

V. (107) C.V. 100

MANUAL INSTRUCTIONS. BATCH UNIT
D.V. 330, 322

CG 36 CODE RT-695-D PKG.
EST. WGT. NOV 16 32779
2781 LBS.
STD. HRS. TIME 7:00 AM

PROCESSES	APPROVED BY
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()	()
TYPED BY	

PUNCHED & CHECKED

NOV 18

NOV 17 1979

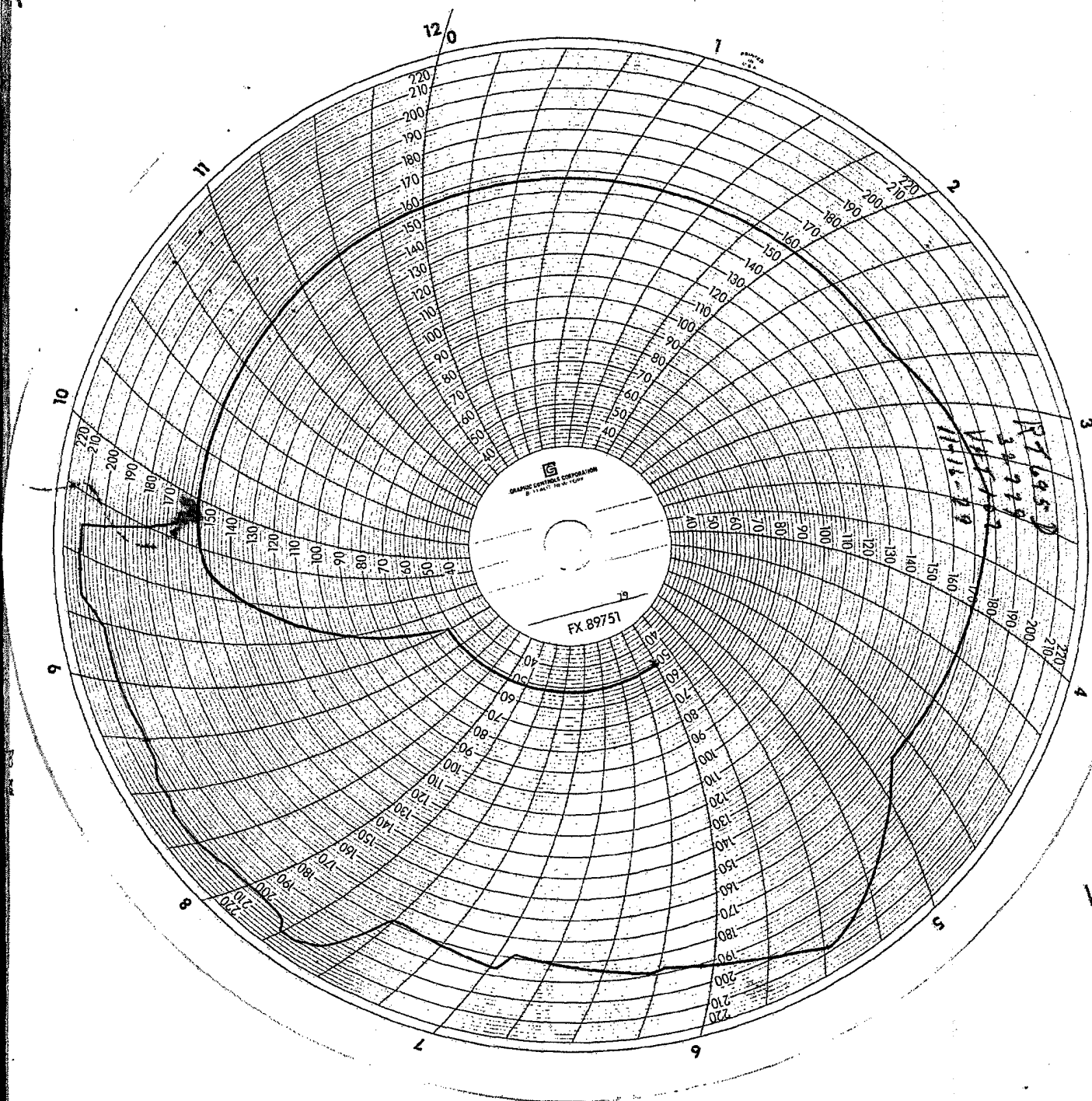
NON-BLEEDING

QUIPMENT	NAME: "BON" RED DARK, OK	USE LBS.	N CODE	ACCT LBS.
REP 1	If necessary, clean, dress Sparkler & pre-coat with 15#		777-A	
1	Obtain for S 6		740-C	
2	Obtain for S 34		82-C	
330 4	Run 1/2" (236) water into V-330			
2	Weigh & POUR IN M 11 .44.29% 436		7-D	215
16	Turn on agitator & steam & dump in from S 2		740-C	1102
	Lot 100% %			
	938 1102 98.67 1117			
7	Dump in	30	113-B	50
8	Dump in	10	777-A	10
9	Heat to 212-214°F			
10	Record: BY (+), if necessary adj to + BY Assume 50% WATCH FOAM		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 S 14 & Record: HT 192°F			
	& Recorder 192°F			
	Record: Start 4:45P Total Min 20 Clarity OK			
-100 3	13 Run 1" (996) water into V-100			
	14 When S 12 complete, pump in V-330 thru Sparkler. Maintain V-330 at 190-195°F. Record: Start 1:00P Total Min 20 SAMPLE FROM NOSE SHOW TO SUPERVISOR FOR			
	15 WEIGH ON POSTAL SCALE & ADD LOT 282 28 5B4C 28			
330 4	16 WHEN S14 COMPLETE, CLOSE V-330 OUTLET & STOP PUMP. R+D			
	17 RUN IN 22" (431 G) WATER & HEAT TO 180-190°F			
-100 5	18 PUMP V-330 THRU SPARKLER INTO V-100			
	19 WHEN MT. BLW OLT SPARKLER INTO V-100			
	20 ADD TO 16" (1590 G) 3			
	21 HEAT TO 165-170°F (TAKE LOT SAMPLE)			
	22 SHOW 1 qt sample to shift supervisor for APPROVAL. (EXAMPLE OF ACCEPTABLE CHARIFICATION OF N740-C IS AVAILABLE IN OFFICE TO COMPARE TO.) - TAKE SAMPLE WITH AGITATION			
	IF S-23 IS OK, CONTINUE WITH S-23.			
	IF S-23 IS NOT ACCEPTABLE, RE-CHARIFY THRU SPARKLER			
	23 RUN IN FROM V-324 THRU DIRECT M.S. 31.62% 1401 28-D 443			
	24 LINES RINSE IN - STIR 15 MIN AT 165-170°F			
	25 ADD TO 50" (4970 G) AT 28-32°F 6570x330 57-A 21450			

(M)

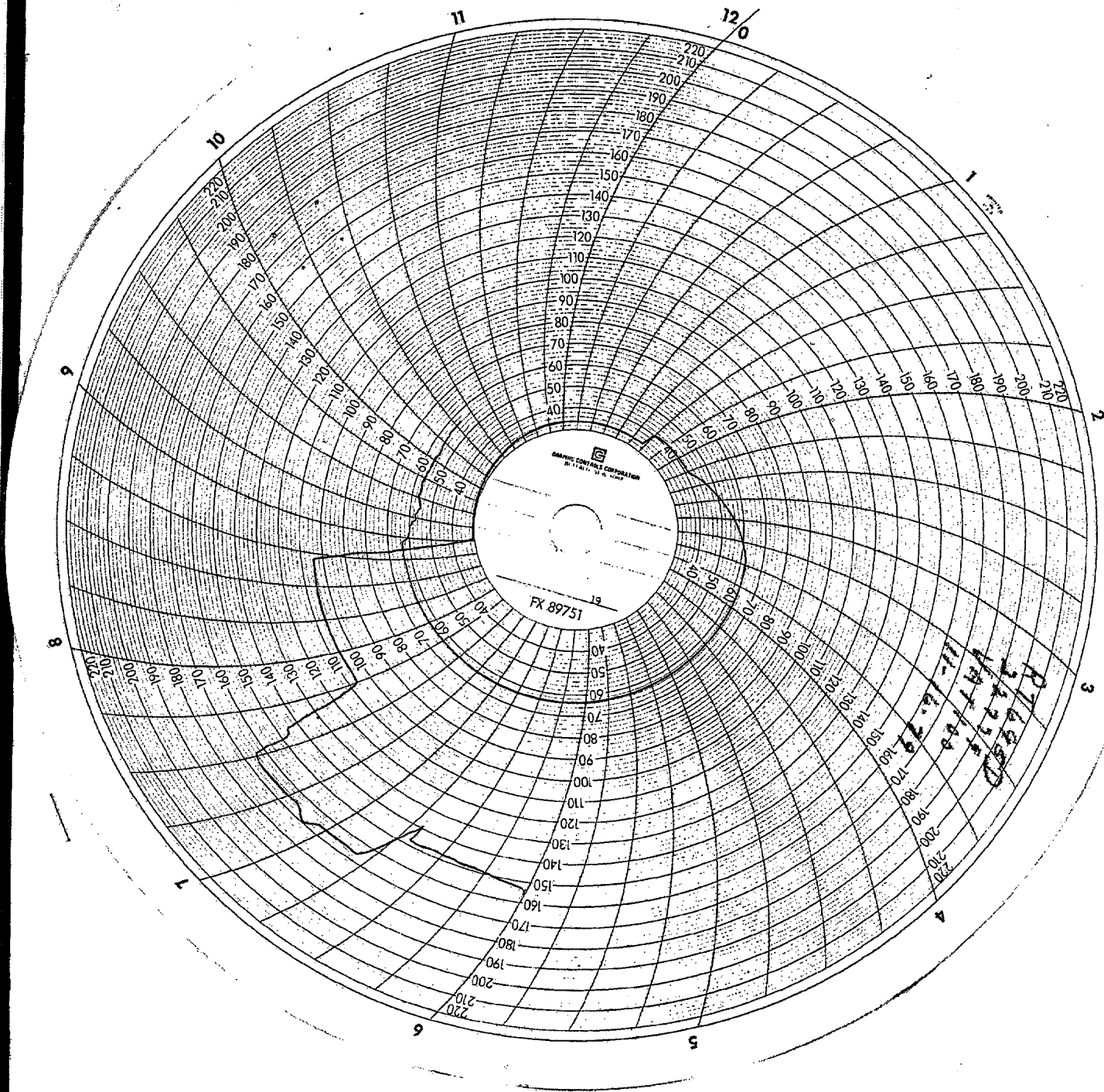
EQUIPMENT	PAGE 2 CG 36 CODE RT-695-D EST. WGT. 2781 LBS.	USE LBS.	N CODE	ACCT LBS.
07	20 RUN 25" (2400G) WATER INTO V-107			
7	21 TURN ON AGITATOR & STEAM & DUMP IN	1400	336-B	1400
	22 DUMP IN	250	65-A	250
	23 HEAT TO 150-160°F & STIR			
	24 RECORD: PH 5.9 (5.0-5.5)			
	25 IF PH ABOVE 5.5, ADJ TO PH 5.5 IN LOWER ASSUME 28%	1	27-D	1
	26 RECORD: PH 4.8			
	27 NOTE: IF PH BELOW 5.0, DO NOT ADJ UPWARD			
	28 HOLD FOR 5 MIN			
322	32 RUN IN 47" (160G) WATER INTO V-322	60	7-D	25
4	33 WEIGH & POUR IN	1065	7-D	525
	34 DUMP IN FROM S3	2768	82-C	968
	35 WEIGH & ADD	18	180-C	18
	36 HEAT TO 70-90°F			
	37 STIR IN IN 1-2 MIN	27	567-B	27
	38 DUMP IN & STIR 5 MIN OR LONGER TO DISSOLVE	8	479-D	8
02/330	39 WEIGH & POUR INTO V-313 FOR 3 1/2	1117	725-A	365
6				
22	40 ADD V-322 TO 65" (2240G) AT 70-80°F			
7	41 SAURY WITH 30 GAL WATER IN DRUM, POUR IN & STIR 5 MIN	160	39-A	160
100	42 RUN IN N-725-A FROM 330 AFAP INTO V-100			
8	43 STIR 15 MIN AT 32-38% MAINTAINING 4 ISR + KI		57-A	
	Record: Time Start 1:30 A, CR +, KI +			
	NOTE: 1. If CR -, KI - add 20% asis increments Assume 32%		28-A	
	Record: CR (+), KI (+)			
	2. If CR +, KI - add 20% asis increments Assume 33%		725-A	
	Record: CR (+), KI (+), Temp 01			
	44 COUPLE V-322 THRU UNDERSURFACE DISTRIBUTOR INTO V-100 IN 90-110 MIN (USE 1/16" ORIFICE)			
	Record: START 2:10 A, TOTAL MIN 102			
	45 WHEN 5% COMPLETE STIR 5 MIN			
	Record: DIAZO = (-), BASE + (+), PH 12.0 (11.4-11.8)			
	NOTE: IF PH 13.5-14.0 WEIGH & DUMP IN 30%			
	"ASIS" N-7-D AFAP ASSUME 50%		7-D	
	Record: PH			
	2. IF NECESSARY, ADJ TO PH 11.4-11.8 ASSUME 50%		7-D	
	Record: PH 11.4			
	46 ADJ TO PH 9.5-10.2-10.6 ASSUME 32%		28-D	
	Record: PH 10.2			
	NOTE: ADD N-28-D IN 5% AS IS INCREMENTS TO APPROACH PH 9.5-10.2 THEN USE LESS N-28-D			
	10.2-10.3			
	(VERY IMPORTANT NOT TO OVERTSHOOT PH BELOW 10.2)			

EQUIPMENT	PAGE 2 CG 36 CODE RT-695-D EST. WGT. 2781 LBS.	USE LBS.	N CODE	AC LB
107	47 DURING 544 HEAT V-107 TO 210-212°F & SHUT OFF STEAM			
	NOTE: IF NECESSARY, REHEAT V-107 TO 210-212°F PRIOR TO START OF STRIKE			
	48 PUMP V-100 INTO V-107 IN 70-75 MIN. LET V-107 TEMP DROP TO 200-205°F DURING STRIKE THEN MAINTAIN AT 200-205°F FOR DURATION OF STRIKE			
	RECORD: START - 11:42 TOTAL MIN			
	49 WHEN STRIKE COMPLETE, HEAT TO 210-212°F			
	50 STIR 15 MIN AT 210-212°F			
	51 PUMP TO 180-190" (18,240 G). RECORD: PH 7.2 (6.5-7.2)			
	STOP AGITATOR			
	SAMPLE			
	START FIN OPTR			
	3:00 PM 11:00 PM 244			
	11 PM 7 A.M. 54-188			
	7 AM 10 AM 438			



DUP050292404

N 31831.01



MD-3-A

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE

RT-695

LOT

32779

NET WT/PKG

NO. PKG

PACK. WGT

LOCATION

PQ

	25	25.48	40.39	

L.W. 2563

STUMP

TOTAL NET WT.

25.48

PKG. N-CODE

PROD. SPVR.

DATE

WHSE. OPER.

RP 11 12577

DUP050292406

N 31831.03

T
96
94
93
96
1.32
1.07
1.07
1.07
1.39
8.7
90
90
91
98
97
98
1.41
8.7
1.11
96
1.43
96
97
94
43
25.48 T

N 31831.04

DUP050292407

CG 36 CODE RT-695-D PKG.

NOV 16 32779

EST. WGT. 2781 LBS.

PROCESSING INSTRUCTIONS: BATCH UNIT

PROCESSES

APPROVED BY

TYPED BY

MAKING NOTES

REMARKS

NAME: "BON" RED DARK

NON-BLEEDING

INSTRUCTIONS

-PRESSING-

RECORD

AT	107					PRESSLOAD	1ST	2ND	3RD	4TH	5TH
DATE	11/17/79					STARTED	12:15 PM				
TIME	10:15 AM					CAKES USED	60				
RELEASED BY	C. S.					WATER ON	8:30 PM				
PRESS	32	33	35	37		HRS. WASHED	16				
NO. OF CAKES	60	60	60	60		OHMS	4000				
PRESS WITHOUT						HRS. WASHED					
WASH TO 4000						OHMS					
TEST AFTER 16						HRS. WASHED					
LOAD on 8 cars						OHMS					
CLEAN PUMP STRAINER & MAGNETIC						CAKE CONDITION					
SEPARATOR AFTER FILLING						NO. CARS LOADED	6				
CLEAN: BY	8:30 PM					EXPLAIN LOSSES					

SAMPLES

DELIVER TO

SAMPLED BY

RELEASED BY

-DRYING-

XXXXXX	XXX	XXX	LUMP: - OK -	WET	- SALTS -	CONTAMINAT
XXXXXX	XXX	XX				
DRY 12 HOURS AT 220 F			No record of any processing			
DRY 12 HOURS AT 180 F						
Mn COLOR			ADDITIONAL DRYING HOURS REQUIRED			
CO ₂ USAGE			NO. DRUMS 17			
SAMPLES			NO. CARS PULLED			
DELIVER TO			LUMP WGT. 563			
OXYGEN 6-9-8			RELEASED BY			

-GRINDING-

MILL 4 HSP 1/8" RP	SCREEN 4600 RPM	SCREEN	RPM
MAX. TEMP. 170 °F		MAX. TEMP.	°F
MN COLOR		EXPLAIN LOSSES	
SAMPLE XXXXXX WITHOUT MIXING		DATE MIXED 2-28	
SAMPLES 1 ENV & 3 PT CANS		SAMPLED BY 11/17/79	
DELIVER TO C.T.L.		RELEASED BY	

DUP050292408

N 31831.05

347.204
51.0
8.0
0.07

1.67

.14 -

1.71

.14 -

1.76

.14 -

1.64

.14 -

1.68

.14 -

1.63

.14 -

1.73

.14 -

1.82

.12 -

1.77

.14 -

1.72

.14 -

1.83

.14 -

1.72

.14 -

1.63

.14 -

1.63

.14 -

1.62

.14 -

1.53

.14 -

2.0

.14 -

25.63 T

DUP050292409

N 31831.06