105 (106) C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V. (300) (315), 317, 322, 323

CG 46 CODE YT-868-D PKG. _____

→ OCT·31 80 37683

EST. WGT. 22[illegible] LBS.

STD. HRS. _____ TIME 7:A M

PROCESSES		APPROVED BY
( ) YT 868-D	(A)	EWK 10/23/76
( )	( )	EAS 5/26/78
( )	( )	DCG 5/30/78
( )	( )	MW 5/30/78
TYPED BY		
TJ 5/5/78		

East Press.

Start immediately on 3rd Shift.

WHAT DAY

PMENT		NAME: DALAMAR® YELLOW	USE LBS.	N CODE	ACCT. LBS.
REP	1	Obtain for S20		157-C	
1	2	Obtain for S's 6 & 38		46-C	
	3	Clean, Dress, close 24" clarif press - 15 frames			
303	4	Run 10 "(253G) water into V-303			
2	5	Pour in M , %	5	727-D	5
	6	Weigh on Postal Scale & dump in From S2		46-C	14
		Note: Break up lumps Lot #100% %			
		01210 14 97.0	14		
	7	Stir 45 min to dissolve for S 11			
DV	8	During S7, Run in 10" (323 G) water into V- 300			
3	9	Dump in & stir 5 min	5	777-A	5
	10	Pump DV thru clarif press to precoat			
303	11	When S7 stir complete weigh on postal M 12 , 33.16 %	12	725-A	4
4		Scale, pour in & stir 5 min			
	12	Adj to 60-62°F Record: Temp 60 °F		57-A	
	13	Siphon in in 4-6 min M 11 , 76.63 %	94	30-D	[illegible]
	14	Adj to 16" (395 G) at 66-70°F		57-A	72
	15	Stir 5 min & Record: pH 3.7 (4.1-4.5)			
	16	If necessary, Adj to pH 4.1-4.5 Assume 77%		30-D	
		& Record: pH 4.1 Assume 50%	3	727-D	
	17	Stir 2 Hrs minimum for S44 maintaining at 66-70°F			
		Record: Start 815A Total min		57-A	
DV	18	During S 17 stir run 10" (323 G) water into V- 300			
5	19	Weigh in from V-324 M 10 , 31.35 %	1461	28-D	458
	20	Dumpin From S1 Lot #100% %		157-C	974
		253 143 71.4	200		
		253 148 73.8	200		
		253 143 71.4	200		
		253 144 71.8	200		
		270 95 54.0	175		
		270 113 64.8	175		
		270 93 53.4	175		
		270 95 62.8	151		

IPMENT		PAGE 2 CG 46 CODE YT-868-D EST. WGT. 2253 LBS.	USE LBS.	N CODE	ACCT. LBS.
DV	21	Stir 10 min or longer to wet			
5	22	Adj DV to 37" (1280 G) at 20-22°F	18x330	57-A	4620
Cont.	23	Siphoning in 12-15 min M 18 , 33.16 %	725	725-A	405
	24	Stir 30 min at 28-32°F maintaining + CR, + KI for S 27		57-A	
		Record: Time Start 945A, CR + (+) KI + (+)			
		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 (+)			
Misc	25	During S 24 stir weigh in drums for S31 M , %	458	727-D	458
6	26	Weigh in Buggy for S 41 M 11 , 76.63%	372	30-D	748
DV	27	When S 24 stir complete, dump in	15	113-A	15
7	28	Dump in	10	777-A	10
	29	Stir 30 min at 28-32°F maintaining +CR, +KI for S 34		57-A	
		NOTE:			
		(1) If CR-, 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 (+)			
CV	30	During S 29 stir, run 10" (970G) water into V- 106 &			
8		install temp chart			
	31	Pour in N-7-D from S25			
	32	Adj to 30" (2928G) at 66-70°F	3x330	57-A	
	33	Close stack damper			
DV	34	When S 29 stir complete, test DV & Record:			
9		Record: CR + (+), KI + (+), temp 28 °F (28-32°F)		57-A	
		NOTE:			
		(1) If CR-, KI- add 20# "as is" increments Assume 32%		28-A	
		Record: CR (+), KI (+)			
		(2) If CR+, KI- add 20# "as is" increments Assume 33%		725 A	
		Record: CR (+), KI (+)			
	35	Pump DV thru clarif press into V- 315 maintaining	2x330	57-A	660
		Temp at 28-32°F Record: time start 1145A Total min 130			
DV	36	During S35, weigh in drums for S56 M , %	350	727-D	350
10	37	Dissolve in 20 gal water in drum for S59	67	979-D	67
CV	38	Dump in from S2 Lot #100% %		46-C	1309
11		Note: Break up lumps 01400 200 98.6	203		
		01460 600 96.8	621		
		01210 200 97.0	206		
		01360 200 97.0	206		
	39	Stir 10 min to dissolve 01400 109 98.6	111		
	40	Open stack damper			
	41	Run in N-30-D from S26 undersurface in 20-25 min			
	42	Stir 5 min & Record: pH 5.5 (5.8-6.3)			
	43	If necessary, adj to pH 5.8-6.3 Assume 50%	40	727-D	40
		& Record: pH 5.8 Assume 77%		30-D	
	44	When S17 stir complete, run in V-303 on surface AFAP			

85V REV.

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MLNI		PAGE 3 CG 46 CODE YT-868-D EST. WGT. 2253 LBS.	USE LBS.	N CODE	ACCT LBS.
DV 12	45	When S35 complete, wash DV lines, pump & press for 20 min or to a - CR test on a sample of total press effluent, which ever comes first . collect washings in DV (S35)			
	46	Stir 5 min & record: Temp 30 (28-32°F) & if necessary, adj to 28-32°F Record: °F, 49 "		57-A	
	47	Weigh in rubber bucket & wash into DV	10	395 D	10
	48	Stir 5 min & Record: KI + (-)			
	49	If necessary adjust to - KI & Record: KI —	30	395-D	30
CV 13	50	When S49 complete, adj CV to 38" (3708G) at 80-84°F & Record: HT 83 °F, REC 84 °F			
	51	Immediately run in DV thru undersurface distributor in 60-65 min. Maintain CV at 80-84°F, Record: Time Start 400pm Total min 65			
MSC 14	52	During S51, weigh in drum for S63 M %	18	721-D	18
	53	During S51, weigh in rubberlined M 10 . 31.35 % Drum for S67	175	28 D	55
CV 15	54	When S51 complete, stir 10 min			
	55	Record: Diazo — (-) Base + (+) pH 4.3 (4.3-4.7)			
		Note:			
		(1) If Diazo +, Base -, and pH below 4.3:			
		(a) adj to pH 4.3-4.7 Assume 50%		721-D	
		(b) record: pH			
		(2) If Diazo +, Base -, and pH 4.3 or above:			
		(a) add 8# 100% N-7-D to a 55 G drum		721-D	
		(b) adj with water to # 25 G			
		(c) add 20# 100% N-46-C		46-C	
		(d) stir to dissolve			
		(e) pour into CV			
		(f) stir to min			
		(3) Repeat (1) & (2) above as necessary to - Diazo, + Base			
	56	Pour in N-7-D from S36			
	57	Stir 10 min & Record: pH 5.6 (9.5 - 10.5)			
	58	If necessary adj to pH 9.5 - 10.5 Assume 32%		28-D	
		& Record: pH 9.7 Assume 50%	70	721-D	70
	59	Dump in N-979-A from S37			
	60	Heat to 200-204°F in 40-45 min			
	61	Shut off steam Record: Time 7:45pm			
	62	Immediately dump in N-7-D from S52			
	63	Stir 5 min & Redord: pH 9.8 (9.5-10.5)			
	64	If necessary, adj to pH 9.5-10.5 Assume 50%		721-D	
		& Record: pH Assume 32%		28-D	
	65	If necessary, reheat to 200-204°F then shut off steam			
	66	Stir 30 min or longer from S61 Record: Stir time 40			
	67	Pour in N-28-D from S53			
	68	Stir 5 min & Record: pH 5.3 (5.5-6.5)			
	69	If necessary adj to pH 5.5-6.5 Assume 32%		28-D	
		& Record: pH 5.7 Assume 50%	7	721-D	7
	70	Flood to 94" (9174G) & stop agitator			

START	FIN	OPTR
7:00 A	8:00 A	259
3:00pm	9:15pm	320

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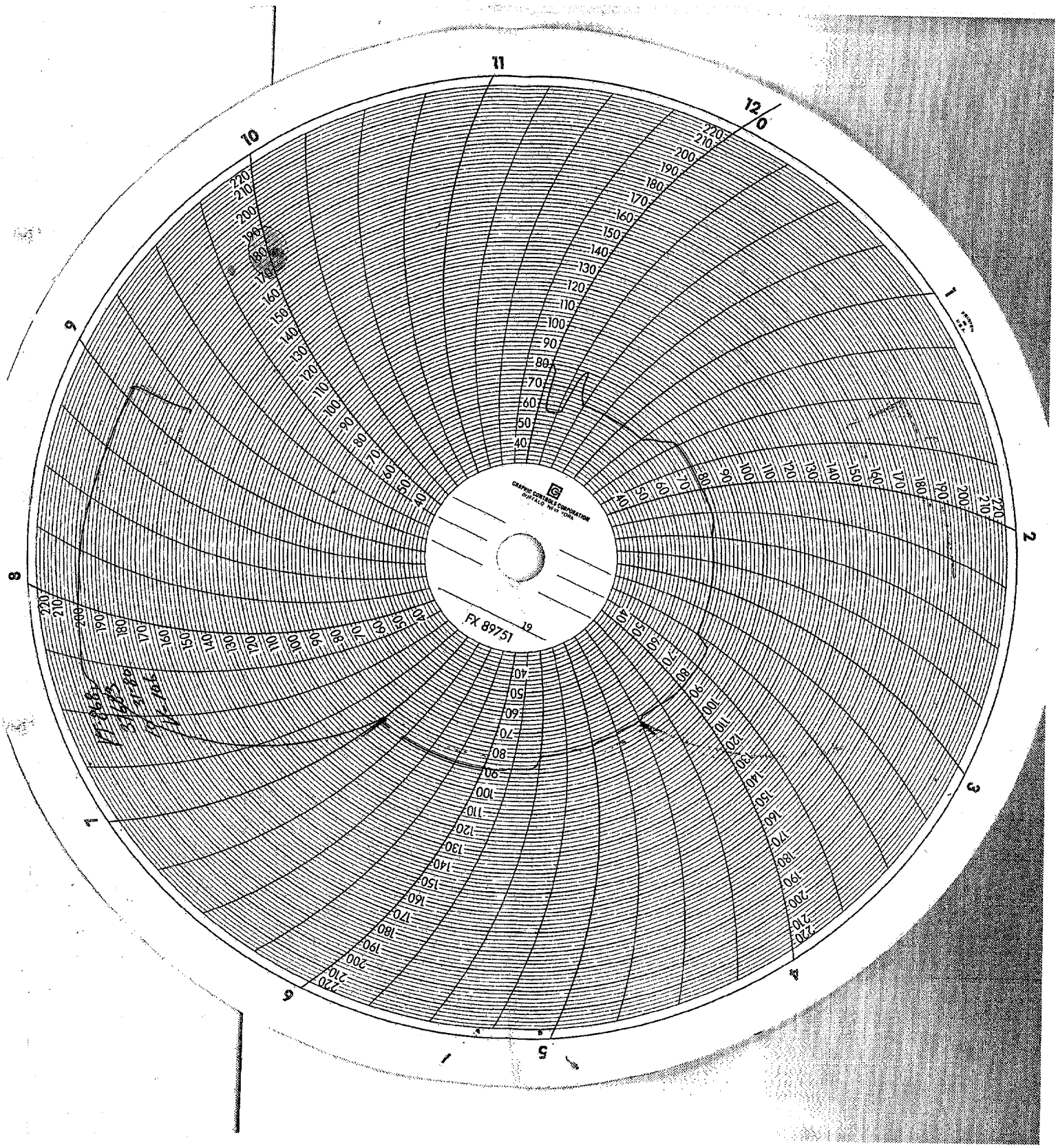

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