

QUALITY WORK INSTRUCTIONS (QWI)

FLAKE SCREENING OPERATION

(HOLLY PLANT ONLY)

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1.0 OPERATIONAL INSTRUCTIONS

The Plant Manager / Production Manager reviews orders and inventory on hand to determine operation requirement. If production is required, the Mill Operator and/or Maintenance Manager will coordinate the re-alignment of product feed and screen connections to allow flake screening and packaging.

2.0 PROCEDURE

The procedure for start up is the following sequence:

- 1) Reverse top feed screw to feed flake screen
- 2) Check top and bottom screens for holes; repair if needed
- 3) Connect screen outlet to bagging auger
- 4) Check for proper CO₂ concentration in equipment
- 5) Turn equipment on and proceed to packaging screened flake
- 6) Product is tested and packaged per customer requirement

Clean up after screened flake production

- 1) Run system empty
- 2) Turn off power supply and CO₂ feed to all equipment
- 3) Disconnect flake screen and blank screen connection to bagging auger
- 4) Clean out all pipes, bagging auger, bagging hopper and super sack filling stations
NOTE: Particular attention should be paid to the cleaning of the slide gate as small particles can get trapped in the guides. The entire system will be cleaned on every use, i.e. bagging hopper and super sack filling stations, even if only one style of package was filled (super sack or 50 lb bag)
- 5) Return direction of top feed screw to feed mill feed hopper
- 6) Run first 500 to 1,000 lbs of milled product into super sack and 50 lb bag and handle as scrap
- 7) Follow screened flake production with a minimum of 10 tons to pestell animal feed sulfur and 20 tons of royal mat sulfur.
- 8) Sample first production 4 times for flake contamination, both super sack and 50 lb bag production