MAKING INSTRUCTIONS: BATCH UNIT

S.V. 102 C.V. 207 D.V. 313, 322, 330

CG 36 CODE RT-695-D PKG.

→ SEP·29·60 37258

EST. WGT. 1350 LBS.

STD. HRS. TIME 7AM

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

V740C - use Lots 102 or 103

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 use Lot 102 or 103		740-C	
	3	Obtain for 32B		253 -C	
313 2	4	Run 25" (370G) water into V-313			
	5	Weigh & pour in 11 Alum	197	7-D	98
	6	Turn on agitator & steam & dump in from S 2		740-C	500
		Lot 100% % 102 502 98.23	508		502
	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 T (+), 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 °F			
		Record: Start 9.35 AM Total Min 16 Clarity OK			
3 207	13	Run 1" (125G) water into V-207			
	14	When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at 190-195°F. Record: Start 9.51 AM Total Min 18 Sample-From Hose			
		Show to supervisor for OK			
	15	Weigh on Postal Scale & Add Lot			
322 4	16	Run in 2" (66G) water into V-322			
	17	Weigh in plastic lined Drums & Pour in & hold for S 28			
		M 1 3/16 %	639	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 Syarkler until sol'n is clear.			
6 207	20	Pump V 313 thru Sparkler into V-207 (Sample)			
	21	When MTY-blow out Sparkler into V-207			
	22	RECORD: VOLUME 11 "			
	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.			

K 13829 REV.

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~~			
	29	Adj to 33" (2277G) at 32-38°F	27x330	57-A	8,910
322	~~30~~	Run in 22" (755G) water into V-322			
	~~31~~	Weigh & Pour in M 11 .42.6%	481	7-D	239
8	~~32~~	Dump in from S3 Lot 499	253	~~C~~ C	~~425~~ 425
			425		
	~~33~~	Weigh on postal scale & add Lot 60316	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-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 5.7 (5.0-5.5)			
	~~42~~	If pH above 5.5, adj to pH 5.5 or lower Assume 78%	4	27-D	3
		Record: pH 4.3			
		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 11 .42.6%	481	725-A	166
10					
322	~~45~~	Adj V-322 to 30" (1031) at 70-80°F ✓ RECORD: TEMP 80°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 11:00AM CR + KI + TEMP 30°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 As sume 33%		725-A	
		RECORD: CR (+), KI (+)			
	~~49~~	Couple V-322 thru under surface distributor into V-207 in 40-45 min Record: Start 11:51AM Total min 47			
	~~50~~	When S 49 complete, stir 15 min			
		Record: DIAZO + (-); BASE + (+); pH 11.9 (11.0-11.8) TEMP 52°F			
		NOTE: (1) If pH is 5.0-7.0, weigh & dump in 15# "as is" N-7-D AFAP		7-D	
		Assume 50% 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 ~~11.4-11.8~~ 8.4-8.8 Assume 32%	100	28-D	32
		Record: pH 8.7 TAKE SEAL SAMPLE Assume 50%	12	7-D	6
		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 deleted N-7 or N-28 for pH adjustment

EQUIPMENT		PAGE 3 CG 36 CODE RT-695-D EST. WGT. 1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
100	53	During S 49, heat to 210-212°F & shut off steam			
		NOTE: If necessary, reheat V-100 to 210, 212°F			
		Prior to start of strike			
	54	Pump V-207 into V-100 in 60-65 min. Let V-100 temp drop to			
		200-205°F, then maintain at 200-205°F for balance of strike			
		Record: Start 3:35 Total min 70			
	55	When strike complete heat to 210-212°F			
	56	Stir 15 min at 210-212°F			
	57	Bleed to 87" (8648G). Record: pH 6.8 (6.5-7.2)			
	58	Stop agitator			
		FVC - 1 Pint Sample			
		Start 7:00 AM 2:00 PM	Fin 3:00 PM 5:30 PM	Optr 144 342	

K 13830 REV.

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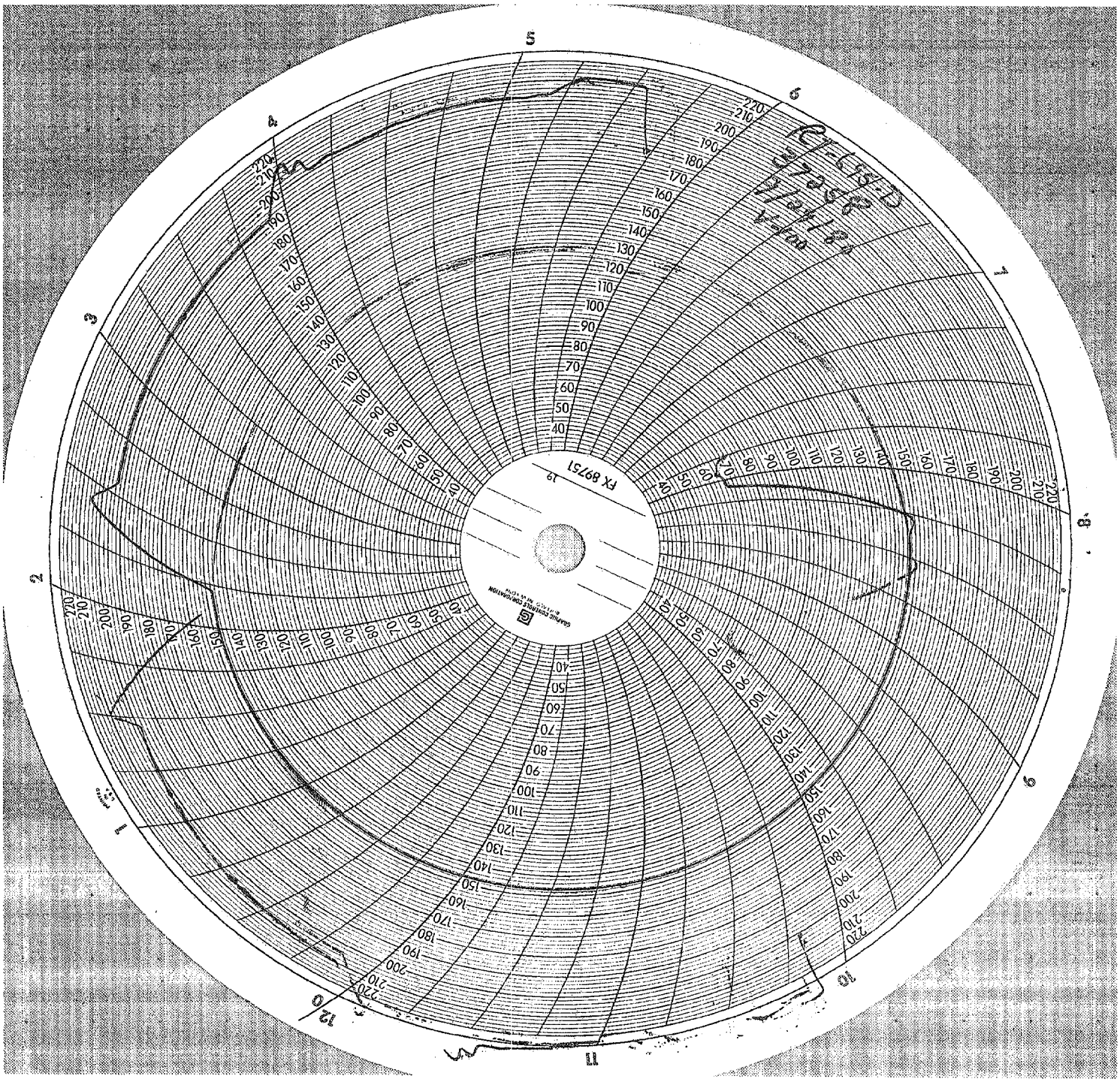

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