

AUG 4 1980

MAKING INSTRUCTIONS: BATCH UNIT

V. (100)

C.V. 207

D.V. 313, 322, 330

CG 36 CODE RT-695-D PKG.

→ AUG - 7 - 80 36769
EST. WGT. 1350 LBS.

STD. MRS. TIME

PUNCHED & CHECKED

AUG - 7 - 1980

PROCESSES	APPROVED BY
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TYPED BY	

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 USE lots 431, 433, 354, 383, 385 on 404 only		253	
313 2	4 Run 25" (370G) water into V-313			
	5 Weigh & pour in 48.04	204	7-D	98
	6 Turn on agitator & steam & dump in from S 2		740-C	502
	Lot 100% %			
	35 720 98.8	42.5		
	1 82 98.80	84		
	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 7 (+), 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 195°F			
	Record: Start 145 Total Min 15 Clarity OK			
3 207	13 Run 1" (125G) water into V-300 207			
	14 When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at 190-195°F. Record: Start 200 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 7 3162	639	28-D	202
313 5	18 When S14 complete, close V-313 outlet & stop pump			
	19 Run in 13" (192G) water & heat to 180-190°F			
	Circulate thru Sparkler until sol'n is clear			
207	20 Pump V 313 thru Sparkler into V-300 207 (Sample)			
	21 When MTY-blow out Sparkler into V-300 207			
	22 RECORD: VOLUME 11 "			
	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 S-23 is not acceptable re-clarify thru sparkler.			

EQUIPMENT	PAGE 2 CG 36 CODE RT-695-D	EST. WGT.	1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
207	25 Run 1" (69G) water into V-207					
7	26 If S-24 is OK, pump V-320 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			35		
	29 Adj to 33" (2277G) at 32-38°F			27x330	57-A	11,550
322	30 Run in 22" (755G) water into V-322					
8	31 Weigh & Pour in M .48.04%			418	7-D	239
	32 Dump in from S3 USE LOTS 431, 433, 354, 383, 385 Lot			725	262-C	419
				160		
				34		
	33 Weigh on postal scale & add Lot			15	180-C	15
	34 Heat to 70-90°F					
	35 Sift in in 1-2 min			12	567-B	12
	36 Weigh on postal scale & stir to dissolve			4	479-D	4
107	37 Run in 14" (1391G) water into V-107					
9	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 6.2 (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 4 .33.12%			501	725-A	166
10						
322	45 Adj V-322 to 30" (1031) at 70-80°F & RECORD: TEMP 62°F					
11	46 Slurry with 30 Gal water in drum, pour in & stir 5 min			73	39-A	73
207	47 Run in N-725-A from S44 AFAP into V-207					
12	48 Stir 30 min at 32-38°F maintaining + Cr, +KI				57-A	
	Record: Time Start 10:25 PM CR + KI & TEMP 36°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 (+)					
	49 Couple V-322 thru under surface distributor into V-207 in 40-45 min Record: Start 11:25 PM, Total min 45 TEMP 66°F					
	50 When S 49 complete, stir 15 min					
	Record: DIAZO - (-); BASE + (+); pH 12.0 (11.0-11.8)					
	NOTE: (1) If pH is 5.0-7.0, weigh & dump in 15# "as is" N-7-D AFAP Assume 50% Record: pH				7-D	
	51 If necessary, adj to pH 11.4-11.8 Assume 50%				7-D	
	Record: pH Assume 32%				28-D	22
	52 Adj to pH 9.0-9.5 Assume 32%				28-D	
	Record: pH 9.5 Assume 50%				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 N-7 or N-28 for pH adjustment					



