

I.V.

100

C.V. 207

D.V. 313, 322, 330

CG 36 CODE RT-695-D PKG.

NOV 4 80 37723

EST. WGT. 1350 LBS.

STD. HRS. TIME 7A

PROCESSES	APPROVED BY
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()	()
TYPED BY	

Hose out V100 & V207

J. Gary will follow batch - Do Not Move up

NON-BLEEDING

EQUIPMENT	NAME: "BON" RED DARK	USE LBS.	N CODE	ACCT. LBS.
Prep	1 If necessary, clean, dress sparkler & pre-coat with 15#		777-A	
1	2 Obtain for S 6		740-C	
	3 Obtain for 32B		253 82-C	
313	4 Run 25" (370G) water into V-313			
2	5 Weigh & pour in	98	722-D	98
	6 Turn on agitator & steam & dump in from S 2		740-C	500
	Lot 100%			
	109 507 98.67 500			
	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%		722-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 120°F			
	& Recorder 190°F			
	Record: Start 308P Total Min 15 Clarity Clear			
330	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 315 Total Min 30 Sample-From Hose			
	Show to supervisor for OK			
	15 Weigh on Postal Scale & Add Lot 297	2	584-C	2
323	16 Run in 2" (66G) water into V-322			
4	17 Weigh in plastic lined Drums & Pour in & hold for S 28			
323	M 10 31.35	644	28-D	202
313	18 When S14 complete, close V-313 outlet & stop pump			
5	19 Run in 13" (192G) water & heat to 190-195°F			
	Circulate thru Sparkler until sol'n is clear. PUMP V313 THRU SPARKLER INTO V330			
	19A Run 5" (70G) water & heat to 190-195°F. CIRCULATE THRU SPARKLER UNTIL CLEAR			
330	20 Pump V 313 thru Sparkler into V-330 (Sample)			
6	21 When MTV-blow out Sparkler into V-330			
	22 RECORD: VOLUME 5.0 "			
	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 2-23 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 1" (69G) water into V-207					
7	26	If 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	TEMP 152°F	10 MIN	STIR		
	29	Adj to 33" (2277G) at 32-38°F (20-TEMP 58°F)	30x330	57-A			
		(25-46°F) (30-36°F) H.T. - 37°F					
322	30	Run in 22" (755G) water into V-322					
8	31	Weigh & Pour in	M	.100%	239	721-D	239
	32	Dump in from S3	Lot		253	82-C	445
					425		
	35	Weigh on postal scale & add	Lot	20.316	119	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-100					
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 5.5 (5.0-5.5)					
	42	If pH above 5.5, adj to pH 5.5 or lower Assume 78%				27-D	
		Record: pH					
		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	.3316%	501	725-A	166
10							
322	45	Adj V-322 to 30" (1031) at 77-80°F & RECORD: TEMP 78°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 37-38°F maintaining + Cr. + KI TEMP 43°F			2x330	57-A	660
		Record: Time Start 8:00 PM CR + KI + TEMP 38°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 9:14 PM Total min. 37					
	50	When S 49 complete, stir 15 min					
		Record: DIAZO - (-); BASE + (+); pH 9.5 (11.0-11.8) TEMP 60°F					
		NOTE: (1) If pH is 5.0-7.0, weigh & dump in 15# "as is" N-7-D AFAP				721-D	
		Assume 50% Record: pH					
	51	If necessary, adj to pH 11.4-11.6				721-D	
		Record: pH					
		Assume 50%				28-D	
		Assume 32%					
	52	Adj to pH 9.0-9.5				28-D	
		Record: pH					
		Assume 50%				721-D	
		NOTE: Add N-7-D in 20# "as is" increments to approach pH 9.0-9.5 Then use less N-28-D					

EQUIPMENT	PAGE 3	CG 36 CODE RT-695-D	EST. WGT.	1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
107 12 100 V	53	During S 49, heat to 210-212°F & shut off steam					
	12	NOTE: If necessary, reheat V-107 to 210, 212°F V-100					
		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 11:40 AM Total min 70					
	55	When strike complete heat to 210-212°F					
	56	Stir 15 min at 210-212°F					
	57	Flood to 87" (8648G). Record: pH 7.1 (6.5-7.2)					
	58	Stop agitator					
		2 gal - R+D					
		Start	Fin	Optry			
		1:30 PM	3 PM	4:30			
		11:40 AM	11:00 PM	12:00			
				3			



