

S.V.

100

C.V.

207

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

313 322, 330

CG 36 CODE RT-695-D

PKG.

→ SEP -2-80 36990

EST. WGT. 1350 LBS.

STD. HRS. TIME

PROCESSES

APPROVED BY

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TYPED BY	

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	
	2 Obtain for 32B		253	2-C
313 2	4 Run 25" (370G) water into V-313			
	5 Weigh & pour in 10-7 90 48.04 204		7-D 98	
	6 Turn on agitator & steam & dump in from S 2		740-C	302
	Lot 100% 54 302 98.5 510			
	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 S14 Record: HT 195°F			
	& Recorder 195°F			
	Record: Start 1:28 PM Total Min 15 Clarity OK			
3 207	13 Run 1" (125G) water into V-313 207			
	14 When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at 190-195°F. Record: Start 1:28 PM Total Min 25 Sample-From Hose			
	Show to supervisor for OK			
	15 Weigh on Postal Scale & Add Lot		584	
322 4	16 Run in 2" (66G) water into V-322			
	17 Weigh in plastic lined Drums & Pour in & hold for S 28			
	M 7 31.62 1039		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 Sparkler until sol'n is clear.			
322 6 207	20 Pump V 313 thru Sparkler into V-322 207 (Sample)			
	21 When MTV-blow out Sparkler into V-322 207			
	22 RECORD: VOLUME			
	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 S-23 is not acceptable re-clarify thru sparkler.			

EQUIPMENT		PAGE 2 CG 36 CODE RT-695-D	EST. WGT.	1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
207	25	Run in (69G) water into V-207					
7	26	Is S 24 is OK, pump V-330 at 165-170°F into V-207					
	27	Heat V-207 to 165-170°F					
	28	Run in V-322, N-28-D, from S17 & rinse in					
	29	Adj to 33" (2277G) at 32-38°F		19	27x330	57-A	9570
322	30	Run in 22" (755G) water into V-322					
8	31	Weigh & Pour in	M 7 .4604%	498		7-D	239
	32	Dump in from S3	Lot			283-C	425
			497	225			
			496	200			
	33	Weigh on postal scale & add	Lot 130		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-107					
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 5.8 (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 5.2					
		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 9 .33.17%		501		725-A	166
10							
322	45	Adj V-322 to 30" (1031) at 77-80°F & RECORD: TEMP 77.0°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 500P CR + KI + TEMP 33.0°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 Assume 33%				725-A	
		RECORD: CR (+), KI (+)					
	49	Couple V-322 thru under surface distributor into V-207 in					
		40-45 min Record: Start 530P Total min 45					
	50	When S 49 complete, stir 15 min					
		Record: DIAZO - (-); BASE + (+); pH 11.8 (11.0-11.8) TEMP 62.0°F					
		NOTE: (1) If pH is 5.0-7.0, weigh & dump in 15# "as is" N-7-D AFAP Assume 50% Record: pH				7-D	
	51	If necessary, adj to pH 11.4-11.8 Assume 32%				28-D	
		Record: pH					
	52	Adj to pH 8.2-8.6 Assume 32%		90		28-D	90
		Record: pH 8.2 Assume 50%				7-D	
		NOTE: Add N-7-D in 20# "as is" increments to approach pH 9.0-9.5 Then use less N-28-D					
		Use only diluted N7 & N28 for pH adjustments					



