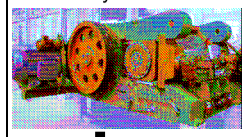
CONVENTIONAL PROCESS FLOW CHART

Section	Step	Name	Remark / Condition
PRIMARY CLAY PREPARATION	1	Incoming Raw Materials	Primary preparation needed when raw material size is big
	2	Boxfeeder 1 	Input Size: <500x300x200mm Clay Moisture: 10~20%
	3	Double Roller Crusher 	Output Size: <50x30x30mm
	4	Boxfeeder 2 	When Boxfeeder 2 is full, divert to stock pile

Section	Step	Name	Remark / Condition
SECONDARY CLAY PREPARATION	7	Boxfeeder 2 & 3 	2 Boxfeeders to proportionate mixing of 2 type of raw materials Example clay + sand
	8	Wet Pan Mill 	Water Addition Clay moisture 16% Output Size: <=40x15mm
	9	Preliminary Roller Mill 	First crushing step Output Size: <=2~3mm
	10	Fine Roller Mill 	Second crushing step Output Size: <=0.8~1mm
	11	To Aging stockyard 	Natural aging in stockyard for >72hr

Section	Step	Name	Remark / Condition
BRICK SHAPING & SETTING	14	Bucket Reclaimer 	Transport processed materials to FORMING department
	15	Boxfeeder 4 	Buffering Boxfeeder between stockyard and forming section
	16	Tertiary Roller Mill 	Breakup dried materials (This step is not necessary if processed materials can be kept wet)
	17	Circular Screen Feeder 	Water Addition & Mixing
	18	Deairing Mixer & Extruder 	Final mixing & deairing Stiff extrusion: Clay Moisture 14~16% Semi/soft extrusion: Clay Moisture 20~24%
		Brick Cutting 	Cutting of clay slug into green product
		Brick Setting 	Setting of green product onto kiln car directly (stiff extrusion) or dryer car (semi/soft extrusion)

Section	Step	Name	Remark / Condition
KILN CAR TRANSFER, DRYING, FIRING AND UNLOADING	14	Kiln Car Transport 	For transfering of kiln car or dryer car
	15	Tunnel Dryer 	Final drying of green product
	16	Tunnel Kiln 	Firing of dried product
	17	Dehacking 	Unloading of fired product