



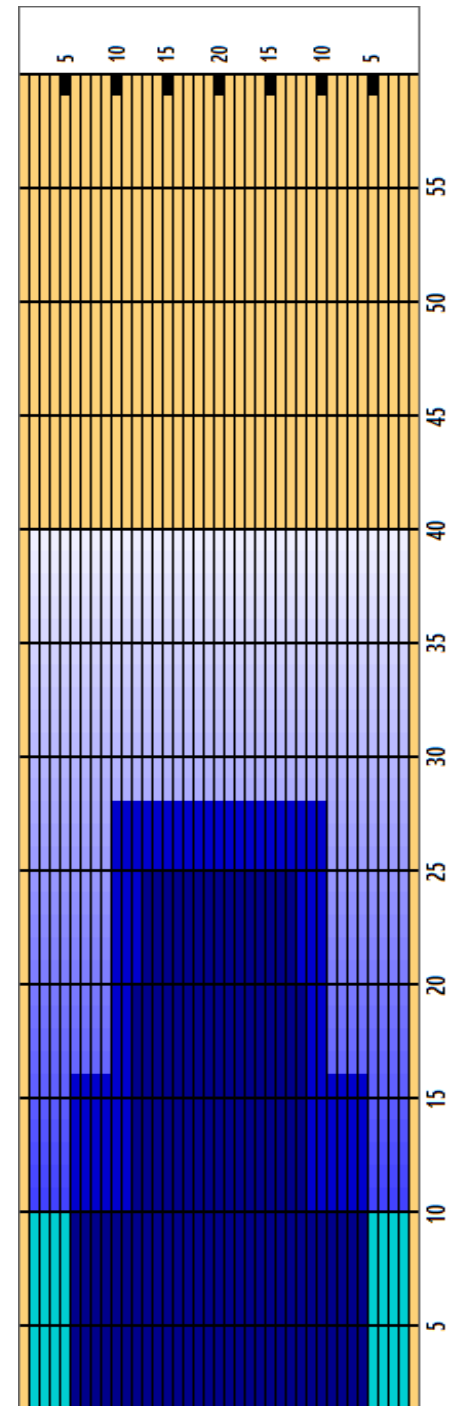
2021 IHSB Practice Pattern (ALL SITES)



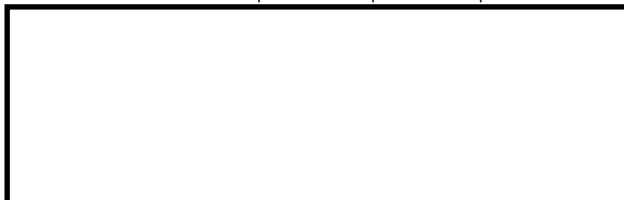
Oil Pattern Distance	40	Reverse Brush Drop	40	Oil Per Board	50 ul
Forward Oil Total	14.15 mL	Reverse Oil Total	12.1 mL	Volume Oil Total	26.25 mL
Tank Configuration	N/A	Tank A Conditioner	N/A	Tank B Conditioner	N/A

	START	STOP	LOADS	SPEED	BUFFER	TANK	CROSSED	START	END	FEET	T.OIL
1	2L	2R	5	18	3	A	185	0.0	10.2	10.2	9250
2	12L	12R	4	18	3	A	68	10.2	20.4	10.2	3400
3	13L	13R	2	18	3	A	30	20.4	25.5	5.1	1500
4	2L	2R	0	18	3	A	0	25.5	40.0	14.5	0

	START	STOP	LOADS	SPEED	BUFFER	TANK	CROSSED	START	END	FEET	T.OIL
1	2L	2R	0	30	3	B	0	40.0	28.0	-12.0	0
2	10L	10R	6	14	3	B	126	28.0	16.1	-11.9	6300
3	6L	6R	4	14	3	B	116	16.1	8.2	-7.9	5800
4	2L	2R	0	14	3	B	0	8.2	0.0	-8.2	0



Cleaner Ratio Main Mix: NA Forward
 Cleaner Ratio Back End Mix: NA Reverse
 Cleaner Ratio Back End Distance: NA Combined
 Buffer RPM: 4 = 700 | 3 = 500 | 2 = 200 | 1 = 100



Item	3L-7L:18L-18R	8L-12L:18L-18R	13L-17L:18L-18R	18L-18R:17R-13R	18L-18R:12R-8R	18L-18R:7R-3R
Description	Outside:Middle	Middle:Middle	Inside:Middle	Middle: Inside	Middle:Middle	Middle:Outside
Track Zone Ratio	3:18	1:57	1	1	1:57	3:18

