

# QUALITY WORK INSTRUCTIONS (QWI) CRIMPER OPERATION (ISI PLANT ONLY)

Document #: QWI-6  
Revision#: 1  
Effective Date: 12/2/09

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## 1.0 OPERATIONAL INSTRUCTIONS

The Plant Manager / Production Manager reviews finished product inventory plus the projected demand to determine whether to operate the plant. If production is required, the plant operator is instructed to start the process. The plant operator is required to maintain an adequate supply of raw material in the raw material hopper (QWI-1) for plant operations. Screen sizes per customer request are installed. The procedure for start up is the following sequence:

## 2.0 PROCEDURE

Turn on in this sequence:

- 1) Product auger
- 2) Oversize conveyor
- 3) Oversize return
- 4) Fines auger
- 5) Oversize crimper - 1
- 6) Oversize crimper - 2
- 7) Shaker screen - 1
- 8) Shaker screen – 2
- 9) Outside elevator
- 10) Outside conveyor
- 11) Main crimper
- 12) Crimper elevator
- 13) Variable speed drive conveyor
- 14) Feed auger from raw material storage

## 3.0 SORTING AND PACKAGING

- 1) Oversize product is automatically fed thru the secondary crimper from the oversize auger and rerun thru the process
- 2) Undersized product is bagged in super sacks and transferred to raw material storage for milling
- 3) Middle deck product is tested and packaged.

## 4.0 SHUT DOWN

To shut down process, reverse start up sequence

## 5.0 PROCESS CONTROL DOCUMENTATION

Particle size results (through screen mesh) are recorded on the production report by the Q.C. Tech/Plant Operator.

## 6.0 IN-PROCESS INSPECTION / TESTING

The Quality Control Technician conducts the necessary analysis, records results in the Final Inspection Log Book, completes the Certificate of Analysis (Form 35), and ensures that the Release Sheet (Form 28) is completed.

The following are performed per product requirement.

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	<u>Inspector</u>	<u>Frequency</u>	<u>Documentation</u>
LOT NUMBER ASSIGNMENT	Plant Operator	Each Skid	Release Sheet (Form 28)
ASH	Q.C.Tech	Production Run	Final Inspection Log Book
HEAT LOSS	Q.C.Tech	Production Run	Final Inspection Log Book
SCREEN ANALYSIS	Q.C.Tech	Production Run	Final Inspection Log Book
ACIDITY	Q.C.Tech	Production Run	Final Inspection Log Book
OIL	Q.C.Tech	Production Run	Final Inspection Log Book

## 7.0 ACCEPT / REJECT CRITERIA

The Q.C. Tech checks specifications in the Specification Manual.  
Product samples are retained for a minimum of 6 months.

## 8.0 CONTROL OF NONCONFORMING PRODUCT

Any nonconformance discovered during manufacture is marked with a Hold Tag (Form 10) and placed in the segregated area. The Plant Manager will schedule a retest to further evaluate the nonconformance and record by notation on the Hold Tag.

## 9.0 GAGES / TEST EQUIPMENT

Instruments used are the Scale, Oven, and Sieves. Calibration details are described in the applicable Calibration Procedure QWI's.

## 10.0 PRODUCT IDENTIFICATION AND TRACEABILITY

Lot numbers are assigned based on the date of manufacture and order of production. Lot numbers are assigned according to the format outlined in QM7 section 7.5.3.