

S.V. 107 ~~10~~ C.V. 207
CG 36 CODE RT-695-D PKG.

D.V. 313 322 330

→ DEC 23 80 38437
EST. WGT. 1350 LBS.

STD. HRS. TIME 3 P DEC 23 1960

PROCESSES	APPROVED BY
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()	()
TYPED BY	

B.O. K-922
Done # 126

DEC 23 1960
NON-BLEEDING

EQUIPMENT	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		740-C	
	3 Obtain for 32B		253 22-C	
313 2	4 Run 25" (370G) water into V-313			
	5 Weigh & pour in 14.7 50.32	195	7-D	98
	6 Turn on agitator & steam & dump in from S 2		740-C	500
	Lot 114 100% 39 28.65	60		
	116 441 29.19 445			
	6A Droughan Postal Scale & DUMP IN	2	584-C	2
	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 add 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			
	Record: Start 1:52 Total Min 15 Clarity Green			
207 3	13 Run 1" (125G) water into V-303 207			
	14 When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at 190-195°F. Record: Start 1:54 Total Min 20 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 13 31.50 641		28-D	202
313 5	18 When S14 complete, close V-313 outlet & stop pump			
	19 Run in 10" (192G) water & heat to 180-190°F 190-195°F			
	Circulate thru Sparkler until sol'n is clear. Pump V313 thru Sparkler into V307			
	20 Pump V 313 thru Sparkler into V-307 207 (Sample)			
207 6	21 When HTV blow out Sparkler into V-307 207			
	22 Record: VOLUME 2.1"			
	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.			
	Boil out V-307	1000	2-D	500

EQUIPMENT	PAGE 2 CG 36 CODE RT-695-D	EST. WGT.	1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
1087	25 Run 1" (69G) water into V-207					
	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 34-38°F <i>IF NECESSARY ADJ</i> <i>34-38°F</i> <i>RECORD: TEMP 34°F</i>			330	57-A	174
322	30 Run in 22" (755G) water into V-322					
8	31 Weigh & Pour in	M 17.80.35%		475	7-D	239
	32 Dump in from S3	Lot		424	253-C	424
	33 Weigh on postal scale & add	Lot		10	180-C	10
	34 Heat to 70-90°F					
	35 Sit in in 1-2 min			12	567-B	12
	36 Weigh on postal scale & stir to dissolve			4	479-D	4
1079	37 Run in 14" (1391G) water into V-207					
	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 5.1 (5.0-5.5)					
	42 If pH above 5.5, adj to pH 5.5 or lower Assume 78%			2	27-D	1
	Record: pH 5.2					
	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 13.32.4%		496	725-A	166
10	45 Adj V-322 to 30" (1031) at 70-80°F <i>RECORD: TEMP 70°F</i>					
322	46 Slurry with 30 Gal water in drum, pour in & stir 5 min			73	39-A	73
11						
108	47 Run in N-725-A from S44 AFAP into V-207					
12	48 Stir 30 min at 34-38°F maintaining + CR, + KI				57-A	
	Record: Time Start 5:51 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 (+)			100		
	49 Couple V-322 thru under surface distributor into V-207 in					
	40-45 min Record: Start 6:50 Total min 40					
	50 When S 49 complete, stir 15 min					
	Record: DIAZO (-); BASE (+); pH 11.7 (11.0-11.8) TEMP 60°F (60-65°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					
	Assume 50%				7-D	
	Record: pH				28-D	
	Assume 32%					
	52 Adj to pH 10.2-11.2			80	28-D	2.5
	Record: pH 10.0				7-D	
	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 diluted N7 & N28 for pH adj.					
	See attached sheet for pH adj and					

EQUIPMENT	PAGE 3 CG 36 CODE RT-695-D	EST. WGT.	1350 LBS.	USE LBS.	N CODE	ACCT LBS.
107 12 107	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 9:00 PM Total min 6.0					
	55 When strike complete heat to 210-212°F					
	56 Stir 15 min at 210-212°F					
	57 Flood to 87" (8648G). Record: pH 7.0 (6.5-7.2)					
	58 Stop agitator					
	SAMPLE					
	Start Fin Opt					
	200A 300P 126					
	Delayed 1 1/2 HRS - STEP 29					
	too much volume in vat 307.					
	pumped vat 207 to vat 100					





