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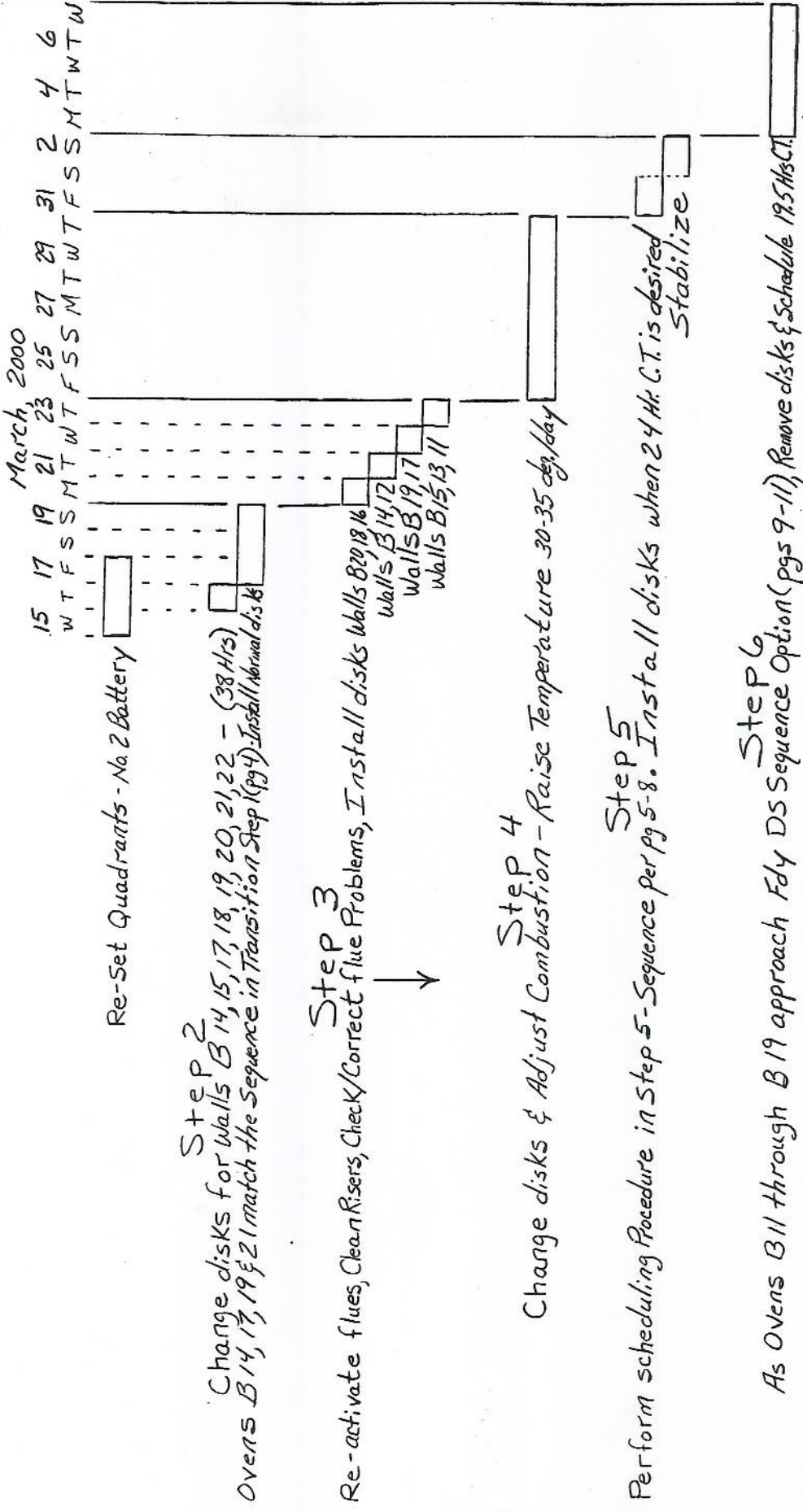
“Methods to Downsize Foundry Production”
Dated: March 2000

Recovered from site on Feb 6 2021

METHODS TO DOWNSIZE FOUNDRY PRODUCTION (FIVE OVENS)
Revised 3/14/00 jop

1. Starting condition (15 ovens on foundry production) are shown in attachment, pages 1 through 3. A prerequisite is that the quadrants for No. 2 Battery be set.
2. The first step is to re-arrange the position of the foundry sequencing. The sequence of the furnace ovens will not change. The heat level of the foundry ovens will not change. The sequence change will be accomplished by installing orifices that allow desired foundry ovens on 38 hour cycle. They will be held in this condition until the desired sequence shown in attached page 4 is achieved. Time required 3 days.
3. Once the foundry ovens are properly positioned, the non-serviceable flues for the ovens to be returned to furnace operating rate will be reactivated. During the same time period orifices will be installed in an attempt to hold the span average flue temperature as close to the existing 2050 to 2100 deg. as possible. Walls will be reactivated over a four day period: B-20,18,16; B-14,12; B-19,17; B-15,13,11. Time required four days.
4. The ovens being restored to furnace service will continue to be maintained in the pushing sequence on page 4. Orifice changes will be made to increase the nominal flue temperature by 35 degrees per day until operating temperature of 2250 to 2300 deg. is achieved. Furnace coal blend should be charged into the ovens. The heat level for ovens B21 to B25 will not change - foundry or furnace blend can be charged. Time required 7 days.
5. The coking time for a group of the ovens to be returned to furnace operation will be reduced by about 5 hours (to 24 - 24.5 hours) as shown in the interim scheduling method in attached pages 5 - 8. Also, this scheduling delay will be increased to a total of 1 hour, creating a one time increase in coking time for all other ovens. This allows pulling No. 1 battery furnace ovens into the new sequence. A one time production loss of about 5 ovens will be experienced. The heat level of the ovens on No. 1 and 2 batteries with extended coking time will be controlled by appropriately closing emergency shut off valves. The orifices for the ovens being returned to furnace service will be changed to maintain the temperature for the new heat demand. After the one time excursion, the existing furnace ovens on both batteries will be at normal nominal 19.5 hour cycle, the ovens being restored to furnace service 24+ hours, and the foundry ovens at 29+ hours. Ovens B-11 to B-19 will be held at 24+ hours for an additional cycle. Time 3 days.
6. The ovens being restored to furnace operation (properly orificed) will be retained in the interim scheduling sequence (pages 5 - 8) until they approach the eventual position in the desired sequence shown in pages 9 - 11. At this point the orifices will be removed and the ovens will push with the normal furnace production at normal coking time of 19.5 hours. Time requirement about 5 days.

Program to Convert Ovens B 20 - B11 To Furnace Coke Production



OPTION G

PATTERN

=====	B-4	A-22
=====	B-6	A-24
=====	B-8	C-16
=====	C-21	C-18
=====	C-23	C-20
C-1	C-25	C-22
C-3	D-21	C-24
C-5	D-23	
C-7	D-25	B-1
C-9	=====	B-3
A-1	=====	B-5
A-3	=====	B-7
A-5	=====	B-9
A-7	=====	D-16
	C-2	D-18
D-1	C-4	D-20
D-3	D-2	D-22
D-5	D-4	D-24
D-7		=====
D-9	A-2	=====
A-9	A-4	=====
A-11	A-6	=====
A-13	A-8	=====
A-15		=====
	C-6	
C-11	C-8	
C-13	C-10	
C-15	C-12	
C-17	C-14	
C-19	A-10	
A-17	A-12	
A-19	A-14	
A-21	A-16	
A-23		
A-25	D-6	
	D-8	
D-11	D-10	
D-13	D-12	
D-15	D-14	
D-17		
D-19	A-18	
B-2	A-20	

OVEN B-10 IS A BUFFER SCHEDULED IN OPEN SLOTS @ AVG FCE/FDY C.T.

OPTION G

DAY 1

FIRST SHIFT			SECOND SHIFT			THIRD SHIFT		
TIME	F'DY	COKE	TIME	F'DY	COKE	TIME	F'DY	COKE
	FCE.	TIME		FCE.	TIME		FCE.	TIME
11:03	====B-16		7:03	B-4		3:03	A-22	
15	====B-18		15	B-6		15	A-24	
26	====B-20		26	B-8		26	C-16	
38	====B-22		38	C-21		38	C-18	
49	====B-24		49	C-23		49	C-20	
12:01	C-1		8:01	C-25		4:01	C-22	
12	C-3		12	D-21		12	C-24	
24	C-5		24	D-23		24		
35	C-7		35	D-25		35	B-1	
47	C-9		47	====B-11		47	B-3	
58	A-1		58	====B-13		58	B-5	
1:10	A-3		9:10	====B-15		5:10	B-7	
21	A-5		21	====B-17		21	B-9	
33	A-7		33	====B-19		33	D-16	
44			44	C-2		44	D-18	
55	D-1		55	C-4		55	D-20	
2:07	D-3		10:07	D-2		6:07	D-22	
18	D-5		18	D-4		18	D-24	
30	D-7		30			30	====B-21	
41	D-9		41	A-2		41	====B-23	
53	A-9		53	A-4		53	====B-25	
3:04	A-11		11:04	A-6		7:04	====B-12	
15	A-13		15	A-8		15	====B-14	
26	A-15		26			26	C-1	19:25
38			38	C-6		38	C-3	
49	C-11		49	C-8		49	C-5	
4:01	C-13		12:01	C-10		8:01	C-7	
12	C-15		12	C-12		12	C-9	
23	C-17		23	C-14		23	A-1	
35	C-19		35	A-10		35	A-3	
46	A-17		46	A-12		46	A-5	
58	A-19		58	A-14		58	A-7	
5:09	A-21		1:09	A-16		9:09		
21	A-23		21			21	D-1	19:26
32	A-25		32	D-6		32	D-3	
44			44	D-8		44	D-5	
55	D-11		55	D-10		55	D-7	
6:07	D-13		2:07	D-12		10:07	D-9	
18	D-15		18	D-14		18	A-9	
30	D-17		30			30	A-11	
41	D-19		41	A-18		41	A-13	
52	B-2		52	A-20		52	A-15	

OVEN B-10 IS A BUFFER SCHEDULED IN OPEN SLOTS @ AVG FCE/FDY C.T.

OPTION G

DAY 2

FIRST SHIFT			SECOND SHIFT			THIRD SHIFT		
TIME	F'DY	COKE	TIME	F'DY	COKE	TIME	F'DY	COKE
	FCE.	TIME		FCE.	TIME		FCE.	TIME
11:03			7:03	C-6	19:25	3:03	C-3	19:25
15	C-11	19:26	15	C-8		15	C-5	
26	C-13		26	C-10		26	C-7	
38	C-15		38	C-12		38	C-9	
49	C-17		49	C-14		49	A-1	
12:01	C-19		8:01	A-10		4:01	A-3	
12	A-17		12	A-12		12	A-5	
24	A-19		24	A-14		24	A-7	
35	A-21		35	A-16		35		
47	A-23		47			47	D-1	19:26
58	A-25		58	D-6	19:26	58	D-3	
1:10			9:10	D-8		5:10	D-5	
21	D-11	19:26	21	D-10		21	D-7	
33	D-13		33	D-12		33	D-9	
44	D-15		44	D-14		44	A-9	
55	D-17		55			55	A-11	
2:07	D-19		10:07	A-18		6:07	A-13	
18	B-2		18	A-20		18	A-15	
30	B-4		30	A-22		30		
41	B-6		41	A-24		41	C-11	19:26
53	B-8		53	C-16		53	C-13	
3:04	C-21	19:26	11:04	C-18		7:04	C-15	
15	C-23		15	C-20		15	C-17	
26	C-25		26	C-22		26	C-19	
38	D-21		38	C-24		38	A-17	
49	D-23		49			49	A-19	
4:01	D-25		12:01	B-1	19:26	8:01	A-21	
12	===B-16	29:09	12	B-3		12	A-23	
23	===B-18		23	B-5		23	A-25	
35	===B-20		35	B-7		35		
46	===B-22		46	B-9		46	D-11	19:25
58	===B-24		58	D-16		58	D-13	
5:09	C-2	19:25	1:09	D-18		9:09	D-15	
21	C-4		21	D-20		21	D-17	
32	D-2		32	D-22		32	D-19	
44	D-4		44	D-24		44	B-2	
55			55	===B-11	29:08	55	B-4	
6:07	A-2	19:26	2:07	===B-13		10:07	B-6	
18	A-4		18	===B-15		18	B-8	
30	A-6		30	===B-17		30	C-21	
41	A-8		41	===B-19		41	C-23	
52			52	C-1	19:26	52	C-25	

OVEN B-10 IS A BUFFER SCHEDULED IN OPEN SLOTS @ AVG FCE/FDY C.T.

TRANSITION STEP 1

PREPARATION

FIRST SHIFT			SECOND SHIFT			THIRD SHIFT		
TIME	F'DY	COKE	TIME	F'DY	COKE	TIME	F'DY	COKE
	FCE.	TIME		FCE.	TIME		FCE.	TIME
11:03	====B-14		7:03	B-4		3:03	A-22	
15	====B-16		15	B-6		15	A-24	
26	====B-18		26	B-8		26	C-16	
38	====B-20		38	C-21		38	C-18	
49	====B-22		49	C-23		49	C-20	
12:01	====B-24		8:01	C-25		4:01	C-22	
12	C-1		12	D-21		12	C-24	
24	C-3		24	D-23		24		
35	C-5		35	D-25		35	B-1	
47	C-7		47	====B-11		47	B-3	
58	C-9		58	====B-13		58	B-5	
1:10	A-1		9:10	====B-15		5:10	B-7	
21	A-3		21	=====		21	B-9	
33	A-5		33	====B-21		33	D-16	
44	A-7		44	C-2		44	D-18	
55	D-1		55	C-4		55	D-20	
2:07	D-3		10:07	D-2		6:07	D-22	
18	D-5		18	D-4		18	D-24	
30	D-7		30			30	====B-12	
41	D-9		41	A-2		41	====B-17	
53	A-9		53	A-4		53	====B-19	
3:04	A-11		11:04	A-6		7:04	====B-23	
15	A-13		15	A-8		15	====B-25	
26	A-15		26			26	C-1	19:25
38			38	C-6		38	C-3	
49	C-11		49	C-8		49	C-5	
4:01	C-13		12:01	C-10		8:01	C-7	
12	C-15		12	C-12		12	C-9	
23	C-17		23	C-14		23	A-1	
35	C-19		35	A-10		35	A-3	
46	A-17		46	A-12		46	A-5	
58	A-19		58	A-14		58	A-7	
5:09	A-21		1:09	A-16		9:09		
21	A-23		21			21	D-1	19:26
32	A-25		32	D-6		32	D-3	
44			44	D-8		44	D-5	
55	D-11		55	D-10		55	D-7	
6:07	D-13		2:07	D-12		10:07	D-9	
18	D-15		18	D-14		18	A-9	
30	D-17		30			30	A-11	
41	D-19		41	A-18		41	A-13	
52	B-2		52	A-20		52	A-15	

OVEN B-10 IS A BUFFER SCHEDULED IN OPEN SLOTS @ AVG FCE/FDY C.T.

STEP 2

INTERIM SCHEDULE

PATTERN

=====		D-19	A-22
=====		B-8	A-24
=====		(B-10)	B-1
=====			B-3
=====		C-21	B-5
C-1		C-23	B-7
C-3		C-25	C-16
C-5		D-21	C-18
C-7		D-23	C-20
C-9		D-25	C-22
		=====	C-24
A-1		=====	
A-3		=====	B-9
A-5		=====	
A-7		=====	D-16
A-9		C-2	D-18
D-1		C-4	D-20
D-3		D-2	D-22
D-5		D-4	D-24
D-7		A-2	
D-9		A-4	=====
A-11		A-6	=====
A-13		A-8	=====
A-15		A-10	=====
A-17			=====
A-19		C-6	
		C-8	
C-11		C-10	
C-13		C-12	
=====		C-14	
=====		A-12	
=====		A-14	
=====		A-16	
=====		A-18	
C-15		A-20	
C-17			
C-19		D-6	
A-21		D-8	
A-23		=====	
A-25		=====	
B-2		=====	
B-4		=====	
B-6		=====	
		=====	
D-11		D-10	
D-13		D-12	
D-15		D-14	
D-17			

OVEN B-20 IS A BUFFER SCHEDULED IN OPEN SLOT @ AVG FCE/FDY C.T.
 (B-10) OLD BUFFER OVEN WILL HAVE TO BE MOVED TO ITS SLOT

STEP 2

INTERIM SCHEDULE

DAY 1

FIRST SHIFT			SECOND SHIFT			THIRD SHIFT		
TIME	F'DY	COKE	TIME	F'DY	COKE	TIME	F'DY	COKE
	FCE.	TIME		FCE.	TIME		FCE.	TIME
11:00	===B-14		7:03	D-7		3:06	A-2	
10	===B-16		13	D-9		16	A-4	
20	===B-18		23	A-11		27	A-6	
30	=====		33	A-13		37	A-8	
40	=====		43	A-15		47	A-10	
50	D-10		53	A-17		57		
12:00	D-12		8:03	A-19		4:07	C-6	
10	D-14		13			17	C-8	
20			23	C-11		27	C-10	
30	A-22		34	C-13		37	C-12	
40	A-24		44	===B-11		47	C-14	
50	B-1		54	===B-13		57		
1:00	B-3		9:04	===B-15		5:07	A-12	
10	B-5		14	=====		17	A-14	
21	B-7		24	=====		27	A-16	
31	C-16		34	C-15		37	A-18	
41	C-18		44	C-17		47	A-20	
51	C-20		54	C-19		58		
2:01	C-22		10:04	A-21		6:08	D-6	
11	C-24		14	A-23		18	D-8	
21			24	A-25		28	===B-12	
31	B-9		34	B-2		38	===B-17	
41			44	B-4		48	===B-19	
51	D-16		55	B-6		58	=====	
3:01	D-18		11:05			7:08	=====	
11	D-20		15	D-11		18	D-10	19:28
21	D-22		25	D-13		28	D-12	
31	D-24		35	D-15		38	D-14	
42			45	D-17		48		
52	=====		55	D-19		58	A-22	19:28
4:02	=====		12:05	B-8		9:08	A-24	
12	=====		15	(B-10)		19	B-1	
22	===B-22		25			29	B-3	
32	===B-24		35	C-21		39	B-5	
42	C-1		45	C-23		49	B-7	
52	C-3		55	C-25		59	C-16	
5:02	C-5		1:05	D-21		9:09	C-18	
12	C-7		16	D-23		19	C-20	
22	C-9		26	D-25		29	C-22	
32			36	=====		39	C-24	
42	A-1		46	=====		49		
52	A-3		56	=====		59	B-9	19:28
6:02	A-5		2:06	===B-21		10:09		
13	A-7		16	=====		19	D-16	19:28
23	A-9		26	C-2		29	D-18	
33	D-1		36	C-4		40	D-20	
43	D-3		46	D-2		50	D-22	
53	D-5		56	D-4				

OVEN B-20 IS A BUFFER SCHEDULED IN OPEN SLOT @ AVG FCE/FDY C.T.
 (B-10) OLD BUFFER OVEN WILL HAVE TO BE MOVED TO ITS SLOT

STEP 2

INTERIM SCHEDULE DAY 2

FIRST SHIFT			SECOND SHIFT			THIRD SHIFT		
TIME	F'DY	COKE	TIME	F'DY	COKE	TIME	F'DY	COKE
	FCE.	TIME		FCE.	TIME		FCE.	TIME
11:00	D-24	19:29	7:03	D-15	19:28	3:06	D-14	19:28
10			13	D-17		16		
20	===B-14	24:20	23	D-19		27	A-22	19:29
30	===B-16	24:20	33	B-8		37	A-24	
40	===B-18	24:20	43	(B-10)		47	B-1	
50	===B-23	29:12	53			57	B-3	
12:00	===B-25	29:12	8:03	C-21	19:28	4:07	B-5	
10	C-1	19:28	13	C-23		17	B-7	
20	C-3		23	C-25		27	C-16	
30	C-5		34	D-21		37	C-18	
40	C-7		44	D-23		47	C-20	
50	C-9		54	D-25		57	C-22	
1:00			9:04	===B-11	24:20	5:07	C-24	
10	A-1	19:28	14	===B-13	24:20	17		
21	A-3		24	===B-15	24:20	27	B-9	19:28
31	A-5		34	===B-22	29:12	37		
41	A-7		44	===B-24	29:12	47	D-16	19:28
51	A-9		54	C-2	19:28	58	D-18	
2:01	D-1		10:04	C-4		6:08	D-20	
11	D-3		14	D-2		18	D-22	
21	D-5		24	D-4		28	D-24	
31	D-7	19:28	34	A-2	19:28	38		
41	D-9		44	A-4		48	===B-12	24:20
51	A-11		55	A-6		58	===B-17	24:20
3:01	A-13		11:05	A-8		7:08	===B-19	24:20
11	A-15		15	A-10		18	===B-21	29:12
21	A-17		25			28	=====	
31	A-19		35	C-6	19:28	38	C-1	19:28
42			45	C-8		48	C-3	
52	C-11	19:29	55	C-10		58	C-5	
4:02	C-13		12:05	C-12		9:08	C-7	
12	=====		15	C-14		19	C-9	
22	=====		25			29		
32	=====		35	A-12	19:28	39	A-1	19:29
42	=====		45	A-14		49	A-3	
52	=====		55	A-16		59	A-5	
5:02	C-15	19:28	1:05	A-18		9:09	A-7	
12	C-17		16	A-20		19	A-9	
22	C-19		26			29	D-1	
32	A-21		36	D-6	19:28	39	D-3	
42	A-23		46	D-8		49	D-5	
52	A-25		56	=====		59	D-7	
6:02	B-2		2:06	=====		10:09	D-9	
13	B-4		16	=====		19	A-11	
23	B-6		26	=====		29	A-13	
33			36	=====		40	A-15	
43	D-11	19:28	46	D-10	19:28	50	A-17	
53	D-13		56	D-12				

OVEN B-20 IS A BUFFER SCHEDULED IN OPEN SLOT @ AVG FCE/FDY C.T.
 (B-10) OLD BUFFER OVEN WILL HAVE TO BE MOVED TO ITS SLOT

STEP 2

INTERIM SCHEDULE DAY 3

FIRST SHIFT			SECOND SHIFT			THIRD SHIFT		
TIME	F'DY	COKE	TIME	F'DY	COKE	TIME	F'DY	COKE
	FCE.	TIME		FCE.	TIME		FCE.	TIME
11:00	A-19	19:29	7:03	C-6	19:28	3:06	C-1	19:28
10			13	C-8		16	C-3	
20	C-11	19:28	23	C-10		27	C-5	
30	C-13		33	C-12		37	C-7	
40	===B-14	24:20	43	C-14		47	C-9	
50	===B-16	24:20	53			57		
12:00	===B-18	24:20	8:03	A-12	19:28	4:07	A-1	19:28
10	=====		13	A-14		17	A-3	
20	=====		23	A-16		27	A-5	
30	C-15	19:28	34	A-18		37	A-7	
40	C-17		44	A-20		47	A-9	
50	C-19		54			57	D-1	
1:00	A-21		9:04	D-6	19:28	5:07	D-3	
10	A-23		14	D-8		17	D-5	
21	A-25		24	===B-11	24:20	27	D-7	
31	B-2		34	===B-13	24:20	37	D-9	
41	B-4		44	===B-15	24:20	47	A-11	
51	B-6		54	=====		58	A-13	
2:01			10:04	=====		6:08	A-15	
11	D-11	19:28	14	D-10	19:28	18	A-17	
21	D-13		24	D-12		28	A-19	19:28
31	D-15	19:28	34	D-14	19:28	38		
41	D-17		44			48	C-11	19:28
51	D-19		55	A-22	19:28	58	C-13	
3:01	B-8		11:05	A-24		7:08	===B-12	24:20
11	(B-10)		15	B-1		18	===B-17	24:20
21			25	B-3		28	===B-19	24:20
31	C-21	19:28	35	B-5		38	=====	
42	C-23		45	B-7		48	=====	
52	C-25		55	C-16		58	C-15	19:28
4:02	D-21		12:05	C-18		9:08	C-17	
12	D-23		15	C-20		19	C-19	
22	D-25		25	C-22		29	A-21	
32	=====		35	C-24		39	A-23	
42	=====		45			49	A-25	
52	=====		55	B-9	19:28	59	B-2	
5:02	===B-23	29:12	1:05			9:09	B-4	
12	===B-25	29:12	16	D-16	19:29	19	B-6	
22	C-2		26	D-18		29		
32	C-4		36	D-20		39	D-11	19:28
42	D-2		46	D-22		49	D-13	
52	D-4		56	D-24		59	D-15	
6:02	A-2		2:06			10:09	D-17	
13	A-4		16	=====		19	D-19	
23	A-6		26	=====		29	B-8	
33	A-8		36	=====		40	(B-10)	
43	A-10		46	===B-22	29:12	50		
53			56	===B-24	29:12			

OVEN B-20 IS A BUFFER SCHEDULED IN OPEN SLOT @ AVG FCE/FDY C.T.
 (B-10) OLD BUFFER OVEN WILL HAVE TO BE MOVED TO ITS SLOT

OPTION FDY DS

PATTERN

=====		
=====		
C-1	B-14	C-16
C-3	B-16	C-18
C-5	B-18	C-20
C-7		C-22
C-9	C-21	C-24
A-1	C-23	
A-3	C-25	B-9
A-5	D-21	B-11
A-7	D-23	B-13
A-9	D-25	B-15
	=====	B-17
	=====	B-19
D-1	C-2	
D-3	C-4	D-16
D-5	D-2	D-18
D-7	D-4	D-20
D-9	A-2	D-22
	A-4	D-24
A-11	A-6	
A-13	A-8	=====
A-15	A-10	=====
A-17		
A-19	C-6	
	C-8	
C-11	C-10	
C-13	C-12	
C-15	C-14	
C-17	A-12	
C-19	A-14	
A-21	A-16	
A-23	A-18	
A-25	A-20	
B-2		
B-4	D-6	
B-6	D-8	
	D-10	
D-11	D-12	
D-13	D-14	
D-15		
D-17	A-22	
D-19	A-24	
B-8	B-1	
B-10	B-3	
B-12	B-5	
	B-7	
=====		

OVEN B-20 IS A BUFFER SCHEDULED IN OPEN SLOTS @ AVG FCE/FDY C.T.

OPTION FDY DS

DAY 1

FIRST SHIFT			SECOND SHIFT			THIRD SHIFT		
TIME	F'DY	COKE	TIME	F'DY	COKE	TIME	F'DY	COKE
	FCE.	TIME		FCE.	TIME		FCE.	TIME
11:00	===B-22		7:00	B-14		3:00		
11	===B-24		11	B-16		11	C-16	
21	C-1		21	B-18		21	C-18	
32	C-3		32			32	C-20	
42	C-5		42	C-21		42	C-22	
53	C-7		53	C-23		53	C-24	
12:03	C-9		8:03	C-25		4:03		
14	A-1		14	D-21		14	B-9	
24	A-3		24	D-23		24	B-11	
35	A-5		35	D-25		35	B-13	
45	A-7		45	===B-21		45	B-15	
56	A-9		56	=====		56	B-17	
1:06			9:06	C-2		5:06	B-19	
17	D-1		17	C-4		17		
27	D-3		27	D-2		27	D-16	
37	D-5		37	D-4		37	D-18	
47	D-7		47	A-2		47	D-20	
58	D-9		58	A-4		58	D-22	
2:08			10:08	A-6		6:08	D-24	
19	A-11		19	A-8		19		
29	A-13		29	A-10		29	====B-23	
40	A-15		40			40	====B-25	
50	A-17		50	C-6		50	C-1	19:29
3:01	A-19		11:01	C-8		7:01	C-3	
11			11	C-10		11	C-5	
22	C-11		22	C-12		22	C-7	
32	C-13		32	C-14		32	C-9	
43	C-15		43			43	A-1	
53	C-17		53	A-12		53	A-3	
4:03	C-19		12:03	A-14		8:03	A-5	
13	A-21		13	A-16		13	A-7	
24	A-23		24	A-18		24	A-9	
34	A-25		34	A-20		34		
45	B-2		45			45	D-1	19:28
55	B-4		55	D-6		55	D-3	
5:06	B-6		1:06	D-8		9:06	D-5	
16			16	D-10		16	D-7	
27	D-11		27	D-12		27	D-9	
37	D-13		37	D-14		37		
48	D-15		48			48	A-11	
58	D-17		58	A-22		58	A-13	
6:08	D-19		2:08	A-24		10:08	A-15	
18			18	B-1		18	A-17	
29	B-8		29	B-3		29	A-19	
40	B-10		40	B-5		40		
50	B-12		50	B-7		50	C-11	19:28

OVEN B-20 IS A BUFFER SCHEDULED IN OPEN SLOTS @ AVG FCE/FDY C.T.

OPTION FDY DS

DAY 2

FIRST SHIFT			SECOND SHIFT			THIRD SHIFT		
TIME	F'DY	COKE	TIME	F'DY	COKE	TIME	F'DY	COKE
	FCE.	TIME		FCE.	TIME		FCE.	TIME
11:00	C-13	19:28	7:00	C-14	19:28	3:00	C-9	19:28
11	C-15		11			11	A-1	
21	C-17		21	A-12	19:28	21	A-3	
32	C-19		32	A-14		32	A-5	
42	A-21		42	A-16		42	A-7	
53	A-23		53	A-18		53	A-9	
12:03	A-25		8:03	A-20		4:03		
14	B-2		14			14	D-1	19:29
24	B-4		24	D-6	19:29	24	D-3	
35	B-6		35	D-8		35	D-5	
45			45	D-10		45	D-7	
56	D-11	19:29	56	D-12		56	D-9	
1:06	D-13		9:06	D-14		5:06		
17	D-15		17			17	A-11	19:29
27	D-17		27	A-22	19:29	27	A-13	
37	D-19		37	A-24		37	A-15	
47			47	B-1		47	A-17	
58	B-8	19:29	58	B-3		58	A-19	
2:08	B-10		10:08	B-5		6:08		
19	B-12		19	B-7		19	C-11	19:29
29	B-14		29			29	C-13	
40	B-16		40	C-16	19:29	40	C-15	
50	B-18		50	C-18		50	C-17	
3:01			11:01	C-20		7:01	C-19	
11	C-21	19:29	11	C-22		11	A-21	
22	C-23		22	C-24		22	A-23	
32	C-25		32			32	A-25	
43	D-21		43	B-9	19:29	43	B-2	
53	D-23		53	B-11		53	B-4	
4:03	D-25		12:03	B-13		8:03	B-6	
13	===B-22	29:13	13	B-15		13		
24	===B-24	29:13	24	B-17		24	D-11	19:28
34	C-2	19:28	34	B-19		34	D-13	
45	C-4		45			45	D-15	
55	D-2		55	D-16	19:28	55	D-17	
5:06	D-4		1:06	D-18		9:06	D-19	
16	A-2		16	D-20		16		
27	A-4		27	D-22		27	B-8	19:29
37	A-6		37	D-24		37	B-10	
48	A-8		48			48	B-12	
58	A-10		58	===B-21	29:13	58	B-14	
6:08			2:08	=====		10:08	B-16	
18	C-6	19:28	18	C-1	19:28	18	B-18	
29	C-8		29	C-3		29		
40	C-10		40	C-5		40	C-21	19:29
50	C-12		50	C-7		50	C-23	

OVEN B-20 IS A BUFFER SCHEDULED IN OPEN SLOTS @ AVG FCE/FDY C.T.