

Reymond Products International, Inc.



Plant Questionnaire

Date: _____

Plant Name: _____

Plant Location: _____

The following Questionnaire has been designed and formatted to enlighten us as to how your plant operates. Please take the time to fill out as many questions as possible so that we may better serve you.

MACHINE:

- 1.) What machine is currently being used?

- 2.) Hinge door or a die changer?

- 3.) If a die changer is being used, (only on the 90 machine) what type and model is it?

- 4.) What size is your point auger? _____ What type or style are you currently using?

- 5.) How often is the point auger changed?

- 6.) How often is the complete set changed?

- 7.) What type of cylinder liners?

- 8.) How often are the liners changed?

- 9.) Are you using a single or double pug system?

- 10.) What type of water control system are you using, and what is your extrusion moisture?

- 11.) What is your present extrusion rate in tons per hour?

MATERIALS:

- 1.) Are you adding grog or calcite to your body, and if so, at what percentage?

- 2.) Are you running smooth brick, and if so, are you adding any manganese or other additives to change the color of the product?

- 3.) Does your company stockpile your material, and if so, is it covered, and how much is stockpiled at a time?

- 4.) What type of material do you extrude? (clay, shale, or a blend?) If blended, at what percentage?

- 5.) On a scale from 1 to 10, with 10 being the optimum for plasticity, where would you rate your material?

- 6.) What mesh are your materials ground to, and, what type or styles of screens are currently being used?

EXTRUSION:

- 1.) What die or dies are you currently using, and how many places is your unit set up to oil (4), (6), (8) or (10)?
- 2.) How often do you have to replace a die and shaper cap?
- 3.) What is the length of your current die base? And cap?
- 4.) Are there any bulges or flow restrictions?
- 5.) What is the distance between die exit and conveyor/off bearing equipment?
- 6.) What types of problems are you experiencing, and what steps have thus far been taken towards correcting the problem?
- 7.) Are you currently using any extrusion aids or additives during the extrusion process? If so, what type and how much?
- 8.) What type of die lube are you currently using?
- 9.) What type of lube pump are you currently using, and what kind of oil pressure is normal?
- 10.) What method has been used to test die balance? How were the results?

TEXTURING:

- 1.) Are you using a blade or wire cut?
- 2.) Blade/wire or combination blade/wire?
- 3.) 3-way or 4-way?
- 4.) Do you have a cut and roll back product (s)?
- 5.) What type of off bearing equipment is used? Conveyor belt, UHMW, Etc.?
- 6.) How much texturing area is available before the cutter?
- 7.) Do you score the bottom of the column?

CUTTING:

- 1.) What type of cutter are you currently using, is it a "Reel or Slug"?
- 2.) If a "Reel" cutter, what make & model is it?

DRYING AND FIRING:

- 1.) What type, and how long of a kiln are you currently using, and at what temperatures are you firing your products?
- 2.) If using a continuous kiln, what is your normal push rate?
- 3.) In the past, have you ever experienced problems with drying the product?