S.V. 107 C.V. 100 D.V. 330, 322, 207, 317 DATE PRINTED: 4/07/82

CC 36 CODE RT-695-D PKG ___

7/20/82 (DATE) G2J38 (LOT NUMBER)

PROCESSES ( )RT-695-D (O)

APPROVED BY JJG 3/18/81 EWK 12/7/81

COMTYP JOB NAME = 36RT695DMO

TYPED BY: KLW

EST. WT. 2608* LBS. Pre-coat sparkler STANDARD HRS. _____ TIME _____M

PREPARATION NOTES: _____

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# DICALITE FILTER AID	15	777-A	15
	2	OBTAIN FOR S 6 2-CHLORO-4-AMINO TOLUENE-5 SULFONIC ACID		740-C	
	3	OBTAIN FOR S 42 3-HYDROXY-2-NAPHTHOIC ACID		82-C	
317 2	4	RUN 23* (732G) WATER INTO V-317			
	5	WEIGH & POUR IN SODIUM HYDROXIDE M 10, 49.55%	434	7-D	215
	6	TURN ON AGITATOR & STEAM & DUMP IN FROM S 2 2-CHLORO-4-AMINO-TOLUENE-5-SULFONIC ACID		740-C	1104
		LOT 287 100% 1104 99.30	1112		
		[redacted]			
	8	DUMP IN ACTIVATED CARBON	50	113-B	50
	9	DUMP IN DICALITE, FILTER AID	10	777-A	10
	10	HEAT TO 214-216 DEG. F WATCH FOAM			
	11	RECORD: BY ___(+), IF NECESSARY ADJUST TO + BY SODIUM HYDROXIDE ASSUME 50%		7-D	
	12	STIR 30 MIN. AT 212-214 DEG. F, THEN SHUT OFF STEAM WATCH FOAM NOTE RECORD: SPARKLER PRESSURE 0 PSI IF NOT ZERO, NOTIFY SUPERVISOR			
	13	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR MAINTAIN AT 190-195 DEG. F FOR S 15 RECORD: HT 190 DEG. F & RECORDER 190 DEG.F RECORD: START 10:10 TOTAL MIN 15 CLARITY CLEAR			
				JUL 22 1982	
100 3	14	RUN #1 (99G) WATER INTO V-100			
	15	WHEN S-13 COMPLETE, PUMP V 317 THRU SPARKLER. MAINTAIN V-317 AT 190-195 DEG.F RECORD: START 10:25 TOTAL MIN 15 SAMPLE FROM HOSE. SHOW TO SUPV'R FOR OK			

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EQUIPMENT		PAGE 02 OF 04 CG 36 CODE RT-695-D (O)	USE LBS	N-CODE	ACCT LBS
317 4	16	WHEN S 13 COMPLETE, CLOSE V-317 OUTLET & STOP PUMP			
	17	RUN IN 7" (216G) WATER & HEAT TO 190-195 DEG F			
317 CONT'D 4	18	CIRCULATE THRU SPARKLER UNTIL SOLUTION IS CLEAR MAINTAIN AT 190-195 DEG. F FOR S 19 & RECORD: HT 190 DEG. F & RECORDER RECORD: START 11:20 TOTAL MINS ___ CLARITY OK			
100 5	19	WHEN S 18 IS COMPLETE, PUMP V-317 THRU SPARKLER INTO V-100			
	20	RUN IN 5" (90G) WATER & HEAT TO 190-195 DEG. F			
	21	CIRCULATE 15 MIN THRU SPARKLER, PUMP V-317 THRU SPARKLER INTO V-100			
	22	WHEN MT, BLOW OUT SPARKLER INTO V-100			
	23	HEAT TO 165-170 DEG. F (TAKE 1 QT. SAMPLE) (WITH AGITATION ON) TEST FOR CLARITY OF SOLUTION. SHOW 1 QT. SAMPLE TO SHIFT SUPERVISOR FOR APPROVAL (EXAMPLE OF ACCEPTABLE CLARIFICATION OF N-740-C IS AVAILABLE IN OFFICE TO COMPARE WITH)			
	24	IF S 23 IS OK, CONTINUE WITH S 25. IF S 23 IS NOT ACCEPTABLE, RECLARIFY THRU SPARKLER			
	25	IF S 23 IS OK, REHEAT V-100 TO 165-170 DEG. F FOR S 26 OK [illegible]			
100 6	26	ADJ TO 16" (1590G)			
	27	HEAT V-100 TO 165-170 DEG. F			
	28	RUN IN V-324 HYDROCHLORIC ACID THRU DIRECT LINE AND RINSE IN M 1 29.69 %	1482	28-D	443
	29	STIR 15 MIN AT 165-170 DEG. F			
	30	ADJ TO 50" (4970G) AT 34-38 DEG. F RECORD: TEMP _____ DEG. F AND IF NECESSARY ADJ TO 34-38 DEG. F & RECORD: TEMP _____ DEG. F	50X330 _____	57-A 57-A	16500 _____
107 7	31	RUN 45" (4320G) WATER INTO V-107			
	32	TURN ON AGITATOR AND STEAM AND DUMP IN MANGANESE SULPHATE	1400	336-B	1400
	33	DUMP IN BARIUM SULPHATE	250	65-A	250
	34	HEAT TO 150-160 DEG. F AND STIR			
	35	RECORD: PH 5.9 (5.0-5.5)			
	36	IF PH ABOVE 5.5, ADJ TO PH 5.5 OR LOWER SULFURIC ACID ASSUME 78%	___1___	27-D	___1___
	37	RECORD: PH 5.4			
	38	NOTE: IF PH BELOW 5.0, DO NOT ADJ UPWARD			
	39	HOLD FOR S 58			

EQUIPMENT		PAGE 03 OF 04 CG 36 CODE RT-695-D (O)	USE LBS	N-CODE	ACCT LBS
322 8	40	RUN IN 47" (1610G) WATER INTO V-322			
	41	WEIGH AND POUR IN SODIUM HYDROXIDE M 10 49.55%	949	7-D	470
	42	DUMP IN FROM S 3 3-HYDROXY-2-NAPHTHOIC ACID LOT 7669	934	82-C	934
	43	WEIGH 1-HYDROXY-2-NAPHTHOIC ACID ON POSTAL BALANCE AND ADD LOT 10707	20	180-C	20
	44	HEAT TO 70-90 DEG. F			
	45	SIFT IN BLANCOL N IN ONE TO TWO MINUTES	27	567-B	27
	46	DUMP IN TETRASODIUM PYROPHOSPHATE & STIR 5 MIN OR LONGER TO DISSOLVE	8	479-D	8
313 3 9	47	WEIGH SODIUM NITRITE & POUR INTO V-313 FOR S 50 M 9 33.36%	1094	725-A	365
322 10	48	ADJ V-322 TO 65" (2240G) AT 77-80 DEG. F & RECORD: TEMP 80 DEG. F			
	49	SLURRY TRISULPHOIC SOAP D WITH 30 GALS WATER IN DRUM. POUR IN AND STIR 5 MIN.	160	39-A	160
100 11	50	RUN IN N-725-A FROM S 47 AFAP INTO V-100			
	51	STIR 30 MIN AT 36-38 DEG. F MAINTAINING +CR, +KI		57-A	
	52	RECORD: TIME START 10 PM CR + KI + TEMP 38 DEG. F			
		NOTE:			
		(1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS HYDROCHLORIC ACID ASSUME 32%		28-A	
		RECORD: CR_____(+), KI_____(+)			
		(2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS SODIUM NITRITE ASSUME 33%		725-A	
		RECORD: CR_____(+), KI_____(+) TEMP_____DEG. F			
	53	COUPLE V-322 THRU UNDERSURFACE DISTRIBUTOR INTO V-100 IN 90-110 MIN (USE 9/16"ORIFICE)			
		RECORD: START 1030 TOTAL MIN 100			
	54	WHEN S 53 COMPLETE STIR 15 MIN			
	55	RECORD: DIAZO – (-); BASE + (+)			
		PH 8.0 (7.0-8.0) TEMP 65 DEG. F (60-65 F)			
		NOTE:			
		(1) IF PH IS 5.0-7.0, WEIGH AND DUMP IN 30# "AS IS" N-7-D DILUTED TO 30 GAL AFAP SODIUM HYDROXIDE ASSUME 50%	20	7-D	10
		(2) (FOR PH ADJUSTMENTS USE ONLY DILUTED N-28-D AND N-7-D)			
	56	ADJ TO PH 9.0-9.5 (SEE ATTACHED PH ADJ AID)			
		HYDROCHLORIC ACID ASSUME 32%	–	28-D	
		(1) IF PH IS 6.5-7.0, WEIGH 40# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN & RINSE IN PT. STIR 5 MIN &			
		RECORD: PH 9.5 (9.0-9.5)			

EQUIP MENT		PAGE 04 OF 04 CG 36 CODE RT-695-D (O)	USE LBS	N-CODE	ACCT LBS
100 11 CONT		2) IF PH IS 7.0-7.5, WEIGH 35# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. & RINSE IN PT. STIR 5 MIN & RECORD: PH_____(9.0-9.5)			
		3) IF PH IS 7.5-8.0, WEIGH 30# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. RINSE IN PT. STIR 5 MIN & RECORD: PH_____(9.0-9.5)			
		4) IF PH IS 8.0-8.5, WEIGH 10# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. & RINSE IN PT. STIR 5 MIN & RECORD: PH_____(9.0-9.5)			
		5) IF PH IS 8.5-8.9, WEIGH 5# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. & RINSE IN PT. STIR 5 MIN & RECORD: PH_____(9.0-9.5)			
		6) IF PH IS ABOVE 9.5, DO NOT ADJUST			
	157	RECORD: PH_____SODIUM HYDROXIDE ASSUME 50%	_____	7-D	_____
		NOTE: ADD N-28-D IN 5# "AS IS" INCREMENTS TO APPROACH PH 9.0-9.5 THEN USE LESS N-28-D HYDROXHLORIC ACID (CONCENTRATED N-28-D & N-7-D AND TOO LOW COUPLING TEMPERATURE CAUSES MASSTONE TO GO TOO LIGHT)			
	158	SHUT OFF AGITATOR			
107 12	159	DURING S 53 HEAT V-107 TO 210-212 DEG. F & SHUT OFF STEAM			
		NOTE: IF NECESSARY REHEAT V-107 TO 210-212 DEG. F PRIOR TO START OF STRIKE			
	160	PUMP V-100 INTO V-107 IN 70-75 MIN.			
		LET V-107 TEMP DROP TO 200-205 DEG. F DURING STRIKE THEN MAINTAIN AT 200-205 DEG. F FOR BALANCE OF STRIKE WITH AGITATOR SHUT OFF IN V-100			
		RECORD: START 12:30 PM TOTAL MIN 105			
	161	WHEN STRIKE COMPLETE, HEAT TO 210-212 DEG.F			
	162	STIR 15 MIN AT 210-212 DEG. F			
	163	FLOOD TO 180-190° (18240G)			
		RECORD: PH 7.2 (6.5-7.2) AND STOP AGITATOR			

START	FINISH	OPERATOR
7:00 AM	3:00 PM	409
3	11	120
11:00 PM	3:00 AM	237

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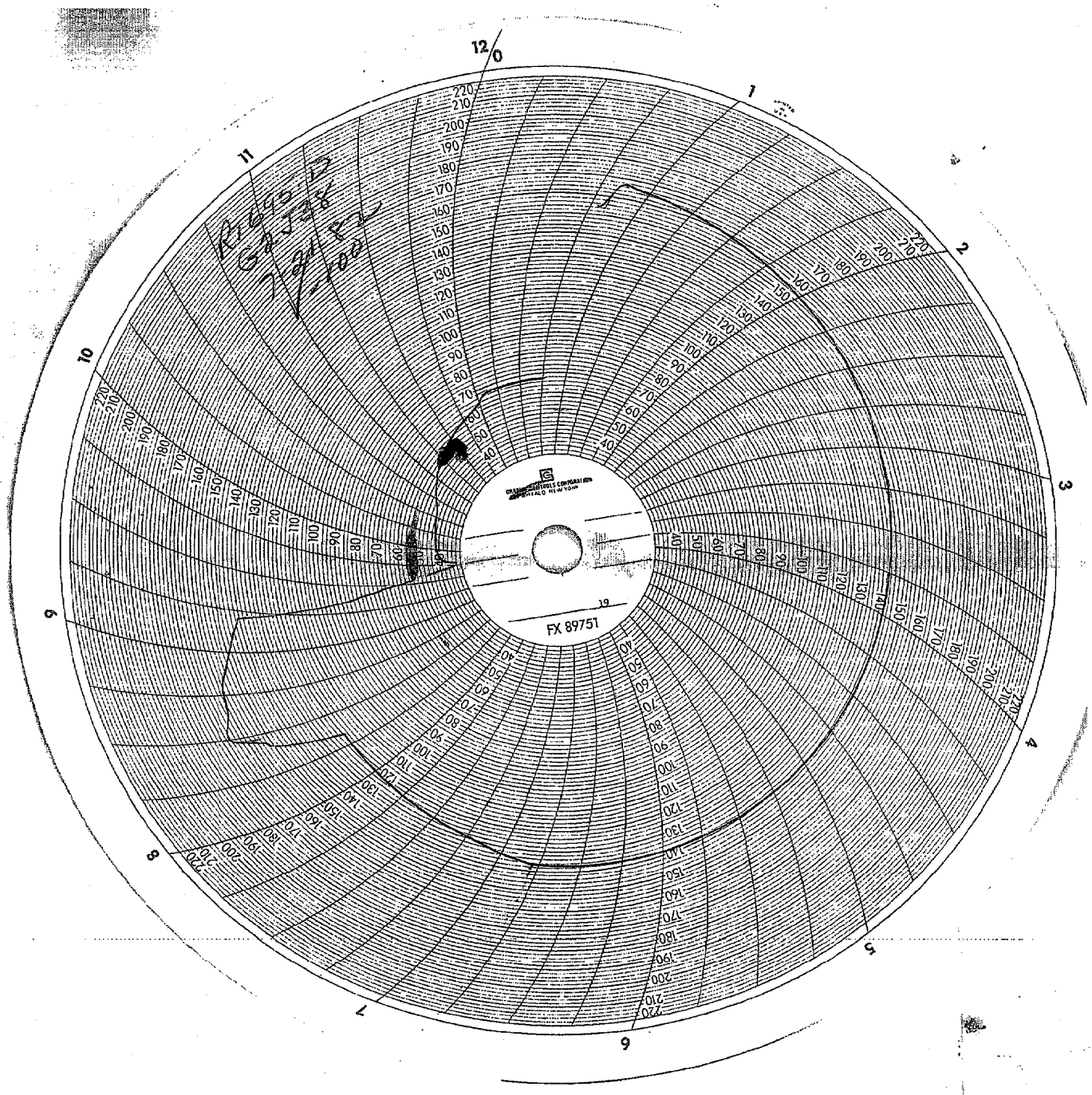

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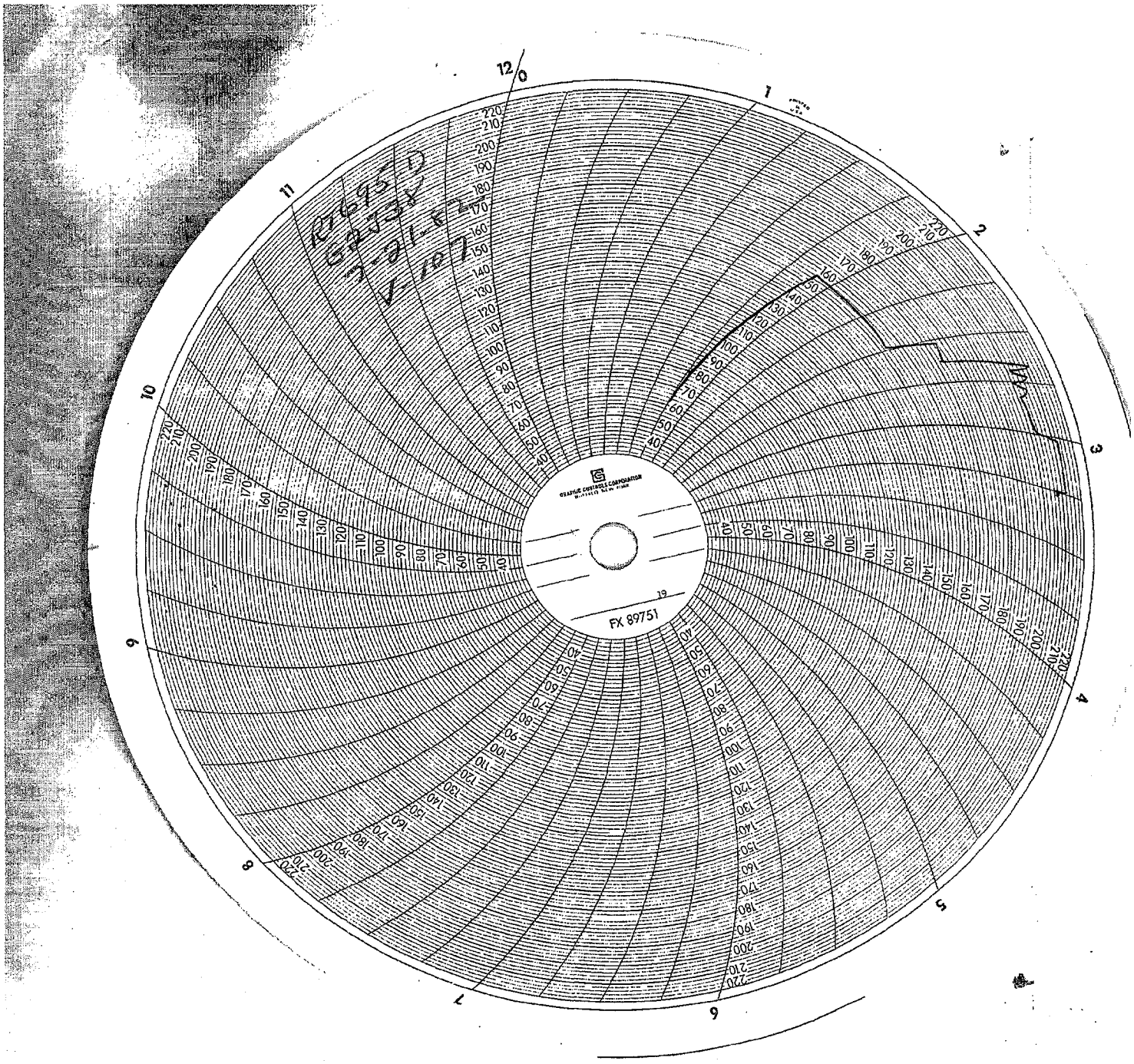

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