

S.V. HF-MILL 6

C.V. 180 AUXILIARY VAT 382 (10 CHARGES MAX.)

DATE PRINTED: 11/25/81

CG 20

CODE BC-2-A

PKG ---

PROCESSES

APPROVED BY

(C) BC-2-A

BBK 11/20/81

JUL 20 1982

G2J37

(DATE)

(LOT NUMBER)

JOB NAME: 20BC002AMC

TYPED BY: DB

ESTIMATED WGT ~~226.54~~ LBS.

STANDARD HRS.

TIME 3 P.M.

PREPARATION NOTES:

*12 charge milled
✓ 180 full*

EQUIP MENT		NAME: "MONASTRAL" BLUE B	04 PAGES	USE LBS	N-CODE	ACCT LBS
PREP	1	INSTALL TEMP & AMPS CHARTS DAILY				
	2	WEIGH BC-2-A BORAX SLUDGE FOR S-5 + 11, RECORD WGT. IN S-23 PER CALC S-3 NOTE: TOTAL WGT INCLUDES LIQUID. AFTER WEIGHING, DIPPER OFF EXCESS LIQUID & POUR INTO V-291 THRU CLASSIFIER				
	3	CALC FOR S-10, 12 & 23 $660\# - (0.7 \times \text{---} \div \text{SLUDGE S-2}) =$ $\#N-972-A$				
HF MILL	4	START AGITATOR WITH COOLING WATER OFF				
	5	DUMP IN 1 BUGGY OF SLUDGE FROM S-2 & ADD	14	567-B	0	
	6	DUMP IN & STIR 10-15 MIN TO UNIFORMITY NOTE: TURN ON WATER SPRAYS WHEN MILL TEMP REACHES 120 DEG F OMIT S-7-9 ON 1ST CHARGE OF 1ST BATCH OF A CAMPAIGN.	100	8520-A	0	
CLASS	7	DURING S-6 STIR, BACKWASH LINES FROM CLASSIFIER TO V-391 & PLACE CART UNDER SLUDGE DISCHARGE				
391 A	8	ADJ TO 24" (293 G) & TURN ON AGITATOR <i>Note volume adj.</i>				
291 S	9	RUN V-391 AT 3.0-3.5 GPM (85-100 MIN) THRU CLASSIFIER INTO V-291.				
HF MILL	10	DURING S-9 DUMP IN ALL BUT 50% N-972-A CALC IN S-3			972-A	0
	11	ADD 2ND BUGGY OF SLUDGE FROM S-2 & STIR 3-6 MIN TO UNIFORMITY				
	12	ADD 50% N-972-A FROM S-10 & ADJ TO 27-32 AMPS WITH N-972-A OR WATER			972-A	0
	13	WHEN 27-32 AMPS REACHED WITH + OR - 15" VORTEX STIR FOR 3 HRS AT 27-32 AMPS & BELOW 130 DEG F A. ADD N-972-A WATER OR ICE TO MAINTAIN 27-32 AMPS BELOW 130 DEG F. B. RECORD ALL N-CODE INGREDIENTS USED IN TABLE S 23. C. RECORD DATA IN TABLE S-40.				
	14	WHEN S-13 STIR COMPLETED, ADD 5-10" WATER AVOID OVERFLOWING HF-MILL				

AUG 5 1982

N32864

EQUIP MENT		PAGE 02 OF 04 CG 20 CODE BC-2-A (C)	USE LBS	N-CODE	ACCT LBS
CONT.	15	STOP AGITATOR & COOLING WATER SPRAYS			
CLASS	16	WHEN S-9 COMPLETE & V-391 MTY CLOSE CLASS- 7 IFIER FEED VALVE & BACKWASH LINE TO V-391 FOR 30 SECS.			
	17	OPEN FEED VALVE & DRAIN V-391 TO CLASSIFIER			
		NOTE: DO NOT WASH IN V-391			
	18	STOP V-391 AGITATOR & CLOSE CLASSIFIER FEED VALVE			
391	19	WHEN S-15 DONE TURN ON AGITATOR & PUMP IN			
8		CHARGE FROM HF-MILL CONTINUOUSLY DILUTING			
		MILL CHARGE WITH + OR - 100 GAL WATER.			
	20	WASH IN MILL & FLUSH PUMPING LINES INTO V-391.			
180	21	PUMP V-291 TO V-180 NOTE: V-381 MAY BE USED			
9		AS AN AUXILIARY COLLECTION VAT UP TO 10 CHARGES. IF USED HEAT V-382 TO 15-160°F BEFORE RUNNING INTO V-180.			
MISC	22	REPEAT S 1-21 UNTIL ⁽²³⁾ CHARGES ARE COLLECT-			
10		ED IN V-180			
	23	CHARGE OUT RAW MATERIALS IN TABLE 1 BELOW:			
		TABLE 1			

CHGE	N-567-B	REC SLUDGE	N-972-A	N-8520-A					
NO.	LBS	AS IS	100%	#S3	#S13	TOTAL	LOT NO	LBS	OPTR
1	14	530	371	289		298	3615	100	433
2	14	550	385	275		275	3615	100	438
3	14	660	462	288	2	200	3615	100	105
4	14	552	386	274		274	3615	100	438
6	14	605	424	236		236	3615	100	101
7	14	660	462	198		198	3615	100	438
8	14	605	424	236	10	246	3615	100	232
9	14	655	459	201		201	3624	100	105
10	14	615	451	209			3624	100	438
11	14	700	490	170		170	3624	100	166
12	14	658	461	199	1	200	3624	100	101
13	14	730	511	199		199	3624	100	438
14	14	640	448	212		212	3624	100	101
15	14	750	525	135		135	3624	100	166
16	14	690	483	172		172	3624	100	105
17	14	961	633	127		127	3632	100	101
TOTALS									

0 567-B 154
0 972-A 2298
0 8520-A 1100

* * * * *
24 ENTER TOTAL LBS OF R/MS IN ACCT LBS COLUMN
NOTE: ENTER CHGE. NO. BEING MILLED. EXTRA
SPACES INCLUDED IN TABLE FOR USE IF MORE
THAN 1 LOT N-8520-A USED IN A CHARGE.

EQUIP MENT		PAGE 03 OF 04 CG 20 CODE BC-2-A (C)	USE LBS	N-CODE	ADCT LBS
180	25	TURN ON AGITATOR & INSTALL TEMP CHART			
11	26	RUN IN FROM V-386 M 1.9 76.92	1037	27-D	798
	27	RECORD: PH 1.8 (1.0-2.0)			
	28	IF NECESSARY ADJ TO PH 1.0-2.0 ASSUME 78%		27-D	
		RECORD: PH			
	29	HEAT TO 178-182 DEG F IN 40-45 MIN			
384	30	RUN IN 2200+ WATER INTO V-384			31
12	31	WEIGH IN ACID-DRUM & POUR IN M 1 29.89%	104	28-D	94
	32	TURN ON AGITATOR & STEAM			
	33	WEIGH & ADD IN 3-5 MIN LOT %	94	365-B	94
	34	HEAT TO 130-140F & STIR TO DISSOLVE FOR S35			
180	35	WHEN S-29 COMPLETE RUN V-384 AT 130-140°F			
13		INTO V-180 AT 178-182°F IN 10-15 MIN.			
	36	STIR 30 MIN AT 178-182 DEG F			
	37	RECORD: SPOT TEST (+) (-)			
		IF (-), CONTACT SUPERVISOR			
	38	FLOOD TO 86" (9159 G) AT 178-182 DEG F			
	39	STOP AGITATOR			
		NOTE: DURING PRESSING, REHEAT SV TO 178-182°F AT THE START OF EACH SHIFT			
MISC	40	RECORD DATA WHILE MILLING (ONCE EACH CHARGE)			
14		TABLE 2			

CHGE	TIME	MILL	ACCURACY	* F				
NO.	DATE	START	FIN	HRS	TIME	AMMETER	REC	REC
1	7/1/81	4:09	7:00	3	6:00	29	28	115
2	7/2/81	9:00	12:00	3	10:00	29	28	119
3	7/2/81	1:00	4:00	3	2:00	29	28	125
4	7/2/81	1:00	4:00	3	2:30	29	29	121
5	7/2/81	6:00	9:00	3	10:00	28	28	115
6	7/2/81	3:30	6:30	3	5:00	29	29	116
7	7/2/81	10:35	1:00	3	12:00	29	29	119
8	7/2/81	4:00	7:00	3	6:30	29	29	117
9	7/2/81	1:00	4:00	3	2:30	27	27	121
10	7/2/81	9:00	12:00	3	10:00	28	28	126
11	7/2/81	5:00	8:00	3	2:00	29	29	115
12	7/2/81	1:00	4:00	3	3:00	28	28	118
13	7/2/81	1:00	4:00	3	2:00	28	28	121
14	7/2/81	9:00	12:00	3	11:00	27	27	127
15	7/2/81	1:00	4:00	3	2:30	27	27	110
16	7/3/81	8:00	11:00	3	10:00	28	28	129
17	7/3/81	1:00	4:00	3	3:00			
18								
19								
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21								
22								
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27								
28								
29								
30								
31								
32								
33								

Note: mill 23 charge

only 12 charge in v-180 one full

EQUIP MENT	PAGE 04 OF 04 CG 20 CODE BC-2-A (C)	USE LBS	N-CODE	ACCT LBS																																																																		
V-180 15	SUPPLEMENT TO BC-2-A LOT NOTE: THIS PAGE TO REMAIN IN MAKING UNTIL V-180 IS EMPTY 1 AT START OF EACH SHIFT DURING PRESS-FILLING CYCLE: REHEAT SV TO 178-182 DEG F NOTE: USE TEMP CONTROLLER ABOVE 16" IN VOL USE MANUAL CONTROLLER FROM 9 1/2" TO 16" (CANNOT HEAT BELOW 9 1/2") 2 RECORD <table border="1"> <thead> <tr> <th>V-180 INITIAL</th> <th>TEMP FINAL</th> <th>BY OPTR</th> <th>DATE</th> <th>TIME</th> <th>APPROVED SUPV'R</th> </tr> </thead> <tbody> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table> 3 WHEN VAT EMPTY, ATTACH RECORDER CHART TO THIS CARD & DELIVER CARD TO PROCESS ENGINEERING				V-180 INITIAL	TEMP FINAL	BY OPTR	DATE	TIME	APPROVED SUPV'R																																																												
V-180 INITIAL	TEMP FINAL	BY OPTR	DATE	TIME	APPROVED SUPV'R																																																																	

Boxed out VAT-384 20th N-3-A

DATE PRINTED: 11/25/81

PROCESSES | APPROVED BY:
(C) BC-2-A () | BBK 11/24/81
TYPED BY: JMH

G2J37

(LOT)

NOTES:

JOB NAME: 20BC002AFC

INSTRUCTIONS

= PRESSING

RECORD

VAT	180	PRESSLO	1ST	2ND	3RD	4TH	5TH
DATE	8-4-82	STARTED	10 PM				
TIME	6:00 P	CAKES USED	22				
RELEASED BY	SS	WATER ON	10 AM				
PRESS	31	HRS. WASHED	243				
NO. OF CAKES	44	OHMS					
PRESS WITH AGITATION		HRS. WASHED					
WASH TO 3000 OHMS - 135-145°F WATER		OHMS					
TEST AFTER 20 HOURS		HRS. WASHED					
LOAD IN	DRUM - 510 - 6A 5M 325#	OHMS					
NOTE: 1. REQUEST MAKING REPEAT SV TO		CAKE CONDITION					
178-182°F ONCE PER SHIFT.		NO CARS LOADED					
2. AIR-BLOW PRESSCAKE WHEN		EXPLAIN LOSSES					
3000 OHMS REACHED FOR 15 MIN.							
AT 40 PSI.							

SAMPLES THIEF ~~SAMPLE~~ PER SOP
DELIVER TO CTL

SAMPLED BY
RELEASED BY

= DRYING =

DO NOT DRY

= GRINDING =

DO NOT GRIND

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