

CG 67	CODE	SF-67	PKG.	
06-001	EST. WGT.	6362	LBS.	
5/28/81	STD. HRS.	9.5	TIME	M
APPROVED BY	PROCESSES	(v) SF-67		
FEB 9-8-76	DCG 9-17-76			
TYPED BY	JIC 10-7-76			

EQUIPMENT

1 Prep

1. Inspect clarifier press and clean if necessary (use 28 frames)

2. Weigh in SS container for S's 11 & 12

3. Obtain for S's 10 & 12 (4700-4900# (as is))

4. Obtain for S 16

Note: Use in full drum increments

5. Record: V-348 scale accuracy at 100#

6. Calc and weigh in V-348 for S 7

Note: Enter #100% under "Acct Lbs"

7. Record: V-348 scale accuracy at 100#

8. Calc and weigh in V-348 for S 7

Note: Enter #100% N-7-D under "Acct Lbs"

9. Run V-348 into V-209 on wash water from previous batch

10. Adjust to 32" (1298 G)

Record: 11.5 of, if above 115°F, adj to 115-110°F

11. Add 2 drums N-418-C from S 3 in 4-6 minutes

12. Add 16# N-421-E from S 2

13. Repeat S's 10 & 11 adding slowly to avoid excessive temp rise

until all remaining N-418-C and N-421-E is added

Note: Keep temp below 185°F, stop adding N-418-C if necessary

and allow to cool before proceeding

14. Stir 10 minutes at 175-185°F

15. Heat to 214-218°F and boil vigorously for 30 minutes

16. Turn off steam

17. Add N-418-C from S 4 in 2-3 minutes

18. Stir 10 minutes at 200-218°F

Record: pH 10.8-11.1, if necessary adj to pH

10.8-11.1 with N-418-C in 20# increments

Record: pH (10.8-11.1)

19. Adjust to 39" (1578 G) at 180-200°F

20. Stir 20 minutes at 180-200°F

21. Circulate thru clarifier press and V-209 until effluent is clear

Maintain V-209 at 180-200°F

Record: Clarity OK

22. When press effluent is clear, pump V-209 thru clarifier press

23. Into V-239

Record: Time Start 8:00

24. Wash in V-209 with minimum water

239

209

348

1

NON-BLEEDING

2975

