V. 107 C.V. 207 D.V. 313 322 330

CO 36 CODE RT-695-D PKG. _____

JAN 29 34085

EST. WGT. 1350 LBS.

ATD. MRS. _____ TIME 7 AM

993

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

R+D will follow — PRECOAT SPARKLER

NON-BLEEDING

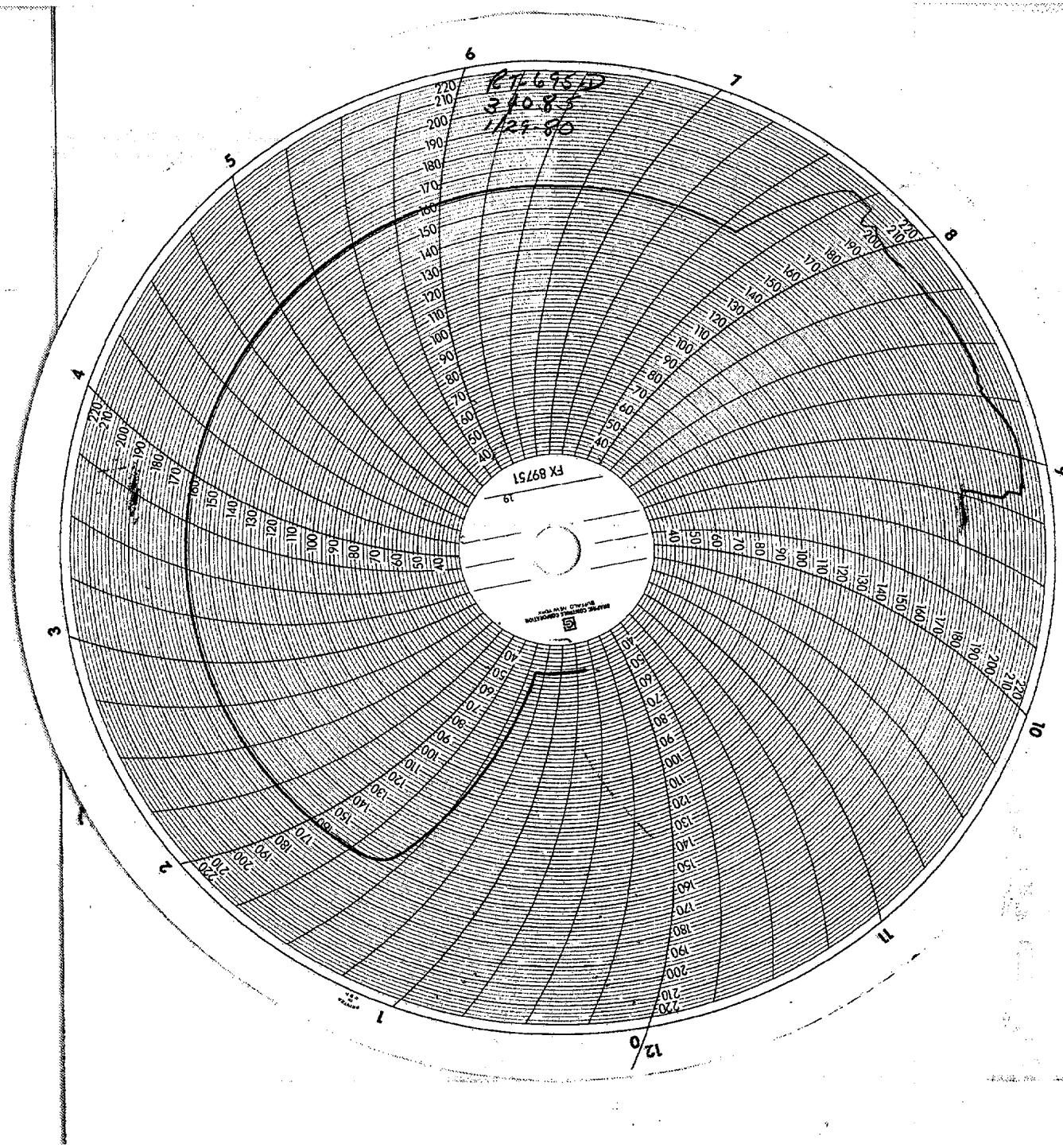
IPMENT		NAME: BON RED DARK	USE LBS.	N CODE	ACCT. LBS.
Prep 1	1	If necessary, clean, dress Sparkler & pre-coat with 15#		777-A	
	2	Obtain for S 6		740-C	
	3	Obtain for S 28		82-C	
13	4	Run 25" (370 G) water into V-313			
	5	Weigh & POUR IN M 2, 47.46%	198	7-D	98
2	6	Turn on agitator & steam & dump in from S 2		740-C	500
		Lot 100% %			
		990 500 98.32	509		
	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 ___ (+), 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 °F			
		& Recorder 202 °F			
		Record: Start 10.22 AM Total Min 21 Clarity OK			
30	13	RUN 1" (125G) WATER INTO V-330			
3	14	WHEN S-12 COMPLETE, PUMP V-313 THRU SPARKLER. MAINTAIN V-313 AT 190-195°F. RECORD: START 10.43 TOTAL MIN 12 SAMPLE-FROM HOSE-SHOW TO SUPERVISOR FOR OK / R+D			
	15	WEIGH ON POSTAL SCALE & ADD LOT 282	2	58H-C	2
22	16	RUN IN 2" (66 G) WATER INTO V-322			
4	17	WEIGH IN PLASTIC LINED M 1, 31.76%	636	28-D	202
		DRUMS & POUR IN & HOLD FOR S 28			
13	18	WHEN S14 COMPLETE, CLOSE V-313 OUTLET & STOP PUMP			
5	19	RUN 43" (192G) WATER & HEAT TO 180-190°F			
	20	CIRCULATE THRU SPARKLER UNTIL CLEAR			
30	20	PUMP V-313 THRU SPARKLER INTO V-330 (SAMPLE-			
6	21	WHEN MTY, BLOW OUT SPARKLER INTO V-330			
	22	RECORD: VOLUME 30"			
	23	HEAT TO 165-170°F- TAKE (1st SAMPLE			
		SHOW 1st SAMPLE TO SHIFT SUPERVISOR FOR APPROVAL. (EXAMPLE OF ACCEPTABLE CLARIFICATION OF N7HD-C IS AVAILABLE IN OFFICE TO COMPARE TO.) - TAKE SAMPLE WITH AGITATION			
	24	IF S-23 IS OK, CONTINUE WITH S-25. IF S-23 IS NOT ACCEPTABLE, RE-CLARIFY THRU SPARKLER R+D			
	[redacted]				

EQUIPMENT		PAGE 2 CG 36 CODE PT-695-D EST. WGT. 1350 LBS.	USE LBS.	N CODE	ACCT LBS.
207 7	25	RUN 1" (69G) WATER INTO V-207			
	26	IF S-24 IS OK, PUMP V-330 @ 165-170°F INTO V-207			
	27	HEAT V-207 TO 165-170°F			
	28	RUN IN V-322 N2RD, FROM S17 & RINSE IN			
	29	ADJ TO 33" (227G) AT 32-38°F .31	330	57-A	330
322 8	30	RUN IN 22" (755G) WATER INTO V-322			
	31	WEIGH & POUR IN M 2, 49.46%	485	7-D	239
	32	DUMP IN FROM S 3 LOT 3823	470	82-C	470
	33	WEIGH ON POSTAL SCALE & ADD LOT 90806	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
107 9	37	RUN IN 14" (139G) WATER INTO V-107			
	38	TURN ON AGITATOR & STEAM & 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 6.0 (5.0-5.5)			
	42	IF pH ABOVE 5.5 ADJ TO pH 5.5 OR LOWER Assume 78%	1	27-D	1
		RECORD: pH 5.1			
		NOTE: IF pH BELOW 5.0 DO NOT ADJ UPWARD			
	45	HOLD FOR S 48			
302 10	KH	WEIGH & POUR INTO V-302 FOR S 47 M 1, 33.52%	474	725-A	159
322 11	46	ADJ V-322 TO 30" (103G) AT 70-80°F			
	46	SLURRY WITH 30 GAL H2O WATER IN DRUM, POUR IN & STIR 5 MIN	73	39-A	73
207 12	47	RUN IN N-725-A FROM S44 AFAP INTO V-207			
	48	STIR 5 MIN AT 32-38°F MAINTAINING +CR, +KI	330	57-A	330
		RECORD: TIME START 5:30 PM CR +, KI +			
		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 Assume 33%		725-A	
		RECORD: CR (+), KI (+) TEMP 37°F			
	49	COMPLE V-322 THRU UNDERSURFACE DISTRIBUTOR INTO V-207 IN 40 - 45 MIN			
		RECORD: START 5:50 PM TOTAL MIN 55 TEMP 63°F			
	50	WHEN S49 COMPLETE, STIR 5 MIN			
		RECORD: DIAZO SLT (-), BASE + (+); pH 12.1 (11.4-11.8)	Sample 1 qt		
		NOTE: (1) IF pH IS 5.0-7.0, WEIGH & DUMP IN 15# "AS IS" N-7-D AFAP Assume 50%		7-D	
		RECORD: pH			
	51	IF NECESSARY, ADJ TO pH 11.4-11.8 Assume 50%		7-D	
		RECORD: pH Assume 32%		28-D	
	52	ADJ TO pH ~~9.5-10.5~~ 10.5-11.0 Assume 32%	14C	28-D	45
		RECORD: pH 11.0 Assume 50%		7-D	
		NOTE: ADD N-7-D IN 20# "AS IS" INCREMENTS TO APPROCH pH ~~9.5-10.5~~ THEN USE LESS N-28-D ~~9.5-10.5~~ 10.5-11.0	Sample 1 qt		

DUP050292658

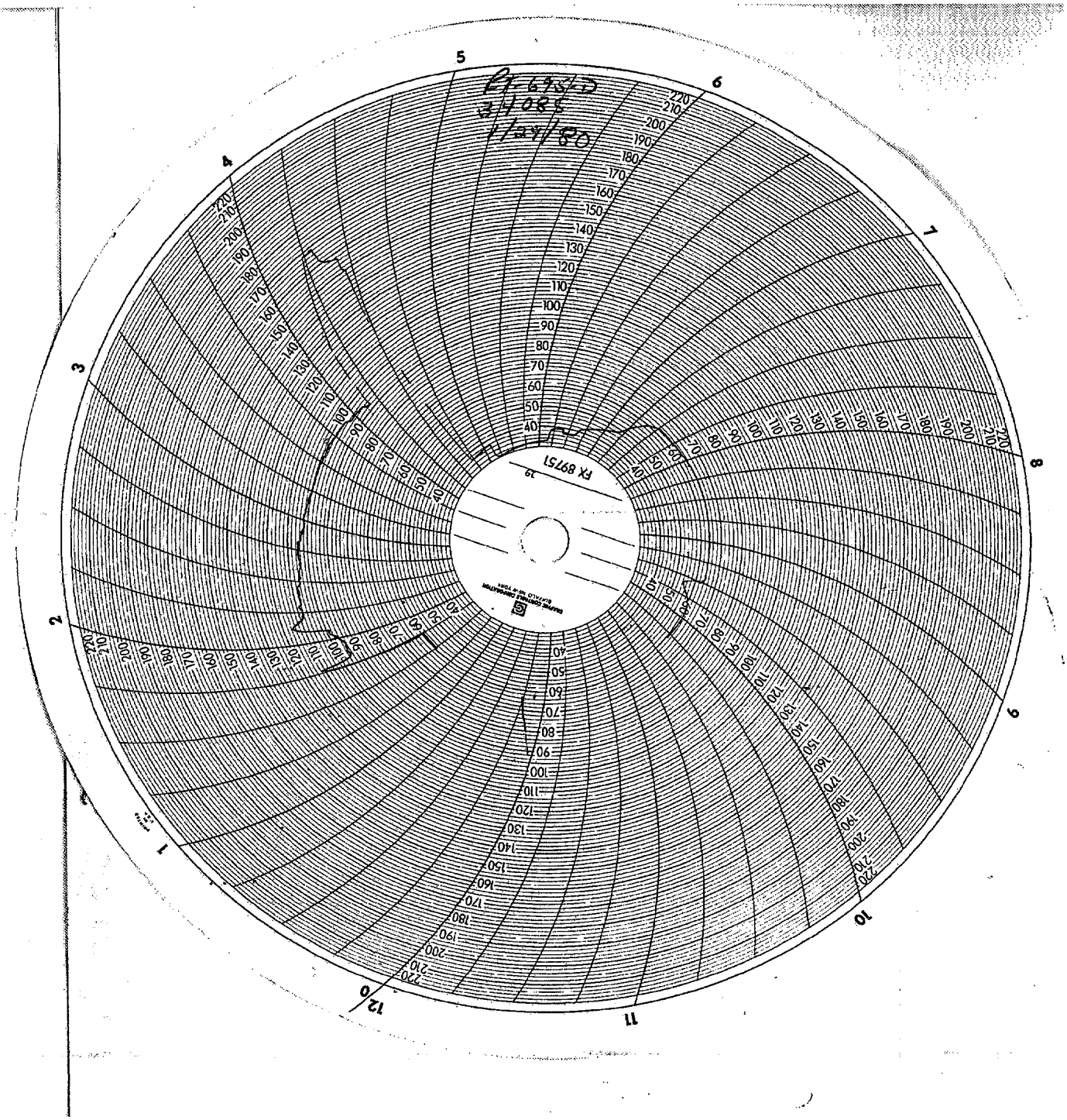
EQUIPMENT		PAGE 3 CG 36 CODE RT-695-D EST. WGT. 1350 LBS.	USE LBS.	N CODE	ACC LB
107	52	DURING S 49, HEAT TO 210-212°F & SHUT OFF STEAM			
12		NOTE: IF NECESSARY, REHEAT V-100 TO 210, 212°F PRIOR TO START OF STRIKE			
	54	PUMP V-207 INTO V-107 IN 60-65 MIN. LET V-107 TEMP DROP TO 200-205°F, THEN MAINTAIN AT 200-205°F FOR BALANCE OF STRIKE			
		RECORD: START 1:50 Pm TOTAL MIN 70			
	55	WHEN STRIKE COMPLETE, HEAT TO 210-212°F			
	56	SEIR 15 MIN AT 210-212°F			
	57	FLOOD TO 87" (8648G). RECORD: PH 7.5 (6.5-7.2)			
	58	STOP AGITATOR SAMPLE			
		START FIN OPTR			
		7.00 AM 3.00 PM 144			
		3:15 Pm 9:35 Pm 342			

DUP050292659



DUP050292660

N 31882.01



DUP050292661

N 31882.02