# STANDARD PROCESS INSTRUCTIONS / TRAVELER

| No. | REVISION | DATE | APPROVED | SINTERED SPECIALTIES DIVISION | | |
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| 00 | CN XXXXX | xx/xx/08 | ZZZ | SSI TECHNOLOGIES | | |
| | | | | Issued | Approved | Sheet No. |
| | | | | xx/xx/08 | ZZZ | 5 of 17 |

## OPERATOR LOADING INSTRUCTIONS:

The following procedure is to be used to prep for vacuum burn-off, or while unloading parts from the 24" burn-off.

Carefully load parts, **I.D. mark up**, on Coors tile and graphite boards as follows:

1. Place clean 3.75" x 4.50" Coors tiles on large graphite boards. See pattern below for tile locations.
2. Lightly salt Coors Tiles with Alumina Oxide.
3. Load (24) parts onto each Coors tile, making sure that the **parts DO NOT touch**.
4. Load (12) tiles per board and <u>four</u> small boards per layer. There will be approximately 22 layers per load and 1,152 parts per layer. **Approximate total lot size = 25,344 pieces**.
5. Place Ø1" x 0.75" lg. spacers at the corners of the small boards in the build.
6. Do **NOT** sinter a short load!!! Combine with other ███████ parts to get the sinter build as close to 22 layers (assuming smaller blades) as possible. Any combination of ███████ part numbers may be processed.



SMALL GRAPHITE BOARDS — 3.75" X 4.50" COORS TILES — Ø1" X 0.75 LG. GRAPHITE SPACERS
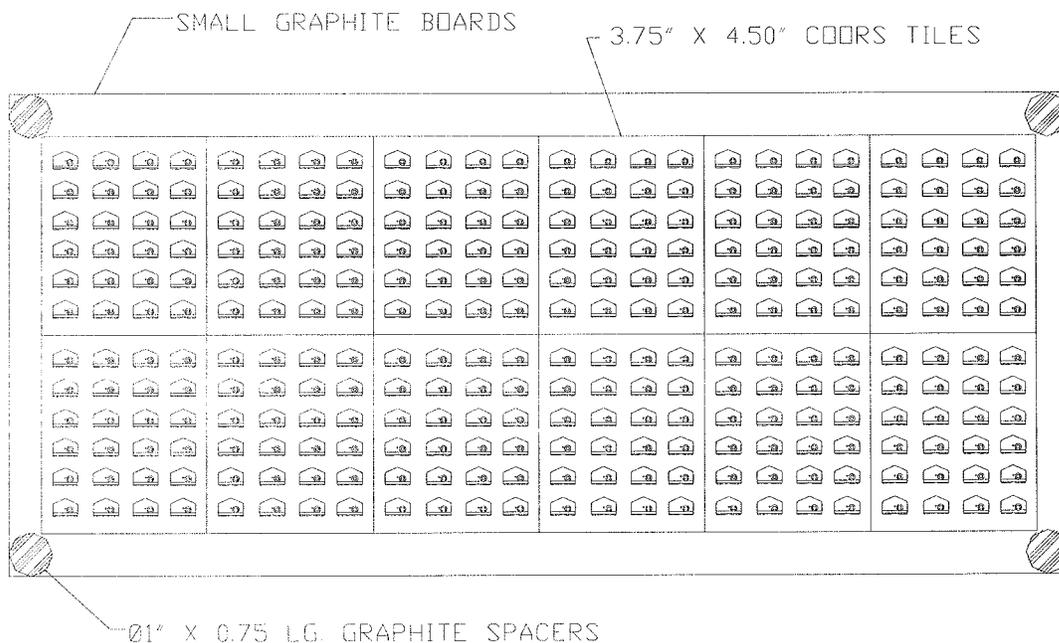
**Primary Loading Pattern**

## NEXT OPERATION: <u>BURN-OFF (LOAD/UNLOAD)</u>