CG 38 CODE RT-695-D PKG ___

JUN 7 1982 (DATE) F2J58 (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. STANDARD HRS. _____ TIME 7A M

PREPARATION NOTES: B.O. V-322 Drum

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	_____	777-A	_____
	2	OBTAIN FOR S 6 2-CHLORO-4-AMINO TOLUENE-5		740-C	
		SULFONIC ACID			
	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 9.___, 49 59 %	434	7-D	215
	6	TURN ON AGITATOR & STEAM & DUMP IN FROM S 2			
		2-CHLORO-4-AMINO-TOLUENE-5-SULFONIC ACID		740-C	1103
		LOT 276 100% 1103 98.57 %	1119		
	7	WEIGH ON POSTAL SCALE 2-AMINO-TOLUENE-5-			
		SULFONIC ACID & ADD LOT 282	/	584-C	/
	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 192 DEG.F & RECORDER 195 DEG.F			
		RECORD: START 4:30A TOTAL MIN 15 CLARITY O.K			
				JUN 9 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 4:45A TOTAL MIN 25			
		SAMPLE FROM HOSE. SHOW TO SUPV'R FOR OK			

6/8

V-107 MAKING INSTRUCTIONS: BATCH UNIT

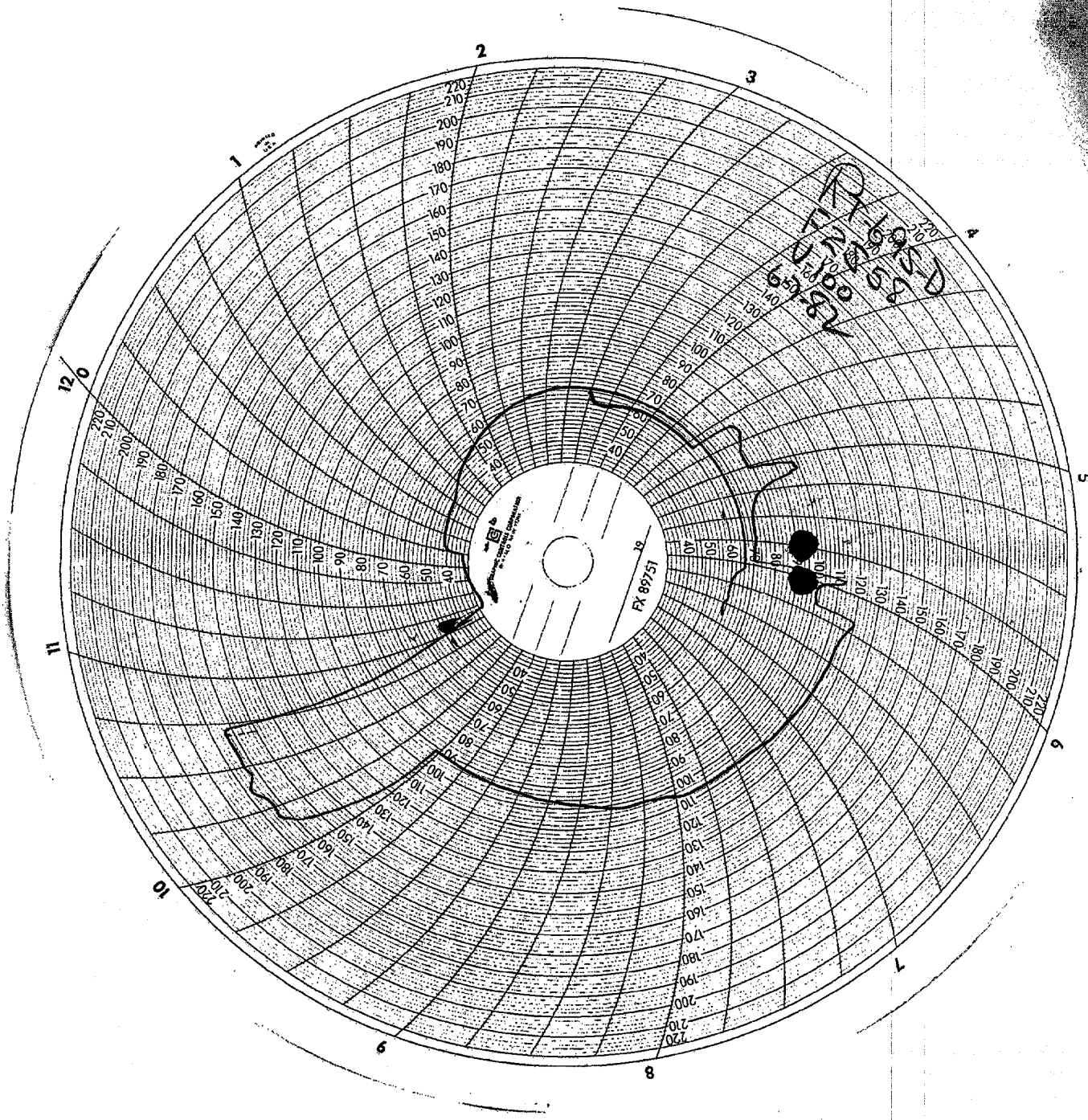
EQUIPMENT		PAGE 02 OF 04 CG 36 CODE RT-695-D (O)	USE LBS	N-CODE	ACCT LBS
317 4	16	WHEN S 13 COMPLETE, CLOSE V-317 OUTLET & STOP PUMP			
	17	RUN IN 7" (216G) WATER & HEAT TO 190-195 DEG F			
317 CONT'D 4	18	CIRCULATE THRU SPARKLER UNTIL SOLUTION IS CLEAR MAINTAIN AT 190-195 DEG. F FOR S 19 & RECORD: HT 192 DEG. F & RECORDER 195 RECORD: START SSA TOTAL MIN 15 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 V-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 1 29.89 %	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 34 DEG. F	50X330 _____	57-A 57-A	16,500 _____
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 6.3 (5.0-5.5)			
	36	IF PH ABOVE 5.5, ADJ TO PH 5.5 OR LOWER SULFURIC ACID ASSUME 78%	3	27-D	2
	37	RECORD: PH 5.3			
	38	NOTE: IF PH BELOW 5.0, DO NOT ADJ UPWARD			
	39	HOLD FOR S 58			

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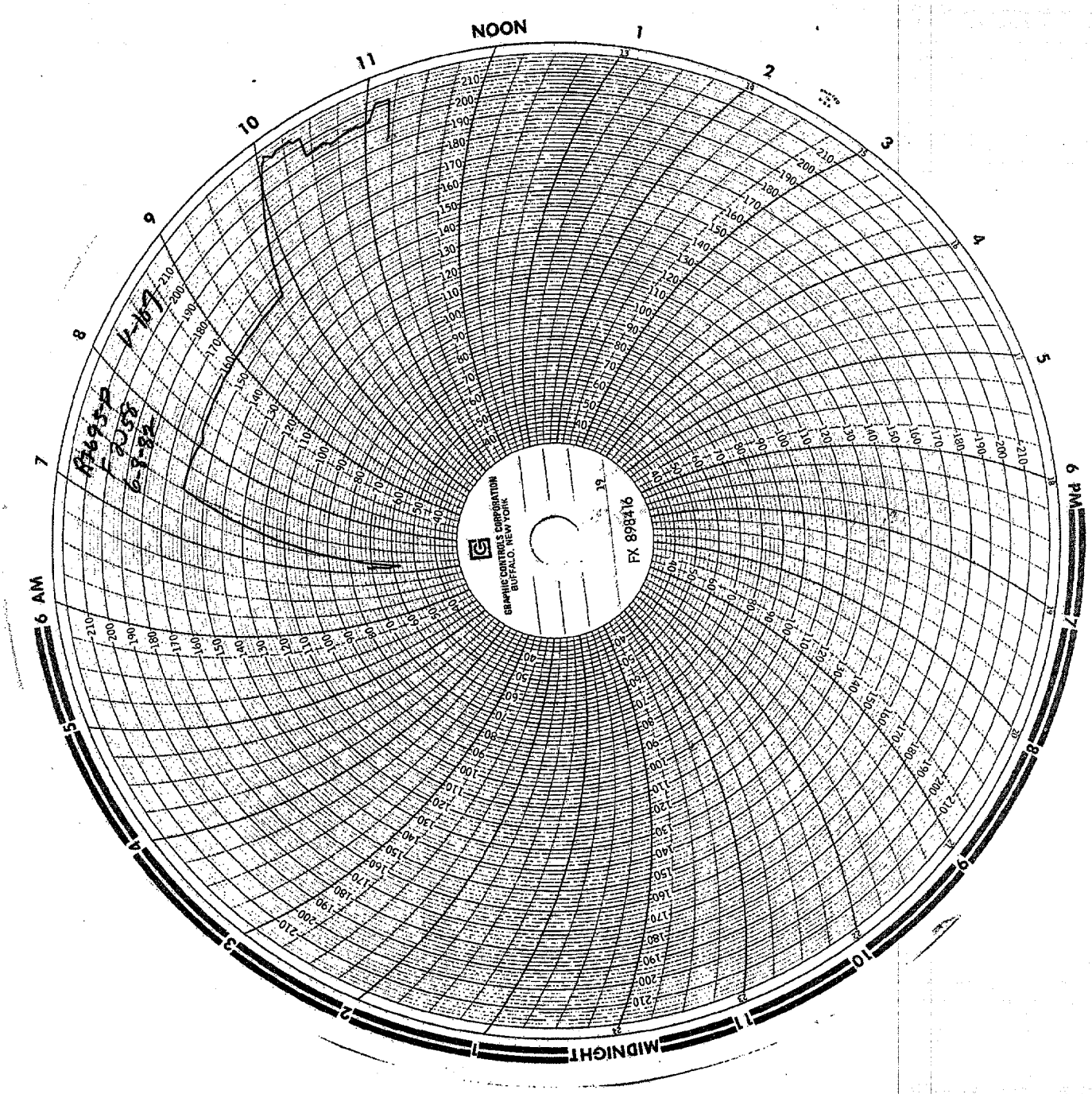
EQUIPMENT		PAGE 03 OF 04 CG 36 CODE RT-695-D (O)	USE LBS	N-CODE	ACCT LBS
322 8	40	RUN IN 47° (1610G) WATER INTO V-322			
	41	WEIGH AND POUR IN SODIUM HYDROXIDE M 9.____, 49 59 %	948	7-D	470
	42	DUMP IN FROM S 3 3-HYDROXY-2-NAPHTHOIC ACID LOT 7490	934	82-C	934
	43	WEIGH 3-HYDROXY-2-NAPHTHOIC ACID ON POSTAL BALANCE AND ADD LOT 10207	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/ 302 9	47	WEIGH SODIUM NITRITE & POUR INTO V-____ 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 78 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 12:15PM, 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 12:55PM TOTAL MIN 110			
	54	WHEN S 53 COMPLETE STIR 15 MIN			
	55	RECORD: DIAZO - (-); BASE + (+)			
		PH 7.0 (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%	60	7-D	50
		(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 9.2 (9.0-9.5)			

EQUIP			USE	N-CODE	ACCT
EQUIP MENT		PAGE 04 OF 04 CG 36 CODE RT-695-D (D)	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 9.2 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)			
	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 STRIKE WITH AGITATOR SHUT OFF IN V-100			
		RECORD: START 4:30 P TOTAL MIN 120			
	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 7.2 (6.5-7.2) AND STOP AGITATOR			

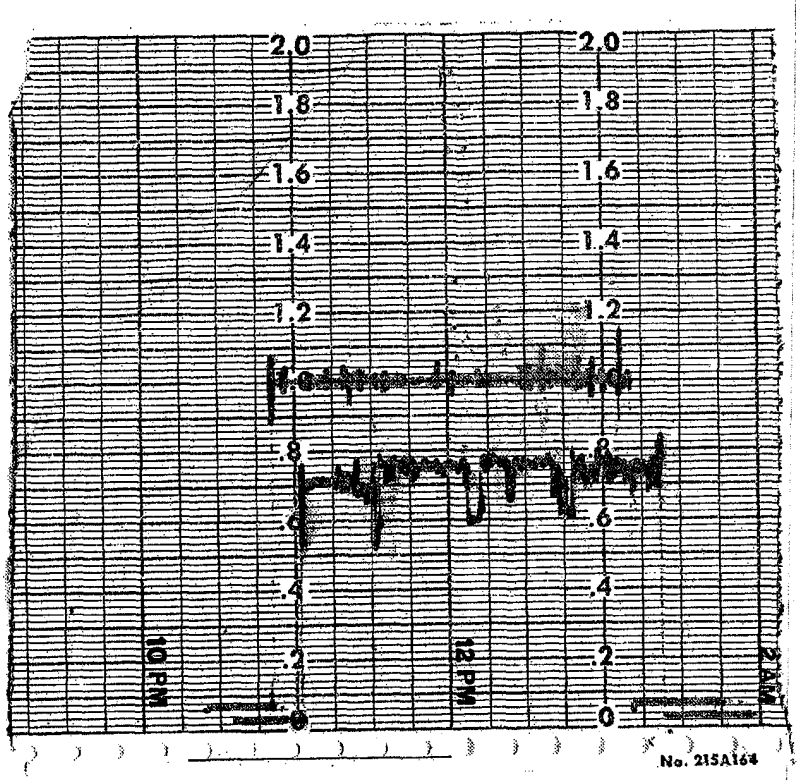
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1:00 PM	3:30 PM	37
3:15 P.M.	7:20 PM	37



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