
	Work Instruction	
	Green Production	
Revision: 00	Procedure No.: WI-8.2.4.44	Date Effective: 6/11/2012

## General Guideline for Green Production Stage

1. Pour slip into plaster mold(s). Barrier ring(s) may be used to confine slip to certain areas of the mold
2. Wait appropriate time for thickened slip to collect on plaster mold
3. Pour out excess slip from mold(s). If making hollow body heaters, it may be necessary to perform this step at different times for each part of the mold for the same heater
4. Embed coil into clay using grooves as a guideline. It may be necessary to bend wires, place thickened clay on coil/leadwire, and adjust coil stretch to make coil fit mold
5. Apply thermocouple (if necessary)
6. For hollow heaters, put ceramic fiber in place
7. Assemble top mold piece(s) onto bottom mold piece. Ensure wires are in proper position and mold pieces fit completely. Apply slip as necessary for hollow heaters to mate heater sections together
8. For solid heaters, fill mold completely with slip
9. Temporarily fasten mold sections together
10. After appropriate amount of time, check and remove clay heater from mold
11. Lightly clean seam edges as is convenient
12. Clean mold
13. After heaters dry somewhat, finish cleaning all seam edges
14. Allow heaters to dry. Plastic may be used at the discretion of the supervisor or manager to keep heaters from drying too fast

### Revision History

Revision Level	Date of Revision	Sections	Description of Change	Initial
00	6/11/2012	All	Initial Release	TCH

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### Authorization

Position	Held By	Signature
Product Manager	Thomas Hittie	<i>Thomas Hittie</i>
Senior Management Representative	Abraham Joseph	<i>Abraham Joseph</i>