AUG 12 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 100 G.V. 207 D.V. 313, (322,) 330

CG 36 CODE RT-695-D PKG.

→ AUG·14·80 36849

EST. WGT. 1350 LBS.

STD. HRS. TIME 7AM

PROCESSES		APPROVED BY
( )	( )	
( )	( )	
( )	( )	
( )	( )	
TYPED BY		

PUNCHED & CHECKED

AUG 1 9 1980

NON-BLEEDING

EQUIPMENT		NAME: "BON" RED DARK	USE LBS.	N CODE	ACCT. LBS.
Prep 1	1	If necessary, clean, dress sparkler & pre-coat with 15#	15	777-A	1
	2	Obtain for S 6		740-C	
	3	Obtain for 32B Use Lot 496		253-C	
313 2	4	Run 25" (370G) water into V-313			
	5	Weigh & pour in 2 - 48.64	304	7-D	98
	6	Turn on agitator & steam & dump in from S 2		740-C	502
		Lot 100% % 53 502 98.5	510		
	7	Dump in	23	113-B	23
	8	Dump in	5	777-A	15
	9	Heat to 212-214°F WATCH FOAM			
	10	Record: BY 1 (+), if necessary adj to + BY Assume 50%		7-D	
	12	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 S14 Record: HT 195 °F & Recorder 195 °F			
		Record: Start 210R Total Min 20 Clarity 2S			
313 3 207	13	Run 1" (125G) water into V-313 207			
	14	When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at 190-195°F. Record: Start 14 Total Min 25 Sample-From Hose Show to supervisor for OK			
	15	Weigh on Postal Scale & Add Lot		584-C	2
322 4	16	Run in 2" (66G) water into V-322			
	17	Weigh in plastic lined Drums & Pour in & hold for S 28 M 7 31162	639	28-D	202
313 5	18	When S14 complete, close V-313 outlet & stop pump			
	19	Run in 13" (192G) water & heat to 180-190°F Circulate thru Syarkler until sol'n is clear.			
313 6 207	20	Pump V 313 thru Sparkler into V-313 207 (Sample)			
	21	When MTY-blow out Sparkler into V-313 207			
	22	RECORD: VOLUME 13½"			
	23	Heat to 165-170°F Take (1 qt sample) Show 1 qt sample to shift supervisor for approval. (Example of acceptable clarification of N-740-C is available in office to compare to) Take sample with agitation			
	24	If S-23 if OK, continue with S-25. If S-23 is not acceptable, re-clarify thru sparkler.			

HRE

K 13829 REV.

EQUIPMENT		PAGE 2 CG 36 CODE RT-695-D EST. WGT. 1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
207	25	~~Run 1" (69G) water into V-207~~			
7	26	~~If S-24 is OK, pump V-330 at 165-170°F into V-207~~			
	27	Heat V-207 to 165-170°F			
	28	Run in V-322, N-28-D, from S17 & rinse in			
	29	Adj to 33" (2277G) at 32-38°F 45	~~27~~x330	57-A	14850
322	30	Run in 22" (755G) water into V-322			
8	31	Weigh & Pour in M 7 , 48.04	478	7-D	239
	32	Dump in from S3 use Lot 496 Lot 496	419	253 ~~[illegible]~~-C	~~[illegible]~~ 419
	33	Weigh on postal scale & add Lot 91224	15 ~~[illegible]~~	180-C	~~[illegible]~~ 15
	34	Heat to 70-90°F			
	35	Sift in in 1-2 min	12	567-B	12
	36	Weigh on postal scale & stir to dissolve	4	479-D	4
100	37	Run in 14" (1391G) water into V-100			
9	38	Turn on agitator & steam and dump in	650	336-B	650
	39	Dump in	200	65-A	200
	40	Heat to 150-160°F & stir to dissolve N-336-B			
	41	Record: pH 5.5 (5.0-5.5)			
	42	If pH above 5.5, adj to pH 5.5 or lower Assume 78%		27-D	
		Record: pH			
		NOTE: If pH below 5.0, do not adj upward			
	43	Hold for S 49			
302	44	Weigh and pour into V-302 for S 47 M 9 , 33.12%	501	725-A	166
10					
322	45	Adj V-322 to 30" (1031) at 77-80°F & RECORD: TEMP 80°F			
11	46	Slurry with 30 Gal water in drum, pour in & stir 5 min	73	39-A	73
207	47	Run in N-725-A from S44 AFAP into V-207			
12	48	Stir 30 min at 32-38°F maintaining + Cr, +KI		57-A	
		Record: Time Start 9:35 CR + KI + TEMP 32 °F			
		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 As sume 33%		725-A	
		RECORD: CR (+), KI (+)			
	49	Couple V-322 thru under surface distributor into V-207 in			
		40-45 min Record: Start 10:10 Total min 41			
	50	When S 49 complete, stir 15 min			
		Record: DIAZO — (-); BASE + (+); pH 12.2 (11.0-11.8) TEMP 60 °F			
		NOTE: (1) If pH is 5.0-7.0, weigh & dump in 15# "as is" N-7-D AFAP		7-D	
		Assume 50% Record: pH			
	51	~~If necessary, adj to pH 11.4-11.8~~ Assume 50%		7-D	
		Record: pH Assume 32%		28-D	
	52	Adj to pH ~~[illegible]~~ 9.5-10.0 Assume 32%	120	28-D	38
		Record: pH Assume 50%	—	7-D	
		NOTE: Add N-7-D in 20# "as is" increments to approach pH 9.0-9.5 Then use less N-28-D			
		use only diluted N7 + N28 for pH adjustment			

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EQUIPMENT		PAGE 3 CG 36 CODE RT-695-D EST. WGT. 1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
10Ⓓ	53	During S 49, heat to 210-212°F & shut off steam			
12		NOTE: If necessary, reheat V-10Ⓓ to 210, 212°F			
		Prior to start of strike			
	54	Pump V-207 into V-10Ⓓ in 60-65 min. Let V-10Ⓓ temp drop to			
		200-205°F, then maintain at 200-205°F for balance of strike			
		Record: Start 12:15 PM Total min			
	55	When strike complete heat to 210-212°F			
	56	Stir 15 min at 210-212°F			
	57	Proof to 87" (8648G). Record: pH 7.0 (6.5-7.2)			
	58	Stop agitator			
		Start Fin Optr			
		10:30 AM 3:00 3.42			
		3:00 PM 11:00 PM 2:00 AM 3.34			
		11:00 PM 2:00 AM 2.37			

K 12930 REV.

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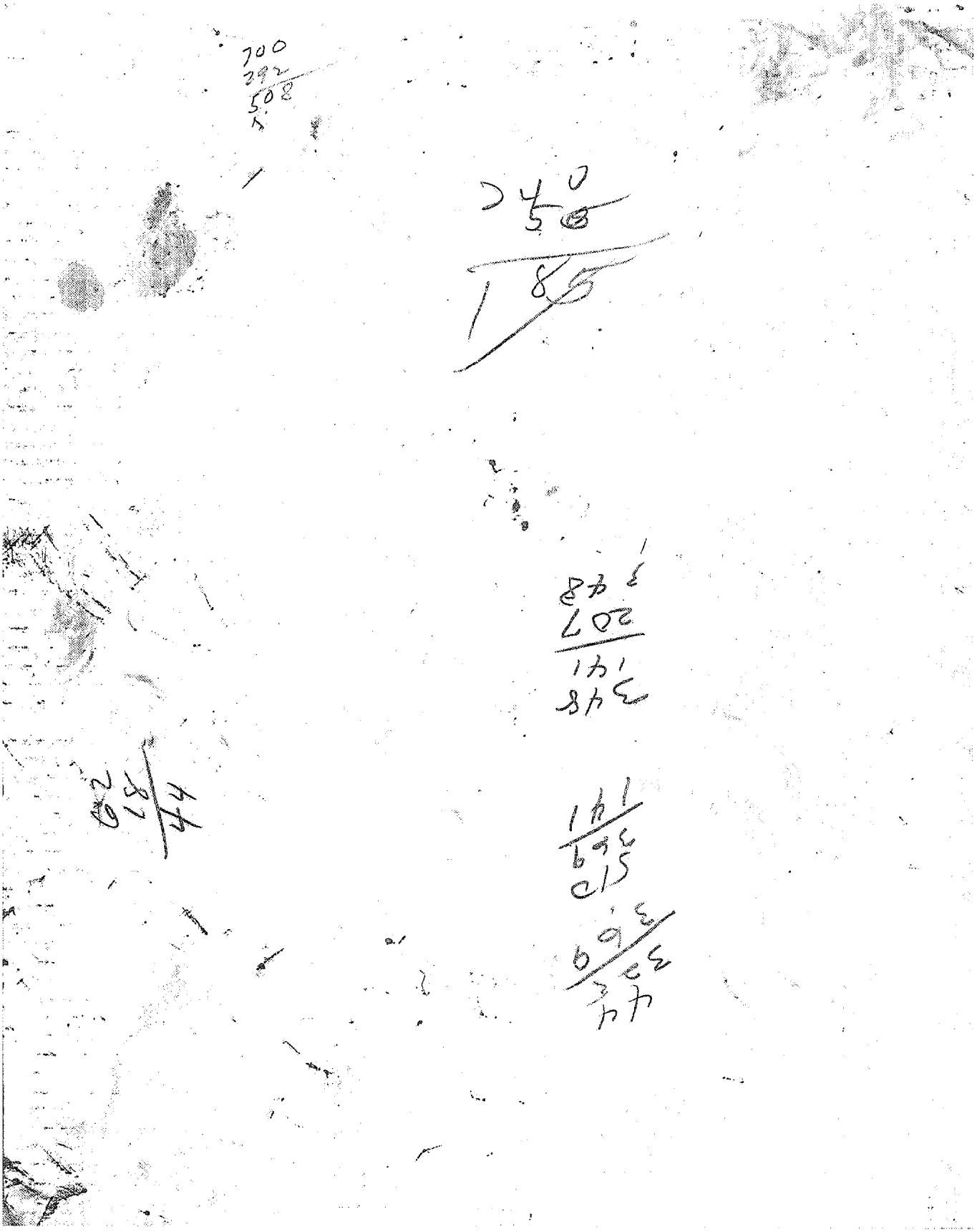

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FA# & Scale #		Make & Capacity	Location	Weight	Reading	Remarks
FA-64-14	7	Fairbanks 800# Plat	6 bldg. 2nd flr on HF-6 platform			
FA-217-4	103	Toledo 6250# Dial	9 bldg. 2nd flr V-926 N-7-D			
FA-236-4	95	Fairbanks 1000# Dial	9 bldg. 2nd flr ingredient scale			
FA-630-4	41	Howe 1000# Plat	9 bldg. 2nd flr			
FA-226-6	51	Howe 1100# Plat	6 bldgl 3rd flr under diazo Plat.			
FA-630-7	38	Toledo 1600# Dial	2nd flr #10 bldg. on [redacted] HF-Mill platform			
FA-64-1	40	Howe 1100# plat.	12 bldg 1st flr flushing unit			
FA-895-1,	121	Toledo 6260#Dial	13 bldg CPC pumping station			
scale #23 and an unidentified scale out			of service 3rd flr #10 Bldg.			

Pump U-207 back to U-313

Then Add LOT-53 69# N-740 100%

13# N-7 100%

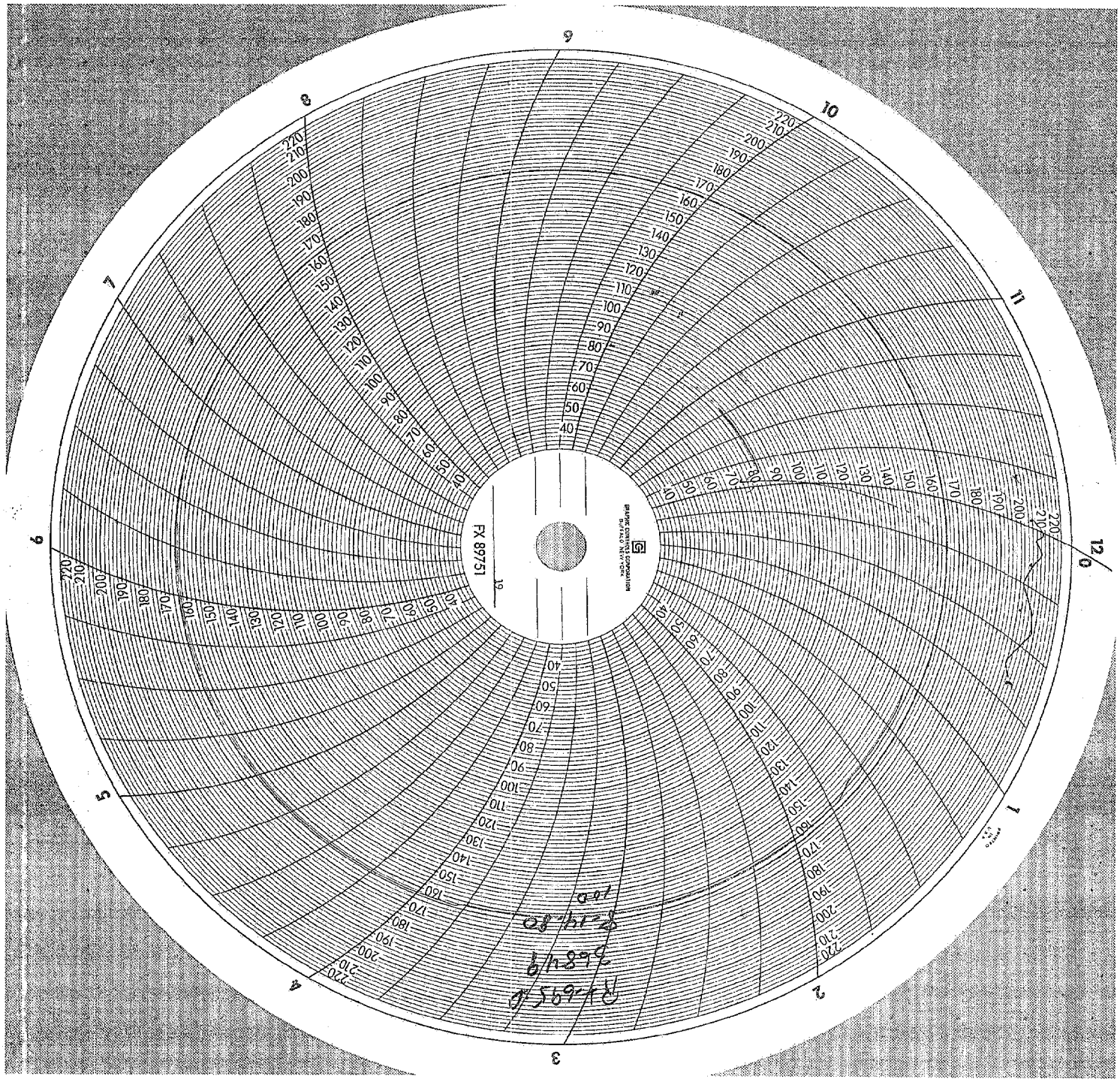
10# N-113

&

boil 30 min. Then Put

back Thru Sparkler —

Sue



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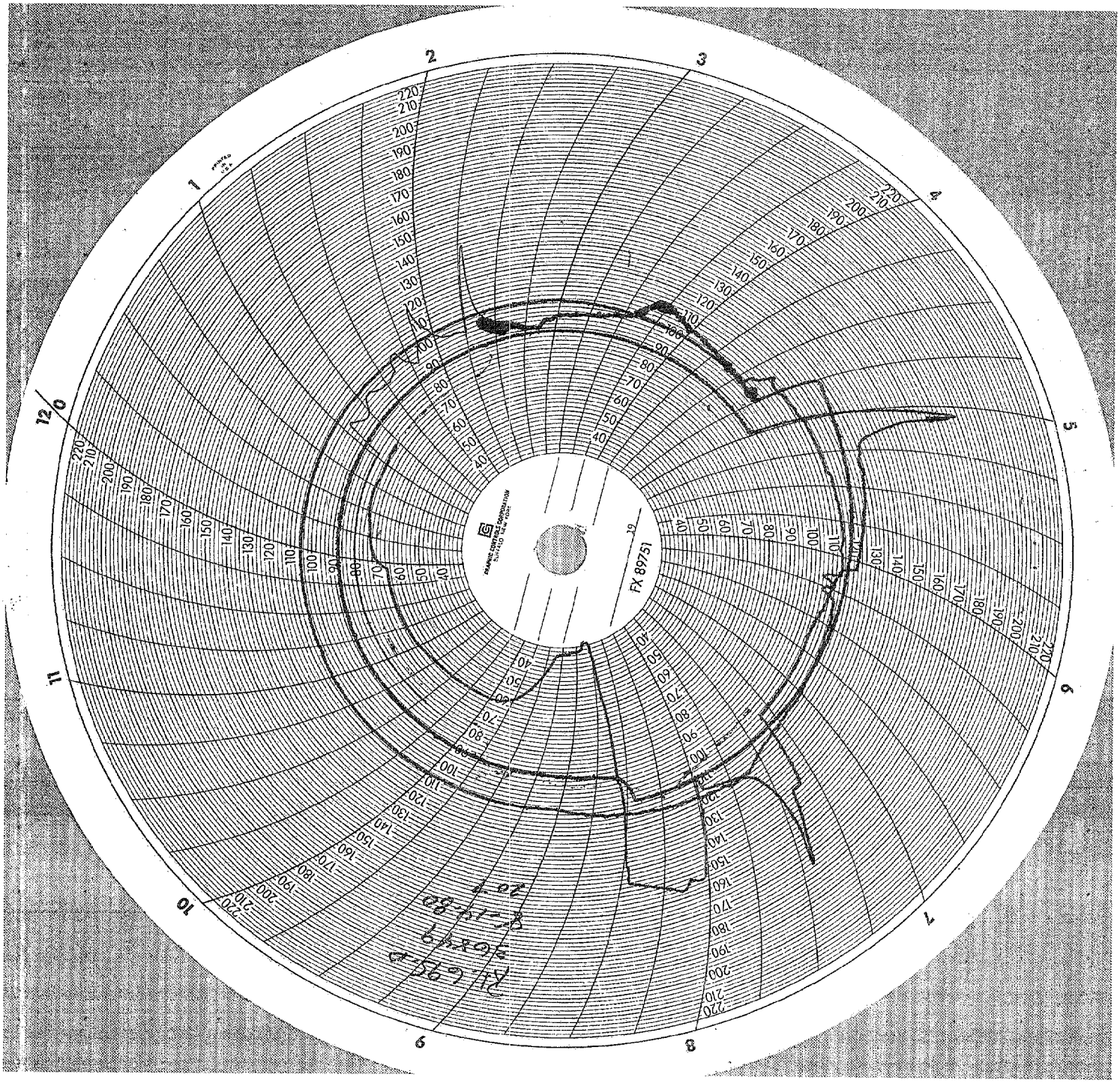

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