MAKING INSTRUCTIONS: BATCH UNIT

S.V. 107 (102) C.V. 207 D.V. 313, 322, 330

CG 36 CODE RT-695-D PKG. _____

→ SEP-5-80 37026

EST. WGT. 1350 LBS.

STD. HRS. _____ TIME 3PM

PROCESSES		APPROVED BY
( )	( )	
( )	( )	
( )	( )	
( )	( )	
TYPED BY		

DO NOT USE N-740-C Lots 530R66 or 100

Note: take 1 qt sample each lot N-740-C & N-253C. Record lot on label

NON-BLEEDING

QUIPMENT		NAME: "BON" RED DARK	USE LBS.	N CODE	ACCT. LBS.
Prep 1	1	If necessary, clean, dress sparkler & pre-coat with 15#		777-A	
	2	Obtain for S 6		740-C	
	3	Obtain for 32B		253-C	
313 2	4	Run 25" (370G) water into V-313			
	5	Weigh & pour in	200	7-D	98
	6	Turn on agitator & steam & dump in from S 2	510	740-C	~~[illegible]~~ 502
		USE LOTS Lot 100% %			
		530 66 54 98.5			
	7	Dump in	23	113-B	23
	8	Dump in	5	777-A	5
	9	Heat to 212-214°F WATCH FOAM			
	10	Record: BY 7 (+), if necessary adj to + BY Assume 50%		7-D	
	11	Stir 30 min. at 212-214°F, then shut off steam WATCH FOAM			
	12	Circulate 15 min or longer thru Sparkler until sol'n is clear			
		Maintain at 190-195°F for S14 Record: HT 200 °F			
		& Recorder 204 °F			
		Record: Start 900 Total Min 15 Clarity ok			
~~[illegible]~~ 3 207	13	Run 1" (125G) water into V-~~[illegible]~~ 207			
	14	When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at			
		190-195°F. Record: Start 915 Total Min 50 Sample-From Hose			
		Show to supervisor for OK			
	~~15~~	~~Weigh [illegible] Lot~~		~~[illegible]~~	
322 4	16	Run in 2" (66G) water into V-322			
	17	Weigh in plastic lined Drums & Pour in & hold for S 28			
		M 31.62 %	639	28-D	202
313 5	18	When S14 complete, close V-313 outlet & stop pump			
	19	Run in 13" (192G) water & heat to 180-190°F			
		Circulate thru Syarkler until sol'n is clear.			
~~[illegible]~~ 6 207	20	Pump V 313 thru Sparkler into V-~~[illegible]~~ 207 (Sample)			
	21	When MTY-blow out Sparkler into V-~~[illegible]~~ 207			
	22	RECORD: VOLUME 12 "			
	23	Heat to 165-170°F Take (1 qt sample)			
		Show 1 qt sample to shift supervisor for approval. (Example			
		of acceptable clarification of N-740-C is available in office			
		to compare to) Take sample with agitation			
	24	If S-23 if OK, continue with S-25. If 2-23 is not acceptable			
		re-clarify thru sparkler.			

K 13829 REV.

EQUIPMENT		PAGE 2 CG 36 CODE RT-695-D EST. WGT. 1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
207	25	~~Run 1" (69G) water into V-207~~			
7	26	~~If [illegible] OK, pump V-330 at 165-170°F into V-207~~			
	27	Heat V-207 to 165-170°F RECORD: VAT 13" (also 1 pt sample)			
	28	Run in V-322, N-28-D, from S17 & rinse in			
	29	Adj to 33" (2277G) at 32-38°F	27x330	57-A	
322	30	Run in 22" (755G) water into V-322			
8	31	Weigh & Pour in M .48.04%	[illegible]	7-D	239
	32	Dump in from S3 Lot		253-C	[illegible]
		497			425
	33	Weigh on postal scale & add Lot 40804	9	180-C	9
	34	Heat to 70-90°F			
	35	Sift in in 1-2 min	12	567-B	12
	36	Weigh on postal scale & stir to dissolve	4	479-D	4
100	37	Run in 14" (1391G) water into V-100			
9	38	Turn on agitator & steam and dump in	650	336-B	650
	39	Dump in	200	65-A	200
	40	Heat to 150-160°F & stir to dissolve N-336-B			
	41	Record: pH 5.9 (5.0-5.5)			
	42	If pH above 5.5, adj to pH 5.5 or lower Assume 78%	1/2	27-D	1
		Record: pH 5.2			
		NOTE: If pH below 5.0, do not adj upward			
	43	Hold for S 49			
302	44	Weigh and pour into V-302 for S 47 M .33.12%	501	725-A	166
10					
322	45	Adj V-322 to 30" (1031) at 77-80°F RECORD TEMP 80 °F			
11	46	Slurry with 30 Gal water in drum, pour in & stir 5 min	73	39-A	73
207	47	Run in N-725-A from S44 AFAP into V-207			
12	48	Stir 30 min at 32-38°F maintaining + Cr, +KI		57-A	
		Record: Time Start 11:55 AM CR — KI + TEMP 35 °F			
		NOTE:			
		(1) If CR-, KI-, add 20# "as is" increments Assume 32%		28-D	
		RECORD: CR (+), KI (+)			
		(2) If CR+, KI-, add 20# "as is" increments As sume 33%		725-A	
		RECORD: CR (+), KI (+)			
	49	Couple V-322 thru under surface distributor into V-207 in			
		40-45 min Record: Start 12:25 AM Total min 41			
	50	When S 49 complete, stir 15 min			
		Record: DIAZO — (-); BASE + (+); pH 11.1 (11.0-11.8) TEMP 64 °F			
		NOTE: (1) If pH is 5.0-7.0, weigh & dump in 15# "as is" N-7-D AFAP		7-D	
		Assume 50% Record: pH			
	~~51~~	~~If necessary, adj to pH [illegible].8~~ ~~Assume 50%~~		~~7-D~~	
		~~Record: pH~~ ~~Assume 33%~~		~~28-D~~	
	52	Adj to pH ~~[illegible]~~ 8.2-8.6 Assume 32%	40	28-D	14
		Record: pH 8.5 Assume 50%		7-D	
		NOTE: Add N-7-D in 20# "as is" increments to approach pH 8.2-8.6 Then use less N-28-D			

USE ONLY DILUTED N-7-D
OR N-28-D FOR pH ADJ.

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EQUIPMENT		PAGE 3 CG 36 CODE RT-695-D EST. WGT. 1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
10	53	During S 49, heat to 210-212°F & shut off steam			
12		NOTE: If necessary, reheat V-107 to 210, 212°F			
		Prior to start of strike			
	54	Pump V-207 into V-107 in 60-65 min. Let V-107 temp drop to			
		200-205°F, then maintain at 200-205°F for balance of strike			
		Record: Start 1:45 AM Total min 70			
	55	When strike complete heat to 210-212°F			
	56	Stir 15 min at 210-212°F			
	57	Flood to 87" (8648G). Record: pH 6.6 (6.5-7.2)			
	58	Stop agitator			

Start	Fin	Optr
600 P	1100 P	259-32
[illegible]	[illegible]	[illegible]

K 13830 REV.

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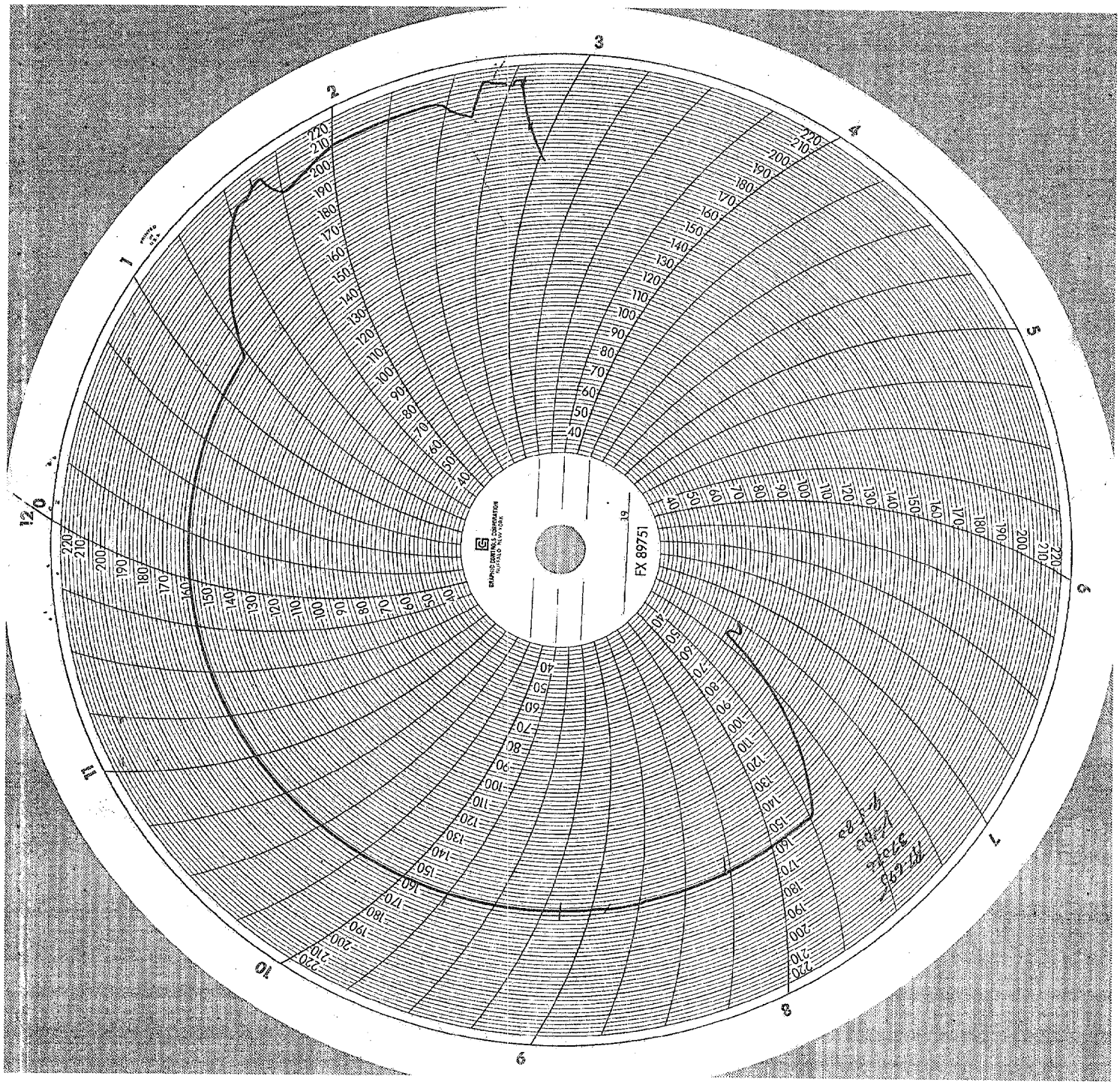
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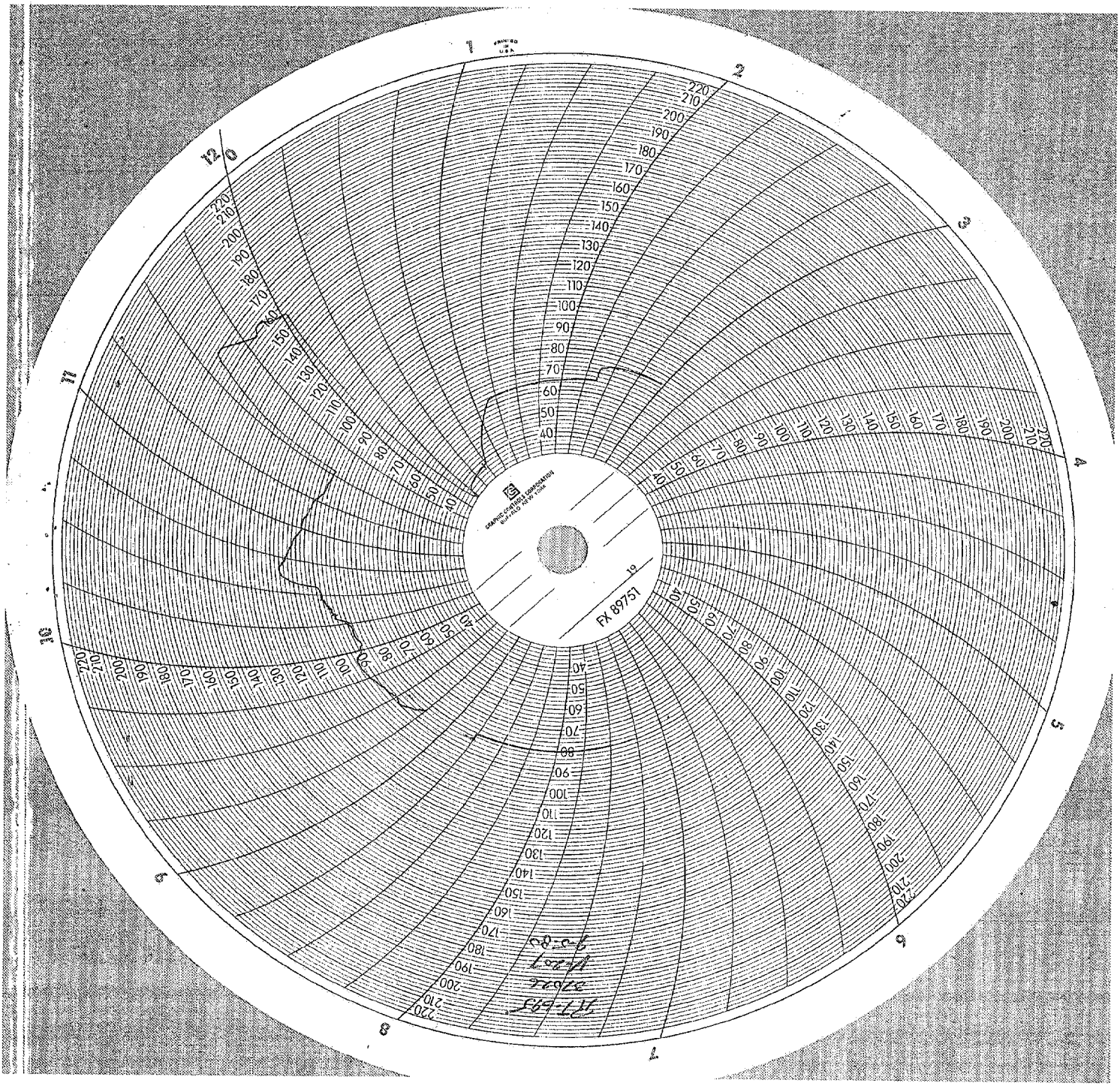

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