

c.v. 260 PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

315, 317, 322, 323, 303

40 CODE RT-539-D PKG.
AUG 11 80 36700 AUG 11 1980
WGT. 486 LBS.
D. HRS. TIME 7A M 29

PROCESS	APPROVED BY
() RT-539-D (M)	EWK 10-25-77
(D) RC-15-A ()	DCG 10-25-77
() ()	MTM 10-31-77
() ()	
TYPED BY	
11c 11-14-77	

LEAVE ONE STUMP ONLY

CLEAN UP
AS YOU GO ALONG
NON-BLEEDING

INT	NAME: NAPHTHANIL® RED DARK	USE LBS.	N CODE	ACCT. LBS.
c.	1 Obtain for S 6		24-C	
	2 Obtain for S 31		151-C	
	3 Clean, dress, close 24" clarif press - 15 frames			
	4 Run 12" (325 G) water into V- 303			60
	5 Run in from V-324 M 6 30.65%	299	28-D	31
	6 Dump in from S 1 LOT 529 1100%	210	24-C	161
	7 Add & stir 15 min to wet LOT 269 2506	208	896-C	2
	8 Adj to 29" (702 G) at 28-32°F	6 x 330	57-A	123
	9 Siphon in in 8-12 min M 9 32.12%	208	725-A	69
	10 Stir 5 min & Record: CR + (+); KI + (+) Note: (1) If CR-, KI-, add 20# "as is" increments Assume 32% Record: CR (+); KI (+) (2) If CR+, KI-, add 10# "as is" increments Assume 33% Record: CR (+); KI (+)		28-D	
	11 Stir 30 min at 28-32°F maintaining +CR, +KI for S 17 Record: Time Start 1/1/5A		725-A	
c.	12 Slurry in 40 Gal water in drum & precoat clarif press with	5	777-A	5
	13 Run 5" (60 G) water into V- 34			
	14 Pour in Assume 50%	78	7-D	39
	15 Pour in & stir 3 min Assume 78%	77	30-D	58
	16 Record: pH (6.5-7.5) & if necessary Assume 75%		30-D	
	n adj to pH 6.5-7.5 Record: pH Assume 50%		7-D	
	17 When S 11 stir complete, test DV & Record: CR (+); KI (+); Temp 28-32°F Note: (1) If CR-, KI-, add 20# "as is" increments Assume 32% Record: CR (+); KI (+) (2) If CR+, KI-, add 10# "as is" increments Assume 33% Record: CR (+); KI (+)		57-A	
	18 Weigh in rubber bucket & wash into DV	5	395-D	5
	19 Stir 5 min & Record: KI + (+)			
	20 If necessary, adj to -KI & Record: KI - (-)	10	395-D	10
	21 Dump in	25	113-A	25
	22 Pump in & stir 15 min	10	777-A	10
	23 Pump DV thru clarif press into V- 323 maintaining temp at 28-32°F Record: Time Start 2/1/5 total min 45	2 x 330	57-A	660

ENT	PAGE	CG 40	CODE RT-539-D (N)	EST. WGT.	486	LBS.	USE LBS.	N CODE	ACC LBS.
	24		When S 23 clarif complete, wash DV (S 4) lines, dump & press for 20 min or to a -OR test on a sample of total press effluent, whichever comes first, collect washings in DV (S23)					87-A	
	25		Stir 5 min & record: Temp <u>28</u> (28-32°F) & if necessary, adj to 28-32°F Record:						
	26		Record: Vol <u>3.2</u> & hold for S 42						
20	27		Install V-260 temp chart & set agitator at 16 rpm						
3	28		Run in 20# (1948 G) water						
6	29		Run 23# (450 G) water into V-330						
	30		Slurry in 20 G water & pour in			13		39-A	13
	31		Dump in from S 2 & stir 10 min to wet		LOT 4.598 3.752	200 708		151-C	308
	32		Pour in						
	33		Heat to 155-162°F AFAP Record: Min <u>4</u>		Assume 50%	156		7-D	70
	34		Stir 5 min to dissolve						
			Record: Solution Color <u>Dr - Brn</u> (Dark Brown)						
			Clarity <u>Clear</u> (Must be Clear)						
			Note: If solution not dark brown & clear, heat to 145-152°F						
			AFAP & Record: Color <u>Dark Brown</u>						
			Clarity <u>Clear</u> (Must be Clear)						
	35		Immediately run V-330 into CV, no agitation in CV						87
	36		Immediately start agitator & syphon in in 15-20 min		9.08	110		30-D	87
	37		Stir 5 min & Record: pH <u>10.2</u> (10.0-10.5)						
	38		If necessary, adj to pH <u>10.0-10.5</u>		Assume 50%			7-D	
			& Record: pH <u>10.4</u>		Assume 75%	40		30-D	30
	39		Run in V-302 or V-330						
	40		Dump in						
	41		Heat to 148-152°F in 15-20 min & record: HT <u>149</u> F & Rec <u>50</u>						
	42		When S 26 complete, couple DV undersurface in 65-70 min						
			Maintain CV at 148-152°F Record: Start <u>2:00</u> Total Min <u>7.0</u>						
	43		Record: Diazo <u>+</u> (- or +), Base <u>+</u> must be <u>+</u>						
			pH <u>4.5</u> (4.5-5.0)						
	44		Stir 15 min						
	45		When S 44 stir complete, test CV &						
			Record: Diazo <u>-</u> must be <u>-</u> , Base <u>+</u> must be <u>+</u>						
			pH <u>4.5</u> (4.5-5.0)						
	46		If S 45 diazo is <u>+</u> and base is also <u>+</u> , sift in 20# N-3-A					3-A	
			& stir to <u>+</u> diazo. WATCH FOAM						
			Record: Diazo <u>-</u> must be <u>-</u> , Base must be <u>+</u>						
			pH <u>(4.8-5.2)</u> Total min since S 43						
	47		Flood to 82" (8126 G) & stop agitator						
			START	FIN	OPTR				
			<u>7:00 PM</u>	<u>3:00 PM</u>	<u>126.0129</u>				
			<u>3:00 PM</u>	<u>4:45 PM</u>	<u>830</u>				

