

105 (106)

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

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

CG 46 CODE YT-868-D PKO.

OCT 30 80 37637

EST. WGT. 224/LBS.

STD. HRS. TIME

PUNCHED & CHECKED

OCT 31 1980

PROCEDURE		APPROVED BY	
1) YT-868-D	A)	ENK	10/23/76
		EAS	5/26/78
		DCG	5/30/78
		NW	5/30/78
TYPED BY			
11/5/78			

EAST
press.

BLEEDING

SHIPMENT	NAME: DALANARD YELLOW	USE LBS.	N CODE	ACCT. LBS.
PREP	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" (2530) water into V-303	5	721	5
2	5 Pour in		721	5
	6 Weigh on Postal Scale & dump in from S2		46-C	
	Note: Break up lumps Lot #100%			
	01210 14 97.0	14		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 22, 33.16 %	12	725-A	4
	12 Scale, pour in & stir 5 min			
	13 Adj to 60-62°F Record: Temp 62°F	1133.0	57-A	33.0
	14 Siphon in in 4-6 min	26.63 %	30-D	72
	15 Adj to 16" (395 G) at 66-70°F		57-A	
	16 Stir 5 min & Record: pH 7.1 (4.1-4.8)			
	17 If necessary, Adj to pH 4.1-4.8		30-D	
	& Record: pH		7-D	
	18 Stir 2 Hrs minimum for S44 maintaining at 66-70°F			
	Record: Start 7:30 PM Total min 120		57-A	
DV	19 During S 17 stir run 10" (323 G) water into V-300			
5	20 Weigh in from V-324	146.1	28-D	458
	21 Dump in from S1 Lot #100%		157-C	974
	252 126 63.2 200			
	252 130 64.8 200			
	252 129 64.4 200			
	252 130 65.2 200			
	252 128 64.0 200			
	252 147 73.6 200			
	252 130 64.8 200			
	252 34 63.6 85			

N35217

IPMENT	PAGE 2 CG 46 CODE YT-8684D	EST. WGT. 2253	LBS.	USE LBS.	N CODE	ACCT LBS.
DV 5	21 Stir 10 min or longer to wet					
Cont.	22 Adj DV to 37" (1280 G) at 20-22°F			18x330	57-A	5940
	23 Siphon in in 12-15 min	M 12	32.16 %	1221	725-A	405
	24 Stir 30 min at 28-32°F maintaining + CR, + KI for S 27				57-A	
	Record: Time Start 9:30 PM, 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 6	25 During S 24 stir weigh in drums for S31 M			466	725-A	466
	26 Weigh in Buggy for S 41 M 11	26.63 %		930	30-D	400
						713
DV 7	27 When S 24 stir complete, dump in			15	113-A	15
	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 8	30 During S 29 stir, run 10" (970G) water into V-106 & install temp chart					
	31 Pour in N-7-D from S25					
	32 Adj to 30" (2928G) at 66-70°F			2 2x330	57-A	660
	33 Close stack damper					
DV 9	34 When S 29 stir complete, test DV & Record:					
	Record: CR + (+), KI + (+), temp 30 °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 Temp at 28-32°F Record: time start 10:45 PM Total min 90			2x330	57-A	660
DV 10	36 During S 26, weigh in drums for S55 M					
	37 Dissolve in 20 gal water in drum for S59			67	979-D	67
CV 11	38 Dump in from S2 Lot #100% %				46-C	1000
	Note: Break up lumps 01430 800 96.8 826 1262					
	01460 465 97.0 479					
	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 6.1 (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					

		PAGE 3 CG 46 CODE YT-868-D	EST. WGT. 2253	LBS.	USE LBS.	N CODE	ACCT LBS.
✓ 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 <u>28</u> (28-32°F) & if necessary, adj to 28-32°F Record: <u>28</u> °F, <u>58</u> "					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 -				12	395-D	12
CV 13 ✓ 50	When S49 complete, adj CV to 38" (3708G) at 80-84°F & Record: HT <u>82</u> °F, REC <u>82</u> °F						
✓ 51	Immediately run in DV thru undersurface distributor in 60-65 min. Maintain CV at 80-84°F, Record: Time Start <u>3:50am</u> Total min <u>70</u>						
MSC	52 Dump in N-7-B from S36			%		7-D	
	53 Dump in N-7-B from S36			%		7-D	
	54 Dump in N-7-B from S36			%		7-D	
CV 15 ✓ 54	When S51 complete, stir 10 min						
✓ 55	Record: Diazo - (-) Base + (+) pH <u>4.4</u> (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						
✓ 56	Pour in N-7-B from S36						
✓ 57	Stir 10 min & record: pH <u>4.2</u> (4.2-4.7)						
✓ 58	If necessary adj to pH 4.2-4.7 Assume 50%					7-D	
	& Record: pH Assume 32%					28-D	
✓ 59	Reheat to 200-204°F then shut off steam						
✓ 60	Record: Stir time <u>5:25 am</u>						
✓ 61	Stir 30 min						
✓ 62	Pour in N-7-B from S36						
✓ 63	Stir 5 min & Record: pH <u>4.2</u> (4.2-4.7) Assume 50%					7-D	
✓ 64	If necessary, adj to pH <u>4.2-4.7</u> Assume 32%					28-D	
✓ 65	& Record: pH						
✓ 66	If necessary, reheat to 200-204°F then shut off steam						
✓ 67	Record: Stir time <u>5:25 am</u>						
✓ 68	Stir 30 min						
✓ 69	Pour in N-7-B from S36						
✓ 70	Flood to 94" (9174G) & stop agitator						

START	FIN	OPTR
<u>8:45P</u>	<u>3:00P</u>	<u>126</u>
<u>5:45 PM</u>	<u>11:00 PM</u>	<u>237</u>
<u>11: PM</u>	<u>6:30 AM</u>	<u>223</u>

120
~~908~~

FORM A

CODE 4-868-D LOT 37637 VATS 106-303-315 EQUIP. E. PRESS.

DATE 12-30-80 OPER. BRITT #223 SUPERVISOR _____

- ✓1. Used all stumps, leave 1 stump identified.
- ✓2. Clean shovel.
- ✓3. Chute washed & top replaced.
- ✓4. Water hose coiled.
- ✓5. Steam ejector turned off after finished in vat.
- ✓6. Scale left clean.
- ✓7. Added ice to vat only when volume reaches agitator.
- ✓8. Floor cleaned around vats used.
- ✓9. Hoses coiled or on rack on diazo press.
- ✓10. Hoses not crossing walkway after finished.
- ✓11. Pump shut off after removing hose from intake.
- ✓12. Ice blower shut off after using.
- ✓13. All spills in area worked clean.
- ✓14. Door on instruments closed.
- ✓15. All empty drums removed from area & discarded.
- ✓16. Corrosive containers properly covered.
- ✓17. Top of vats cleaned of color, paper cups, strings, etc.
- ✓18. Vat door closed after finished - hatches on abbe's.
- ✓19. All tools cleaned & placed in rack or proper places.
- ✓20. Ice house clean - tools on racks.
- ✓21. Revolvator cleaned - platform & pit.

ATTACH TO MAKE CARD

