CG 36 CODE RT-695-D PKG ___ PROCESSES APPROVED BY

NOV 4 1982 (DATE) L2J26 (LOT NUMBER) ( )RT-695-D (D) JJG 3/18/81 EWK 12/7/81

COMTYP JOB NAME = 36RT695DMD

TYPED BY: KLW

EST. WT. 2608* LBS. STANDARD HRS. _____ TIME 3 P.M.

PREPARATION NOTES: Bailout V322

Precoat Sparkler NON-BLEEDING

EQUIP MENT		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 13, 51.53%	417	7-D	215
	6	TURN ON AGITATOR & STEAM & DUMP IN FROM S 2 2-CHLORO-4-AMINO-TOLUENE-5-SULFONIC ACID		740-C	~~1100~~ 1103
Check Weight Record Result on attached Sheet		LOT 322 100% 640 % 98.53	650		
		LOT 321 100% 321 % 98.30	327		
		LOT 323 100% 142 % 98.47	144		
	7	WEIGH ON POSTAL SCALE 2-AMINO-TOLUENE-5-SULFONIC ACID & ADD LOT _____	1	584-C	1
	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 OK 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 195 DEG.F & RECORDER 195 DEG.F RECORD: START 2 PM TOTAL MIN 15 CLARITY OK			
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 2:30 PM TOTAL MIN 20 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 195 DEG. F & RECORDER RECORD: START 3.0 TOTAL MIN 15 CLARITY 015			
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			
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 3, 30.84%	1436	28-D	443
	29	STIR 15 MIN AT 165-170 DEG. F			
	30	ADJ TO 50" (4970G) AT 34-38 DEG. F RECORD: TEMP 37 DEG. F AND IF NECESSARY ADJ TO 34-38 DEG. F & RECORD: TEMP ____ DEG. F	58 50X330 _____	57-A 57-A	20 1/2 0 _____
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 10.5 (5.0-5.5)			
	36	IF PH ABOVE 5.5, ADJ TO PH 5.5 OR LOWER SULFURIC ACID ASSUME 78%	2	27-D	1
	37	RECORD: PH 4.9			
	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 (D)	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 13 , 51.53%	912	7-D	470
	42	DUMP IN FROM S 3 3-HYDROXY-2-NAPHTHOIC ACID LOT 8338 Check Weight & record results in attached Sheet	939	82-C	939
	43	WEIGH 1-HYDROXY-2-NAPHTHOIC ACID ON POSTAL BALANCE AND ADD LOT 10713	15	180-C	15
	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/ 302 9	47	WEIGH SODIUM NITRITE & POUR INTO V-302 FOR S 50 M 10 , 32.76%	1114	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 5:11 CR + KI + TEMP 37 DEG. F			
		NOTE: (1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS HYDROCHLORIC ACID ASSUME 32% RECORD: CR_____(+), KI_____(+)		28-A	
		(2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS SODIUM NITRITE ASSUME 33% RECORD: CR_____(+), KI_____(+) TEMP_____DEG. F		725-A	
	53	COUPLE V-322 THRU UNDERSURFACE DISTRIBUTOR INTO V-100 IN 90-110 MIN (USE 9/16" ORIFICE) RECORD: START 6 TOTAL MIN 110			
	54	WHEN S 53 COMPLETE STIR 15 MIN			
	55	RECORD: DIAZO St (-); BASE + (+) PH 6.5 (7.0-8.0) TEMP 62 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%	210	7-D	105
		(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 11.4 (9.0-9.5)			

AFTER ADJ. P.H. -DIAZO +BASE

EQUIP			USE	N-CODE	ACCT
EQUIPMENT		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			
	57	RECORD: PH 11.4 SODIUM HYDROXIDE ASSUME 50% 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)		7-D	
	58	SHUT OFF AGITATOR			
107 12	59	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			
	60	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 SIRIKE WITH AGITATOR SHUT OFF IN V-100 RECORD: START 815 TOTAL MIN 110			
	61	WHEN STRIKE COMPLETE, HEAT TO 210-212 DEG.F			
	62	STIR 15 MIN AT 210-212 DEG. F			
	63	FLOOD TO 180-190° (18240G) RECORD: PH 7.4 (6.5-7.2) AND STOP AGITATOR			

START	FINISH	OPERATOR
11 am	7 pm	438
3 pm	11 P	120
11 pm	2 M	438

BORI OUT 322 1 HRS

DUP050061089

CODE: RI-695D LOT L2J26

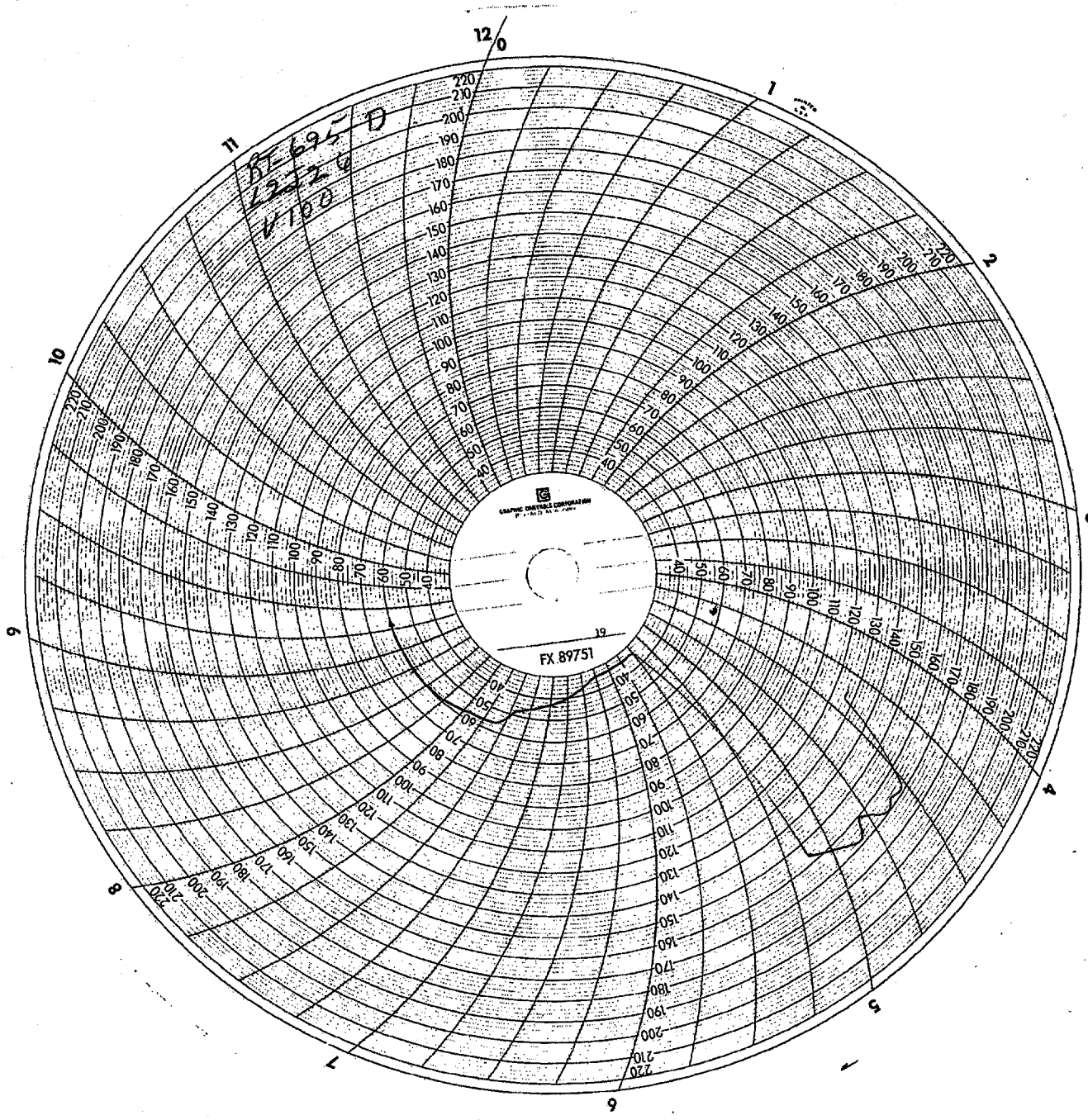
N-740-C CHECK-WEIGH & CALCULATE

DRUM STENCILED					NEWARK CHECK-WEIGH				
LOT	GROSS	TARE	Net	%	GROSS	TARE	NET	X % AS DECIMAL	#100%
[illegible]			325	98.30	346	19	327		
[illegible]			325	98.52	344	19	325		
322			325	98.52	344	19	325		
323	STUMP			98.47	208	19	144		
									1103

46.7
4.60
9.24

N-82-C

8338	266	16	250	-	267	16	251		
8338	266	16	250		267	16	251		939
8338	266	16	250		267	16	251		
8338	266	16	250		157	16	141		
8338	266	16	250		267	16	45		



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