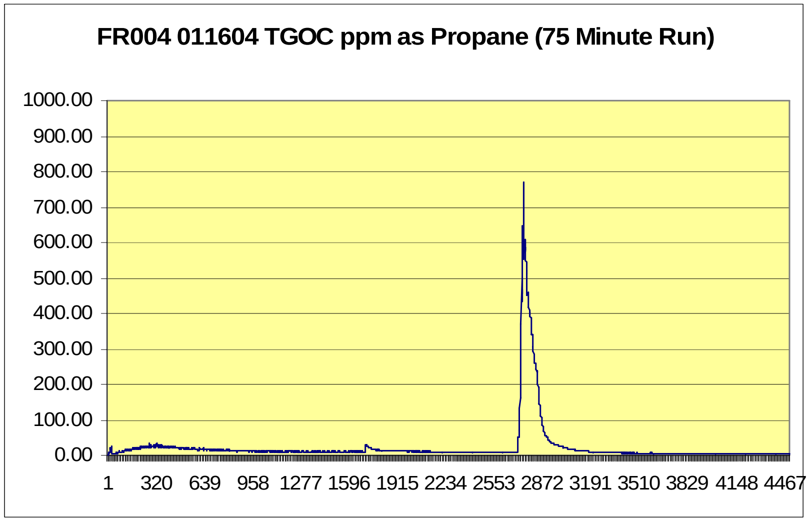
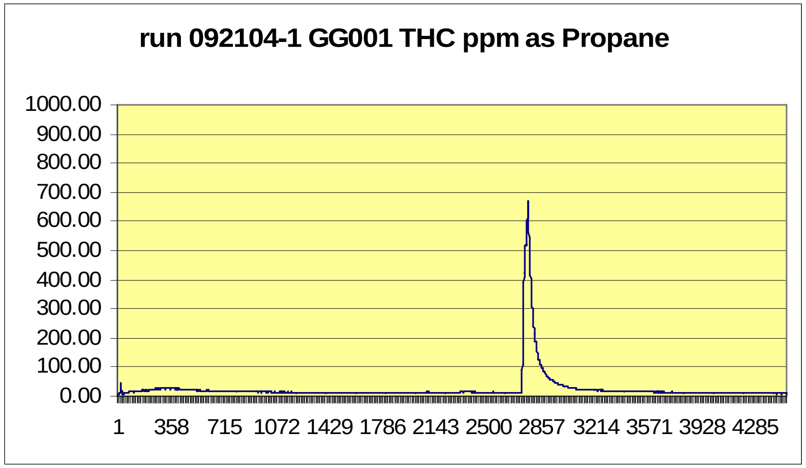
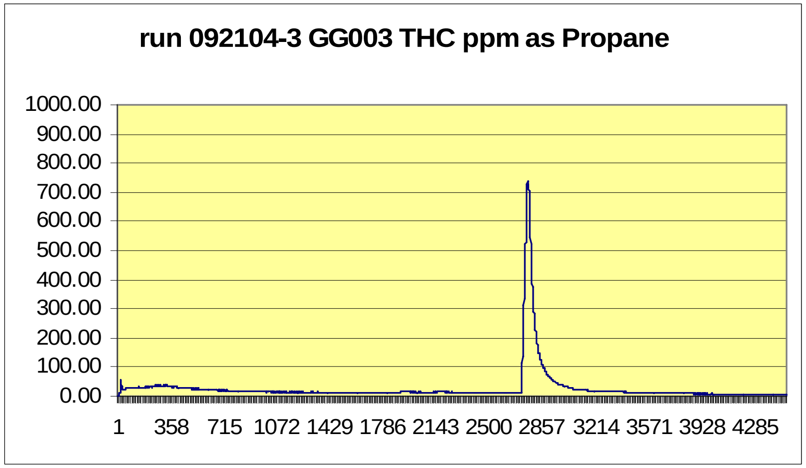

FR001 011504 TGOC ppm as Propane (75 Minute Run)
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 320 639 958 1277 1596 1915 2234 2553 2872 3191 3510 3829 4148 4467

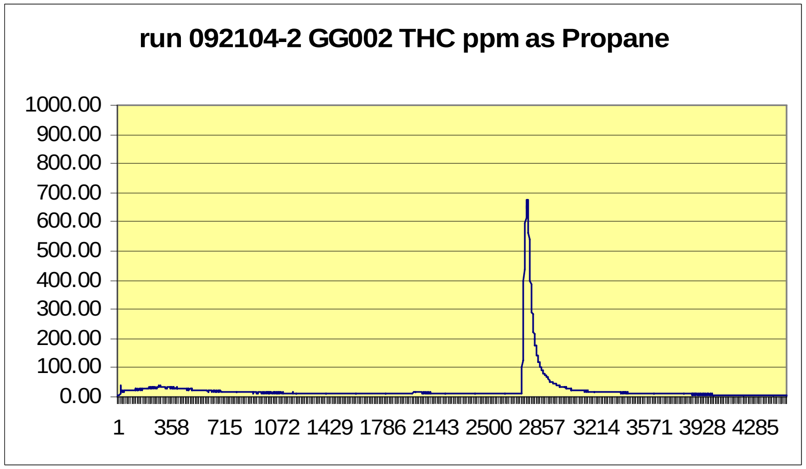

FR003 011604 TGOC ppm as Propane (75 Minute Run)
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 320 639 958 1277 1596 1915 2234 2553 2872 3191 3510 3829 4148 4467

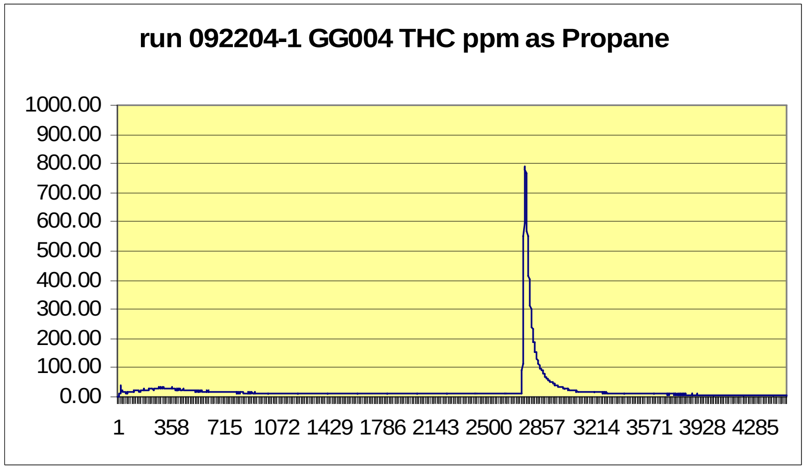

FR002 011504 TGOC ppm as Propane (75 Minute Run)
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 320 639 958 1277 1596 1915 2234 2553 2872 3191 3510 3829 4148 4467

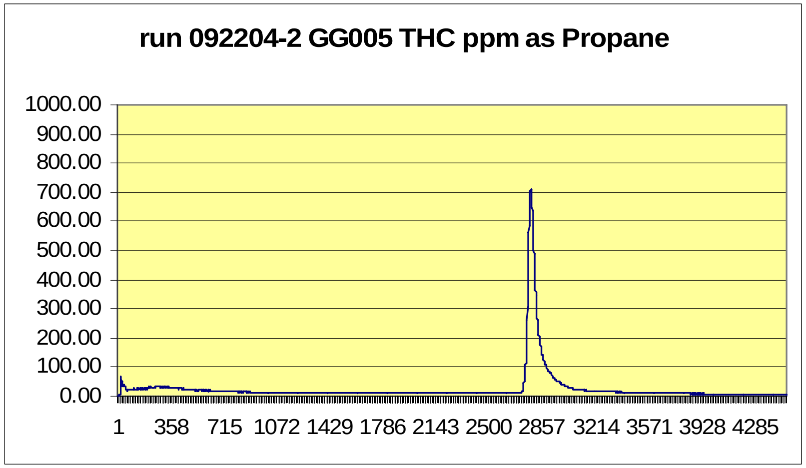

FR004 011604 TGOC ppm as Propane (75 Minute Run)
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 320 639 958 1277 1596 1915 2234 2553 2872 3191 3510 3829 4148 4467

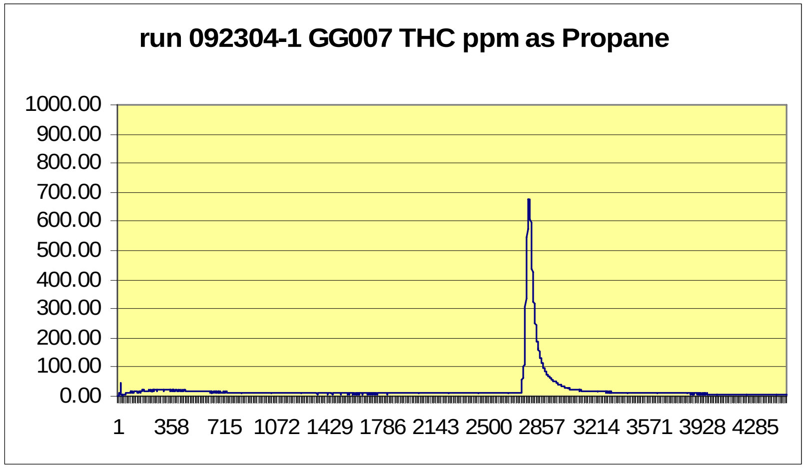

run 092104-1 GG001 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 358 715 1072 1429 1786 2143 2500 2857 3214 3571 3928 4285

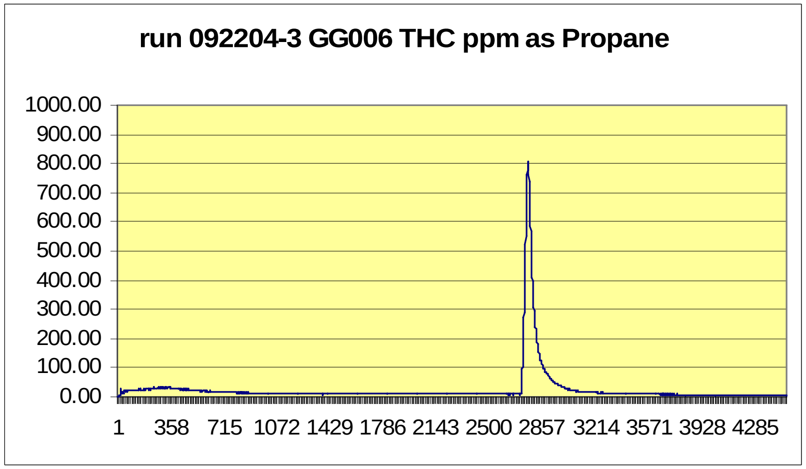

run 092104-3 GG003 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 358 715 1072 1429 1786 2143 2500 2857 3214 3571 3928 4285

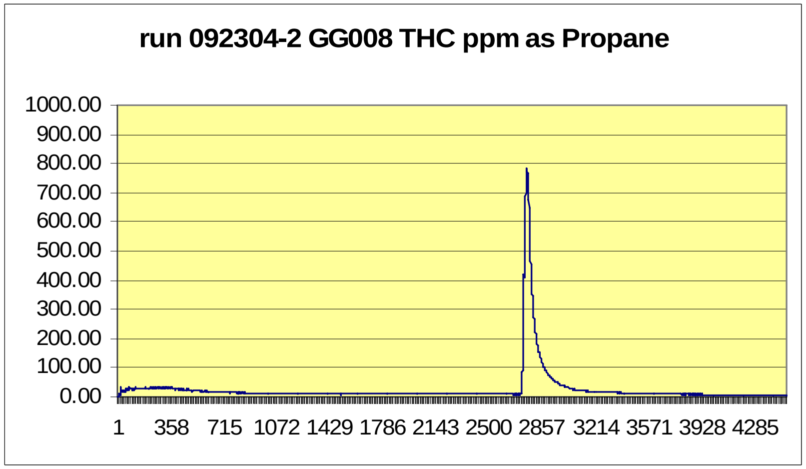

run 092104-2 GG002 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 358 715 1072 1429 1786 2143 2500 2857 3214 3571 3928 4285

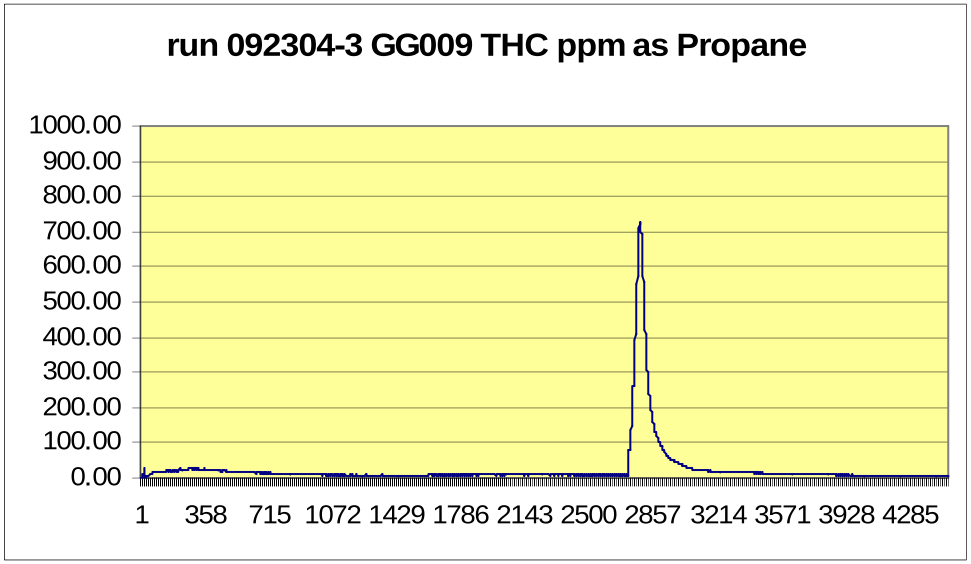

run 092204-1 GG004 THC ppm as Propane
1000.00
900.00
800.00
700.00
600.00
500.00
400.00
300.00
200.00
100.00
0.00
1 358 715 1072 1429 1786 2143 2500 2857 3214 3571 3928 4285


run 092204-2 GG005 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 092304-1 GG007 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 092204-3 GG006 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 092304-2 GG008 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 092304-3 GG009 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

APPENDIX E GLOSSARY

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Glossary

BO	Based on ( ).
BOS	Based on Sand.
Criteria Pollutant	Pollutants, including; CO, SO_2, NOx, VOC, Particulate Matter and Lead, for which the US EPA has established National Ambient Air Quality Standards.
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.
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