S.V. (105) 106 C.V. MAKING INSTRUCTIONS: BATCH UNIT

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

CG 46 CODE YT-868-D PKG.

→ JAN 25 34027

EST. WGT. ~~2000~~ 224/ LBS.

STD. HRS. TIME 3P 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 6/6/78		

But. R&D to follow

. Use N-157-C lot 165, 173, 174, 175 only Carry Over

. Do not use N-41-C lot 92150

. Add 1F N 504C in V-303 last Boil out with N-28-D

BLEEDING

EQUIPMENT		NAME: DALAMAR® YELLOW	USE LBS.	N CODE	ACCT. LBS.
PREP	1	Obtain for S20 Use N-157-C lot 165, 173, 174, 175 only		157-C	
1	2	Obtain for S's 6 & 38 Do not use lot 92150		46-C	
	3	Clean, Dress, close 24" clarif press & 15 frames			
303	4	Run 10 "(253G) water into V-303			5
2	5	Pour In M 2, 518.46 %	10	7-D	50
	6	Weigh on Postal Scale & dump in From S2		46-C	14
		Note: Break up lumps Lot #100% % 91700 91.6	15		
	7	Stir 45 min to dissolve for S 11			
DV	8	During S7, Run in 10" (323 G) water into V-			
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	725-A	4
4		Scale, pour in & stir 5 min			
4 yds	12	Adj to 60-62°F Record: Temp 60 °F		57-A	
	13	Siphon In, in 4-6 min M 2, 79.21 %	97	30-D	78
	14	Adj to 16" (395 G) at 66-70°F		57 A	
	15	Stir 5 min & Record: pH 3.8 (4.1-4.5)			
	16	If necessary, Adj to pH 4.1-4.5 Assume 77%		30-D	
		& Record: pH 4.23 Assume 50%	5	7-D	3
	17	Stir 2 Hrs minimum for S44 maintaining at 66-70°F			
		Record: Start 6:10 PM Total min 260	1	57-A	1
DV	18	During S 17 stir run 10" (323 G) water into V-			
5	19	Weigh in from V-324 M 1, 31.76 %	1442	28-D	458
	20	Dump In From S1 Lot #100% %		157-C	974
		183 102 50.4	202		
		181 134 66.8	200		
		183 94 49.0	203		
		191 125 65.0	194		
		193 103 54.0	199		
		185 102 50.8	200		
		127 124 63.0	197		
		131 125 64.0	195		
		171 59 34.6	99		

K-18620 REV.

EQUIPMENT		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	10 ~~10x330~~	57-A	3300
Cont.	23	Siphon in in 12-15 min M 1, 33.52%	1208	725-A	405
	24	Stir 30 min at 28-32°F maintaining + CR, + KI for S 27		57-A	
		Record: Time Start 7:25p, 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 2, 49.46%	942	7-D	466
6	26	Weigh in Buggy for S 41 M 2, 74.01%	963	30-D	783
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- &			
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 32 °F (28-32°F) to 28°F after rice	2X330	57-A	660
		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%	20	725 A	7
		Record: CR + (+), KI + (+) after 15 min stir			
	35	Pump DV thru clarif press into V- 323 maintaining	2x330	57-A	660
		Temp at 28-32°F Record: time start 9:25 Total min 75			
~~DV~~	~~36~~	~~During S35, weigh in drums for S59 M , %~~		[redacted]	
Misc 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	[redacted]
11		Note: Break up lumps 92050 794 [illegible]	846		[redacted]
		92350 196 92.0	213		1303
		91690 195 95.6	204		
		92870 118 91.6	129		
	39	Stir 10 min to dissolve			
	40	Open stack damper			
	41	Run in N-30-D from S26 undersurface in 20-25 min			
	42	Stir 5 min & Record: pH 5.9 (5.8-6.3)			
	43	If necessary, adj to pH 5.8-6.3 Assume 50%		7-D	
		& Record: pH ✓ Assume 77%		30-D	
	44	When S17 stir complete, run in V-303 on surface AFAP			

K 13830 REV.

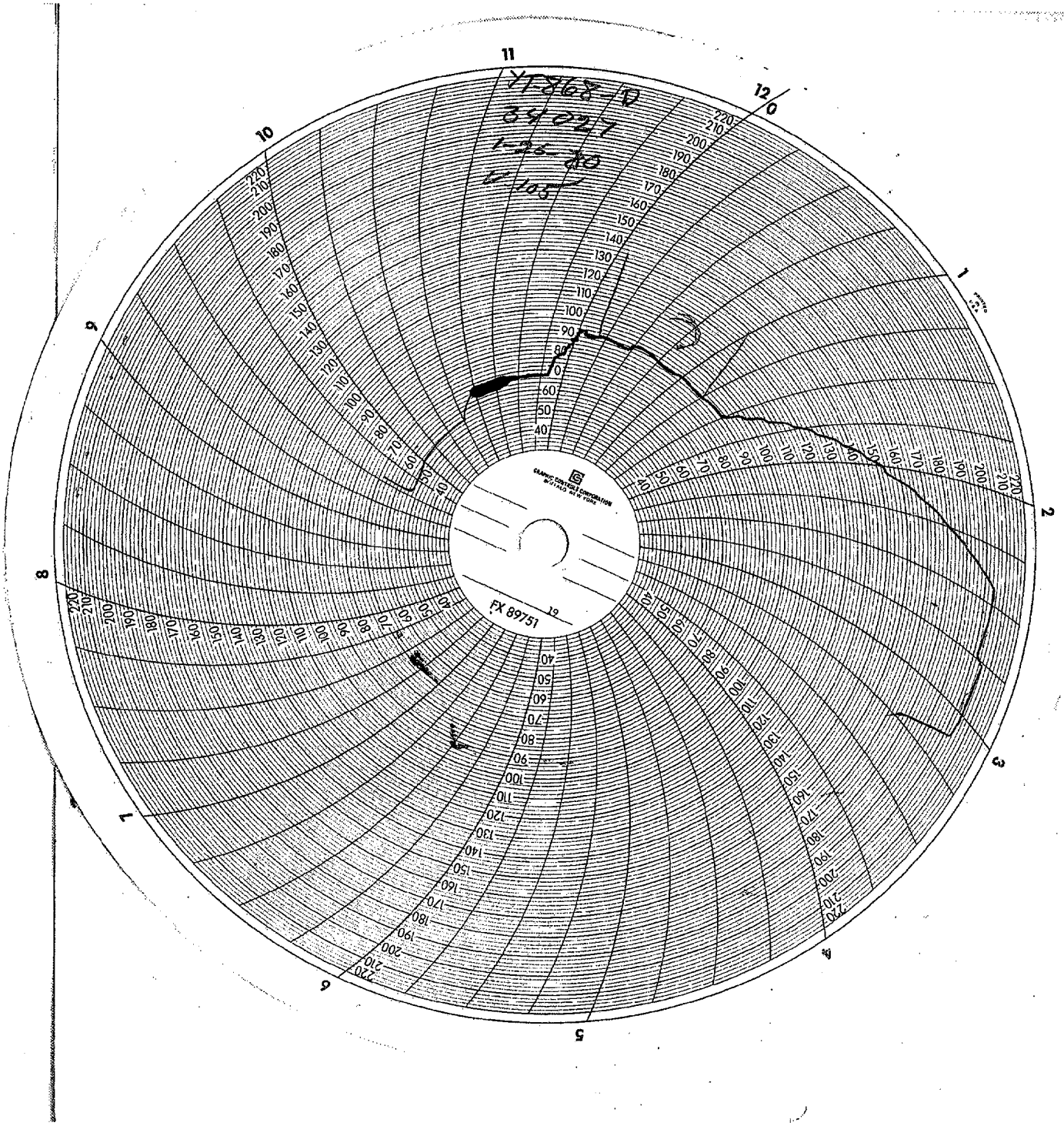
DUP050293458

EQUIPMENT		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 210 (28-32°F) & if necessary, adj to 28-32°F Record: ✓ °F, .52 "		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		395-D	
CV 13	50	When S49 complete, adj CV to 38" (3708G) at 80-84°F			
		Record: HT 82 °F, REC 90 °F			
	51	Immediately run in DV thru undersurface distributor in 60-65 min. Maintain CV at 80-84°F. Record: Time Start 12:10 A.M			
		Total min 65			
[redacted]					
		Drum for S67			
CV 15	54	When S51 complete, stir 10 min			
	55	Record: Diazo — (-) Base + (+) pH 4.4 (4.3-4.7)			
		Note:			
		(1) If Diazo +, Base -, and pH below 4.3:			
		(a) adj to pH 4.3-4.7 Assume 50%		7-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		7-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			
[redacted]					
5		A[redacted] Ass[redacted] 50%			
	59	Pump in N-979-A from S37			
	60	Heat to 200-204°F in 40-45 min			
	61	STIR 30 MIN AT 200-204°F RECORD: TIME 2:50 A.M.			
	62	SHUT OFF STEAM			
	63	RECORD: PH 4.25 (4.2-4.7)			
	64	PUMP T094 (9174G) & STOP AGITATOR & Record			
[redacted]					

START	FIN	OPTR
3 pm 11:00 P.M	4 pm 3:50 AM	438 381

13830 REV.

DUP050293459



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