V. (107) C.V. 100 D.V. 330, 322

CG 36 CODE RT-695-D PKG. _____

→ NOV 24 32935

EST. WGT. 2781 LBS.

STD. HRS. _____ TIME _____ M 7AM 9 JS

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

NOV 25 1979

NON-BLEEDING

UIPMENT		NAME: "BON" RED DARK	USE LBS.	N CODE	ACCT LBS.
RED 1	1	If necessary, clean, dress Sparkler & pre-coat with 15#		777-A	
2	2	Obtain for S 6		740-C	
3	3	Obtain for S 34		82-C	
330 2	4	Run 42" (823G) water into V-330			
	5	Weigh & POUR IN M 11, 49.29%	436	7-D	215
	6	Turn on agitator & steam & dump in from S 2		740-C	1162
		Lot 100% %			
		951 963 98.73	935		
		956 130 98.46	132		
1 39		946 9 98.63	9		
	7	Pump in	30	113-B	50
	8	Dump in	10	777-A	10
	9	Heat to 212-214°F WATCH FOAM			
	10	Record: BY — (+), 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 S 14 & Record: HT 195 °F			
		& Recorder 194 °F			
		Record: Start 10:20 Total Min 15 Clarity Clear			
100 3	13	Run 1" (99G) water into V-100	R+D		
	14	When S 12 complete, pump in V-330 thru Sparkler. Maintain			
		V-330 at 190-195°F. Record: Start 9:30 Total Min 30 SAMPLE FROM HOSE-SHOW TO SUPERVISOR FOR OK			
	15	WEIGH ON POSTAL SCALE & ADD TO LOT 932	2 #	584-C	2 #
330 4	16	WHEN S14 COMPLETE, CLOSE V-330 OUTLET & STOP PUMP			
	17	RUN IN 22" (431G) WATER & HEAT TO 180-190°F			
1-100 5	18	PUMP V-330 THRU SPARKLER INTO V-100			
	19	WHEN AT BLOW OUT SPARKLER INTO V-100			
	20	ADJ TO 16" (1590G)			
	21	HEAT TO 165-170°F (TAKE 1 QT SAMPLE)			
	22	SHOW 1 QT SAMPLE TO SHIFT SUPERVISOR FOR APPROVAL. (EXAMPLE OF ACCEPTABLE CLARIFICATION OF N/TND-C IS AVAILABLE IN OFFICE TO COMPARE TO.) - TAKE SAMPLE WITH AGITATION	R+D		
		IF S-23 IS OK, CONTINUE WITH S-23.			
		IF S-23 IS NOT ACCEPTABLE, RE-CLARIFY THRU SPARKLER			
	23	RUN IN FROM V-324 THRU DIRECT M 6, 31.03%	1388	28-D	443
	24	LINES RINSE IN ↓ after 15 MIN AT 165-170°F	55	330	57-A
		ADJ TO 50" (4970G) AT 28-32°F ↑ RECORD: TEMP 30 °F			

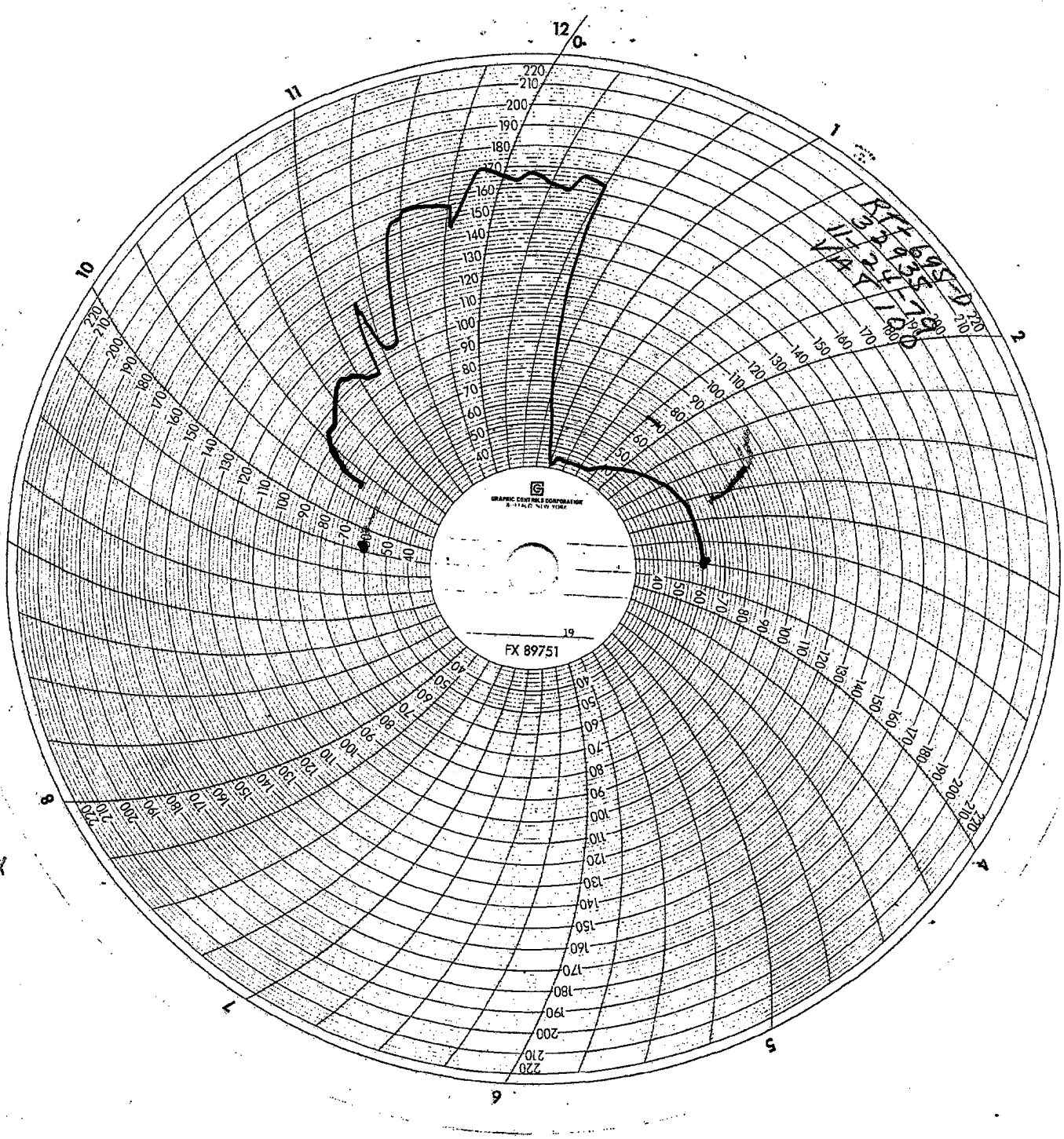
UIPMENT		PAGE 2 CG 36 CODE RT-695-D EST. WGT. 2781 LBS.	USE LBS.	N CODE	ACCT LBS.
07	30	RUN 25" (2400G) WATER INTO V-107			
7	31	TURN ON AGITATOR & STEAM & DUMP IN	1400	336-B	1400
	32	DUMP IN	250	65-A	250
	33	HEAT TO 150-160°F & STIR			
	34	RECORD: pH 6.0 (5.0-5.5)			
	35	IF pH ABOVE 5.5, ADJ TO pH 5.5 OR LOWER ASSUME 78%	/	27-D	—
		RECORD: pH 2.3			
		NOTE: IF pH BELOW 5.0, DO NOT ADJ UPWARD			
	37	HOLD FOR [illegible] S47			
322	32	RUN IN 47" (1610G) WATER INTO V-322			
4	33	WEIGH & POUR IN M 11, 49.29%	[illegible]	7-D	532 ~~525~~
	34	DUMP IN FROM S3 LOT	750	82-C	~~935~~ 968
		2665	156		
		2728	62		
		2665 LOT 90703			
	35	WEIGH & ADD	18	180-C	18
	36	HEAT TO 70-90°F			
	37	SLIT IN IN 1-2 MIN	27	567-B	27
	38	DUMP IN & STIR 5 MIN OR LONGER TO DISSOLVE	8	479-D	8
2/330	39	WEIGH & POUR INTO V330 FOR S42 M 16, 32.68%	[illegible]	725-A	~~350~~ 365
6					
22	40	ADJ V322 TO 65" (2240G) AT 70-80°F			
7	41	SLURRY WITH 30 GAL WATER IN DRUM, POUR IN & STIR 5 MIN	160	39-A	160
100	42	RUN IN N-725-A FROM S30 AFAP INTO V-100			
8	43	STIR 30 MIN AT 32-38°F MAINTAINING + CR + KI	—	57-A	—
		Record: Time Start [illegible], CR —, KI —			
		NOTE: 1. If CR -, KI - add 20# asis increments Assume 32%		28-A	
		Record: CR (+), KI (+)			
		2. If CR +, KI - add 20# asis increments Assume 33%		725-A	
		Record: CR (+), KI (+), Temp °F			
	44	COUPLE V322 THRU UNDERSURFACE DISTRIBUTOR INTO V-100 IN 90-110 MIN (use 9/16" ORIFICE)			
		RECORD: START 1:35 A TOTAL MIN 70			
	45	WHEN S44 COMPLETE STIR 5 MIN			
		RECORD: DIAZO — (-); BASE + (+); pH 11.7 (11.4-11.8)			
		Note: IF pH IS 5.0-7.0, WEIGH & DUMP IN 30# "AS IS" N-7-D AFAP ASSUME 50%	—	7-D	—
		RECORD: pH —			
		2. IF NECESSARY, ADJ TO pH 11.4-11.8 ASSUME 50%	—	7-D	—
		RECORD: pH — ASSUME 32%	—	28-D	—
	46	ADJ TO pH ~~[illegible]~~ 10.2-10.6 ASSUME 32%	80	28-D	26
		RECORD: pH 10.3 ASSUME 50%		7-D	
		Note: ADD N-28-D IN 5# "AS IS" INCREMENTS TO APPROACH pH ~~[illegible]~~ 10.2-10.6 THEN USE LESS N-28-D			

Note Very important not to over adjust below 10.2. Masstone goes too light

DUP050292394

QUIPMENT		PAGE 2 CG 36 CODE RT-695-D EST. WGT. 2781 LBS.	USE LBS.	N CODE	AC LB
107 9	47	DURING S44 HEAT V-107 TO 210-212°F & SHUT OFF STEAM			
		NOTE: IF NECESSARY, REHEAT V-107 TO 210-212°F PRIOR TO START OF STRIKE			
	48	PUMP V-100 INTO V-107 IN 70-75 MIN. LET V-107 TEMP DROP TO 200-205°F DURING STRIKE THEN MAINTAIN AT 200-205°F FOR BALANCE OF STRIKE			
		RECORD: START 3:35 A TOTAL MIN 190			
	49	WHEN STRIKE COMPLETE, HEAT TO 210-212°F			
	50	STIR 15 MIN AT 210-212°F			
	51	FLOOD TO 180-190" (18,240 G). RECORD: pH 7.0 (6.5-7.2) & STOP AGITATOR			
		SAMPLE			
		START FIN OPTIR			
		1:45 P.M. 3:P.M. 54			
		11:05 P.M. 4:30 A 27			
		4:30 A 7:00 A 244			
		8:30 8:30			
		Delayed 3 HRS YT-828 Clarifying			
		Vat 107 Pressing			
		Rec'd Vat 107 8:30 [illegible]			

DUP050292395



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DUP050292396

MD-3-A

PACKAGE TICKET (DRY AND PASTE ONLY)

CODE AT625 LOT 32935

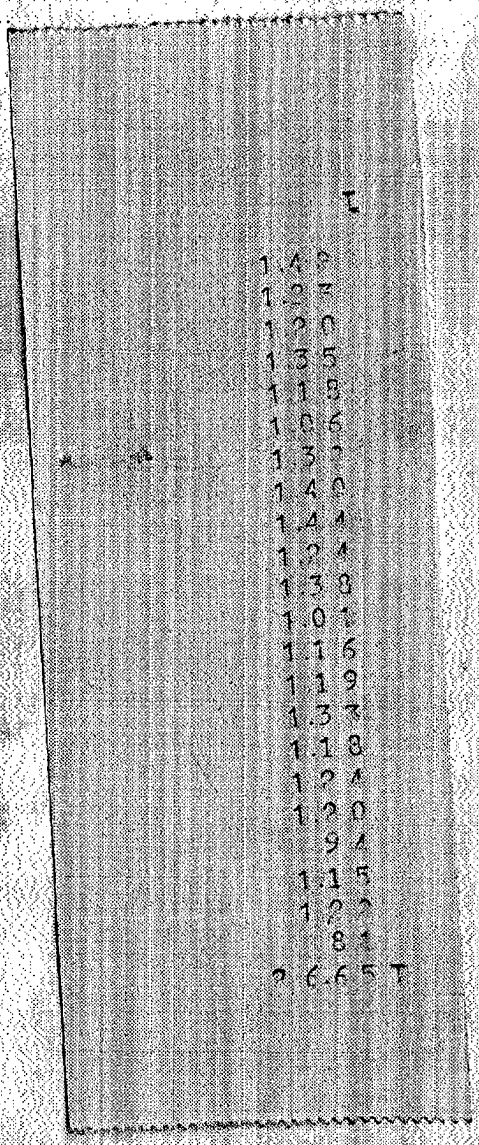
NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PQ
	22	2665	8-60	
	STUMP			

TOTAL NET WT. 2665 PKG. N-CODE

PROD. SPVR.	DATE	WHSE. OPER.
[illegible]	4/31	[illegible]

N 31830.02

DUP050292397



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DUP050292398

5/107

CG 36 CODE RT-695-D PKG. ____

→ NOV24 32935

EST. WGT. 2781 LBS.

PROCESSING INSTRUCTIONS: BATCH UNIT

PROCESSES	APPROVED BY
TYPED BY	

MAKING NOTES

REMARKS

NAME: "BON" RED DARK — NON-BLEEDING

INSTRUCTIONS						-PRESSING-	RECORD					
VAT	107					PRESSLOAD	1ST	2ND	3RD	4TH	5TH
DATE	11-25-79					STARTED	12 PM				
TIME	8:15AM					CAKES USED					
RELEASED BY						WATER ON	9:30				
PRESS	32	33	35	37		HRS. WASHED	13			4	
NO. OF CAKES	60	60	60	60		OHMS	4700				
PRESS WITHOUT AGITATION						HRS. WASHED					
WASH TO 4000 OHMS						OHMS					
TEST AFTER 16 HOURS with 35-75 F water						HRS. WASHED					
LOAD on 8 cars						OHMS					
						CAKE CONDITION					
CLEAN PUMP STRAINER & MAGNETIC						NO. CARS LOADED	6				
SEPERATOR AFTER FILLING						EXPLAIN LOSSES					
CLEAN: BY 375 TIME 930											
SAMPLES											
DELIVER TO						SAMPLED BY		RELEASED BY			

-DRYING-

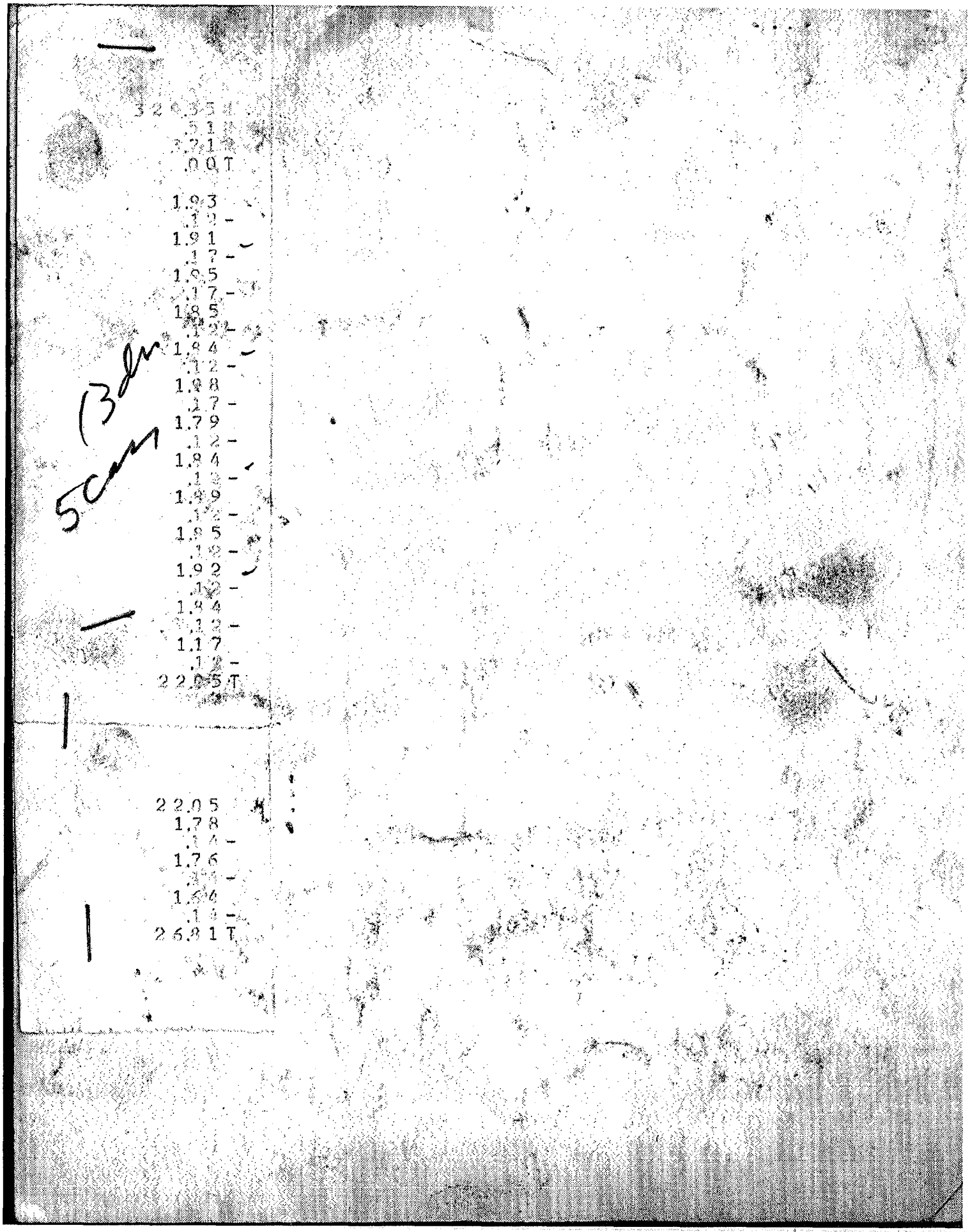
~~XXXXX~~ XXX XXX	LUMP: - OK - WET - SALTS - CONTAMINAT
~~XXXX~~ XXX XXX	
DRY 12 HOURS AT 220 F	
DRY 12 HOURS AT 180 F	
Mn COLOR	ADDITIONAL DRYING HOURS REQUIRED
	NO. DRUMS 16
SAMPLES	NO. CARS PULLED LUMP WGT. 2681
DELIVER TO	SAMPLED BY RELEASED BY

-GRINDING-

MILL 4 HSP 1/8" RP SCREEN 4600 RPM	SCREEN RPM
MAX. TEMP. 170 °F	MAX. TEMP. °F
MN COLOR	EXPLAIN LOSSES
SAMPLE ~~XXXXXX~~ WITHOUT MIXING	DATE MIXED 11-30-79
SAMPLES 1 ENV & 3 PT CANS	
DELIVER TO CTL	SAMPLED BY 447 RELEASED BY

DUP050292399

N 31830.04



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