

MD-3-A

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE

RT443

LOT

37696

NET WT/PKG

NO. PKG

PACK. WGT

LOCATION

PO

18

1324

11

STUMP

Lump 1294

TOTAL NET WT.

1324

PKG. N-CODE

PROD. SPVR.

DATE

WHSE. OPER.

RP

12/1/80

7-2

5. T
10. +
14. +
11. +
10. +
12. +
13. +
15. +
18. +
12. +
10. +
13. +
16. +
19. +
17. +
14. +
16. +
18. +
13. 4. T

31/260

CG 36 CODE RT-443-D PKG. _____

→ NOV 5 80 37696

EST. WGT. 1334 ~~37696~~ LBS.

Card received
5:05 AM

99%

PROCESSING INSTRUCTIONS: BATCH UNIT

PROCESSES RT-443-D (0) APPROVED BY JIG 05-19-77 DCG 05-20-77

TYPED BY emw061777

MAKING NOTES

REMARKS

NAME: DUOL® CARMINE

NON-BLEEDING

INSTRUCTIONS

-PRESSING-

RECORD

VAT	260					PRESSLOAD	1ST	2ND	3RD	4TH	5TH
DATE	11-5-80					STARTED	9:50 AM				
TIME	21:50 AM					CAKES USED	632				
RELEASED BY	244					WATER ON					
PRESS	32	35	37			HRS. WASHED	9				
NO. OF CAKES	60	60	60			OHMS	3000				
PRESS with						HRS. WASHED					
WASH TO	3000					OHMS					
TEST AFTER	4					HRS. WASHED					
LOAD on 9 cars						OHMS					
						CAKE CONDITION					
Clean magnetic separator & screen after pressing						NO. CARS LOADED	7				
						EXPLAIN LOSSES					

Cleaned by 372 Time Cleaned 5:30 PM OK

SAMPLES

DELIVER TO

SAMPLED BY

RELEASED BY

-DRYING-

Dry 48 hrs at 160°F
Cool - 130

LUMP: - OK - WET - SALTS - CONTAMINATED
Dryer sections used:

ADDITIONAL DRYING HOURS REQUIRED

No. Drums: 15

SAMPLES

DELIVER TO

NO. CARS PULLED

SAMPLED BY

LUMP WGT. 1294

RELEASED BY OC

-GRINDING-

MILL 2 LSP 0.066" RP SCREEN 1/50 RPM
MAX. TEMP. 150°F

SCREEN RPM
MAX. TEMP. °F

EXPLAIN LOSSES

SAMPLE WITHOUT MIXING

SAMPLES 2 ENV

DELIVER TO C T L

DATE MIXED

SAMPLED BY

RELEASED BY

37696

51

85

0

97

14

107

14

104

14

102

14

105

14

102

14

104

14

96

14

100

14

95

14

103

14

98

14

96

14

100

14

95

14

129

4

15
grams

DRUM FOR STEP 46 IS STICKED BEHIND SAFETY SHOWER AT 33 ALM

MAKING INSTRUCTIONS: BATCH UNIT

S.V.

C.V. 100, 106, 260

D.V. 300, 315, 317, 322, 323

CG 36 CODE RT-443-D PKG.

→ NOV - 500 37696
EST. WGT. 1334 LBS.

STD. HRS. 5.0 TIME

PUNCHED & CHECKED

NOV - 7 1980

PROCESSES	APPROVED BY
() RT-443-D ()	JJG 05-20-77
()	DCG 05-20-77
()	MTW 06-06-77
()	
TYPED BY	
emw061777	

AFTER V-260 IS AROLITE BOILED OUT, RUN AROLITE
use thru transfer line to Press; Not in press.

Boil out V-223 Done

NON-BLEEDING

EQUIPMENT	NAME: DUOL® CARMINE	USE LBS.	N CODE	ACCT. LBS.
Prep 1	1 Obtain for S 12		82-C	
	2 Obtain for S 24		549-C	
313 2	3 Run 29" (431 G) water into V-313 & adj to 80-100°F			
	4 Add in 8-9 min	400	530-A	400
	5 Stir 5 min & Record: pH 10.1 (9.5-10.5)			
	6 Stir 20 min or longer to dissolve for S 20			
314 3	7 Run 15" (112 G) water into V-314 (only) & heat to 170°F			
	8 Dump in	192	542-A	192
	9 Dissolve in 10 G water at 140-150°F in drum & pour in	50	979-A	50
	10 Stir 30 min or longer to smooth white slurry for S 15			
330 4	11 Run 60" (1176 G) water into V-330			
	12 Dump in from S 1		82-C	424
		Lot 4808 250		
		4873 174		
	13 Stir 30 min or longer to smooth slurry for S 16			
CV 5	14 Run 18" (1788 G) water into CV. install temp chart & turn on agitator			
	NOTE: When V-260 used, set agitation at 16 RPM			
	15 Run in V-314 from S 10 thru screen			
	16 Run in V-330 from S 13			
	17 Heat to 70-80°F			
	18 Adj to 42" (4117 G) & stir 5 min			
	19 Record: pH 11.2 (10.5-11.5) & if necessary adj to pH 11.0-11.5 Record: pH			
		Assume 50%	721-D	
		Assume 32%	28-D	
	20 Run in V-313 from S 6			
	21 Pour in & stir for S 31		Assume 50%	42
DV 6	22 Run 10" (338 G) water into V- 323			
	23 Slurry with 35 G water in drum using lightning mixer & pour in thru screen	105	542-A	105
	24 Dump in from S 2	Lot 774 100%		
		378 98.63	404	398
			549-C	
	25 Weigh on postal scale & add		2 148-C	2
	26 Heat to 75-80°F			
	Boil out V-223			
	Boil out V-323			
		(the)	50	25
			50	25

13829 REV.

DUP050106942

EQUIPMENT	PAGE 2 CG 36 CODE RT-443-D (0) EST. WGT. 1534 LBS.	USE LBS.	N CODE	ACCT. LBS.
DV 6 cont	27 Record: pH <u>11.9</u> (5.0-10.5)			
	28 Stir 20-30 min to dissolve Record: Start <u>8:20</u>			
Misc 7	29 Weigh in drum for S 36 <u>M 12, 33.16%</u>	<u>516</u>	<u>725-A</u>	<u>171</u>
	30 Obtain for S 32	1260	58-A	200
CV 8	31 Heat CV to 93-95°F & Record: HT <u>93</u> °F & Rec <u>93</u> °F			
	32 Dump in N-65-A from S 30			
DV 9	33 When S 28 stir complete, Record: DV pH <u>11.6</u> (9.0-11.0)			
	& if necessary adj to pH 10.0-10.5 Assume 50%		<u>721-D</u>	
	& Record: pH <u>10.1</u> Assume 32%	<u>26</u>	<u>28-D</u>	<u>8</u>
	34 Adj to 20" (668 G) at 28-32°F	5 x 330	57-A	<u>1650</u>
	35 Add for maintaining 28-32°F thru S 40	2 x 330	57-A	<u>660</u>
	36 Pour in N-725-A from S 29			
	37 Weigh in drum & pour in (<u>VERY IMPORTANT</u>) <u>M 10, 31.35%</u>	<u>584</u>	<u>28-D</u>	<u>183</u>
	38 Stir 5 min at 28-32°F maintaining +CR, +KI for S 40			
	Record: CR <u>+</u> (+), KI <u>+</u> (+)			
	NOTE: 1. if CR-KI- add 5# "Asis" increments Assume 32%		<u>28-D</u>	
	Record: CR <u>(+)</u> , KI <u>(+)</u>			
	2. if CR+KI- add 5# "Asis" increments Assume 33%		<u>725-A</u>	
	Record: CR <u>(+)</u> , KI <u>(+)</u> (Must be +)	<u>2 x 330</u>	<u>57</u>	<u>660</u>
	39 Record: Temp <u>28</u> °F (28-32°F)			
CV 10	40 Couple DV thru undersurface distributor into CV in 35-45 min			
	Maintain CV at 93-95°F Start <u>11:16 P</u> Total Min <u>46</u>			
	41 Stir 15 min & Record: Base <u>+</u> (+), Diazo <u>-</u> (S + to -)			
	pH <u>10.9</u> (10.0-10.5)			
	42 If necessary adj to pH 10.0-10.5 & Record: Base <u>(+)</u>			
	Diazo <u>(-)</u> , pH <u></u> , if pH above 10.5 do not adj	Assume 50%	<u>721-D</u>	
	43 Heat to 193-195°F in 45-50 min			
	44 Stir 30 min at 193-195°F			
	45 Flood to <u>82"</u> & stop agitator <u>SAMPLE -</u>			
	<u>46 DUMP IN 1 DRUM RT-443-D LOT 56495</u>			
	<u>47 STIR 1 HR & STOP AGITATOR</u>			
	Step V-100 V-106 V-260 V-213			
	36 80" (8056 G) 96" (9322 G) 82" (8126 G) 84" (8324 G)			
	START <u>3 PM</u> FIN <u>11 PM</u> OPTR <u>120</u>			
	<u>11:00 PM</u> <u>3:50 AM</u> <u>244</u>			

