

PRECOAT SPARKLER

MAKING INSTRUCTIONS: BATCH UNIT

V. 107

C.V. 207

Done 9/22

D.V. 313, 322, 330

CG 36 CODE RT-695-D Pkg.
 → Slt. 22.00 37196
 EST. WGT. 1350 LBS.
 STD. HRS. TIME 11 AM

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

* Use N253-C - 1 full drum } 1 of stumps at V-107
 2 stump drums } other 2 drums, being sent over
 from 9 Bldg - Make up with N82C

NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
Prep 1	1. If necessary, clean dress sparkler & pre-coat with 15# 2. Obtain for S 6 use for 100 in lot 101 only 3. Obtain for 32B N253C-	15	777-A 15 740-C 253-C	
313 2	4. Run 25" (370G) water into V-313 5. Weigh & pour in M. 10 48.20 6. Turn on agitator & steam & dump in from S 2 Lot 101 502 98.63	203 509	7-D 98 740-C 502	
	7. Dump in 8. Dump in 9. Heat to 212-214°F WATCH FOAM 10. Record: BY + (+), if necessary adj to + BY Assume 50% 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 S14 Record: HT 195°F & Recorder Record: Start 10:00 Total Min 15 Clarity Clear	23 5	113-B 23 777-A 5	
322 3	13. Run 4" (125G) water into V-322 207 14. When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at 190-195°F. Record: Start 10:50 Total Min 15 Sample From Hose Show to supervisor for OK 15. Weigh on Postal Scale & Add Lot			
313 4	16. Run in 2" (66G) water into V-322 17. Weigh in plastic lined Drums & Pour in & hold for S 28 M 2 31.62	637	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 Sparkler until sol'n is clear.			
313 6	20. Pump V 313 thru Sparkler into V-322 207 (Sample) 21. When MTY-blow out Sparkler into V-322 207 22. RECORD: VOLUME 17" 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.			

EQUIPMENT		PAGE 2. CG 36 CODE RT-695-D	EST. WGT.	1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
207	25	Run 1" (69C) water into V-207					
7	26	Is 6-24 to OK, pump V-322 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			35 x 330		11,510
	29	Adj to 33" (2277G) at 32-38°F			21 x 330	57-A	
322	30	Run in 22" (755G) water into V-322					
8	31	Weigh & Pour in	M 10.48.20%	496		7-D	239
	32	Dump in from S3	Lot	497	253	C	407
			497	407			
			4912	16	N.82		16
	33	Weigh on postal scale & add	Lot 90804	9	180-C		9
	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
102	37	Run in 14" (1391G) water into V-102					
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 11.321%	500	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 S. to AM CR + KI +					
		NOTE:					
		(1) If CR-KI-, add 20# "as is" increments Assume 32%				28-D	
		RECORD: CR (+), KI (+) TEMP 32°F					
		(2) If CR+KI-, add 20# "as is" increments Assume 33%				725-A	
		RECORD: CR (+), KI (+)					
	49	Couple V-322 thru under surface distributor into V-207 in					
		40-45 min Record: Start 5:35 AM Total min 45					
	50	When S 49 complete, stir 15 min					
		Record: DIAZO - (-); BASE + (+); pH 11.8 (11.0-11.8) TEMP 56.9°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				7-D	
		Record: pH				28-D	
		Assume 32%					
	52	Adj to pH 9.0-9.5 8.2-8.6		150	28-D		50
		Record: pH 8.5				7-D	
		Assume 50%					
		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 N-7 & N-28 for pH adjustment							

EQUIPMENT	PAGE 3	CG 36	CODE RT-695-D	EST. WGT.	1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
100	53	During S 49, heat to 210-212°F & shut off steam						
12		NOTE: If necessary, reheat V-100 to 210, 212°F						
		Prior to start of strike						
	54	Pump V-207 into V-100 in 60-65 min. Let V-100 temp drop to 200-205°F, then maintain at 200-205°F for balance of strike						
		Record: Start <u>6:05 AM</u> Total min <u>65</u>						
	55	When strike complete heat to 210-212°F						
	56	Stir 15 min at 210-212°F						
	57	Flood to 87" (8648G). Record: pH <u>6.8</u> (6.5-7.2)						
	58	Stop agitator						
		Start	Fin	Optr				
		<u>8:00 PM</u>	<u>11:00 PM</u>	<u>126</u>				
		<u>11:00 PM</u>	<u>7:00 AM</u>	<u>237</u>				
		<u>7:00 AM</u>	<u>10:00 AM</u>	<u>201</u>				
		No ICE 2 1/2 HRS						
		NOTE - While striking Press Room						
		Shut off steam for repairs						
		EE						



