

S.V. 107

C.V. 100

D.V. 330,322 207 317

100

CG 36 CODE RT-695-D PKG

PROCESSES

APPROVED BY

() RT-695-D (N)

JJG 3/18/81

(M) ALTERNATE ()

(OK)

() ()

TYPED BY: JLC

ESTIMATED WGT

2781

LBS.

STANDARD HRS.

TIME M

PREPARATION NOTES:

EQUIP MENT	NAME: 'BON' RED DARK	USE LBS	N-CODE	ACCT LBS
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PREP	1	IF NECESSARY, CLEAN, DRESS SPARKLER & PRE-		
	1	COAT WITH 15#	777-A	
	2	OBTAIN FOR S 6	740-C	
	3	OBTAIN FOR S 42	253-C	

317	1	RUN 23" (748G) WATER INTO V-317	5028	428	7-D	215
2	2	WEIGH & POUR IN			740-C	1092
	3	TURN ON AGITATOR & STEAM & DUMP IN FROM S 2				
		LOT 100% 970 987 994	975	123		
	7	WEIGH ON POSTAL SCALE & ADD LOT	8		584-C	8
	8	DUMP IN	50		113-B	50
	9	DUMP IN	10		777-A	10
	10	HEAT TO 214-216 DEG. F WATCH FOAM				
	11	RECORD: BY + (+), IF NECESSARY ADJUST				
		TO + BY ASSUME 50%			7-D	
	12	STIR 30 MIN. AT 212-214 DEG. F, THEN SHUT				
		OFF STEAM WATCH FOAM				
		NOTE RECORD: SPARKLER PRESSURE 0 PSI				
		IF NOT ZERO, NOTIFY SUPERVISOR				
	13	CIRCULATE 15 MIN OR LONGER THRU SPARKLER				
		UNTIL SOLUTION IS CLEAR				
		MAINTAIN AT 190-195 DEG. F FOR S 15				
		RECORD: HT. DEG. F & RECORDER 195 DEG. F				
		RECORD: START TOTAL MIN 5 CLARITY CLEAR				

100	14	RUN #1 (99G) WATER INTO V-100				
3	15	WHEN S-13 COMPLETE, PUMP V 317 THRU				
		SPARKLER: MAINTAIN V-317 AT 190-195 DEG. F				
		RECORD: START 6.50 TOTAL MIN 25				
		SAMPLE FROM HOSE. SHOW TO SUPV'R FOR OK				

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317	16	WHEN S 13 COMPLETE, CLOSE V-317 OUTLET &				
4		STOP PUMP				
	17	RUN IN-12" (215G) WATER & HEAT TO 190-195				
		DEG F				

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 02 OF 04 CG 36 CODE RT-695-D (N)	USE LBS	N-CODE	ACCT LBS
317 CONT'D	4	CIRCULATE THRU SPARKLER UNTIL SOLUTION IS CLEAR MAINTAIN AT 190-195 DEG. F FOR S 19 & RECORD: HT _____ DEG. F & RECORDER RECORD: START <u>7:15</u> TOTAL MIN <u>20</u> CLARITY <u>CLEAR</u>			
100 5	119	WHEN S 18 IS COMPLETE, PUMP V-317 THRU SPARKLER INTO V-100			
	120	RUN IN 5" (90G) WATER & HEAT TO 190-195 DEG. F			
	121	CIRCULATE 15 MIN THRU SPARKLER, PUMP V-317 THRU SPARKLER INTO V-100			
	122	WHEN MT. BLOW OUT SPARKLER INTO V-100			
	123	HEAT TO 165-170 DEG. F (TAKE 1 QT. SAMPLE) (WITH AGITATION ON) TEST FOR CLARITY OF SOLUTION. SHOW 1 QT. SAMPLE TO SHIFT SUPERVISOR FOR APPROVAL (EXAMPLE OF ACCEPTABLE CLARIFICATION OF N-740-C IS AVAILABLE IN OFFICE TO COMPARE WITH)			
	124	IF S 23 IS OK, CONTINUE WITH S 25. IF S 23 IS NOT ACCEPTABLE, RECLARIFY THRU SPARKLER			
	125	IF S 23 IS OK, REHEAT V-100 TO 165-170 DEG. F FOR S 26			
100 6	126	ADJ TO 16" (1590G)			
	127	HEAT V-100 TO 165-170 DEG. F			
	128	RUN IN V-324 THRU DIRECT M. <u>2</u> , <u>32.00</u> % <u>1384</u>		28-D	443
	129	LINE AND RINSE IN			
	130	STIR 15 MIN AT 165-170 DEG. F			
	131	ADJ TO 50" (4970G) AT 34-38 DEG. F			
	132	RECORD: TEMP <u>32</u> DEG. F AND IF NECESSARY 50X330		57-A	16,500
	133	ADJ TO 34-38 DEG. F &			
	134	RECORD: TEMP _____ DEG. F		57-A	
107 7	135	RUN 45" (4320G) WATER INTO V-107			
	136	TURN ON AGITATOR AND STEAM AND DUMP IN	1400	336-B	1400
	137	DUMP IN	250	65-A	250
	138	HEAT TO 150-160 DEG. F AND STIR			
	139	RECORD: PH <u>6.2</u> (5.0-5.5)			
	140	IF PH ABOVE 5.5, ADJ TO PH 5.5 OR LOWER ASSUME 78%	<u>2</u>	27-D	<u>2</u>
	141	RECORD: PH <u>5.4</u>			
	142	NOTE: IF PH BELOW 5.0, DO NOT ADJ UPWARD			
	143	HOLD FOR S 58			
207 8	144	RUN IN <u>23</u> " (1610G) WATER INTO V-322			
	145	WEIGH AND POUR IN M. <u>9</u> , <u>50.28</u> % <u>935</u>		7-T	470
	146	DUMP IN FROM S 3		253-C	<u>930</u>
		LOT <u>552</u>	<u>930</u>		
		WEIGH UN PORTAL _____	<u>24</u>	180-C	<u>24</u>

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 03 OF 04 CG 36 CODE RT-695-D (N)	USE LBS	N-CODE	ACCT LBS
322 8 207	14 15 16	HEAT TO 70-90 DEG. F SIFT IN IN ONE TO TWO MINUTES DUMP IN & STIR 5 MIN OR LONGER TO DISSOLVE	27 8	567-B 479-D	27 8
313/ 302 9	147	WEIGH & POUR INTO V- <u>320</u> FOR S 50 M <u>7</u> <u>32.93%</u> <u>1108</u>		725-A	365
322 10	148 149	ADJ V- 287 TO <u>65</u> (2240G) AT 77-80 DEG. F & RECORD: TEMP <u>77</u> DEG. F SLURRY WITH 30 GALS WATER IN DRUM. POUR IN AND STIR 5 MIN. <u>2</u> <u>SLUT AGITATOR OFF</u>	160	39-A	160
100 11	150 151 152	RUN IN N-725-A FROM S 47 AFAP INTO V-100 STIR 30 MIN AT 36-38 DEG. F MAINTAINING +CR, +KI RECORD: TIME START <u>1:04</u> CR <u>+</u> KI <u>+</u> TEMP <u>38</u> DEG. F NOTE: (1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS ASSUME 32% RECORD: CR <u>+</u> , KI <u>+</u> (2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS ASSUME 33% RECORD: CR <u>+</u> , KI <u>+</u> TEMP <u>38</u> DEG. F		57-A 28-A 725-A	
153 154 155	153 154 155	COUPLE V- <u>302</u> THRU UNDERSURFACE DISTRIBUTOR INTO V-100 IN 90-110 MIN (USE 9/16" ORIFICE) RECORD: START <u>1:20</u> TOTAL MIN <u>105</u> WHEN S 53 COMPLETE STIR 15 MIN RECORD: DIAZO <u>-</u> (-), BASE <u>+</u> (+) PH <u>8.4</u> (7.0-8.0) TEMP <u>63</u> DEG. F (60-65 F) NOTE: (1) IF PH IS 5.0-7.0, WEIGH AND DUMP IN 30# "AS IS" N-7-D DILUTED TO 30 GAL AFAP ASSUME 50% (2) (FOR PH ADJUSTMENTS USE ONLY DILUTED N-28-D) AND N-7-D)		7-D	
156	156	ADJ TO PH 9.0-9.5 (SEE ATTACHED PH ADJ AID) ASSUME 32% 1) IF PH IS 6.5-7.0, WEIGH 40# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. STIR 5 MIN & RECORD: PH <u>9.0-9.5</u> 2) IF PH IS 7.0-7.5, WEIGH 35# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. STIR 5 MIN & RECORD: PH <u>9.0-9.5</u> 3) IF PH IS 7.5-8.0, WEIGH 30# AS IS N-7-D POUR INTO 50 GAL WATER (1/2 FULL) IN PT & RUN INTO CV 100 IN 15 MIN. STIR 5 MIN & RECORD: PH <u>9.0-9.5</u>		28-D	

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 04 OF 04 CG 36 CODE RT-695-D (N)	USE LBS	N-CODE	ACCT LBS
100		4) IF PH IS 8.0-8.5, WEIGH 10# AS IS N-7-D			
11		POUR INTO 50 GAL WATER (1/2 FULL) IN PT &			
CONT		RUN INTO CV 100 IN 15 MIN. STIR 5 MIN &			
		RECORD: PH _____ (9.0-9.5)			
		5) IF PH IS 8.5-8.9, WEIGH 5# AS IS N-7-D			
		POUR INTO 50 GAL WATER (1/2 FULL) IN PT &			
		RUN INTO CV 100 IN 15 MIN. STIR 5 MIN &			
		RECORD: PH _____ (9.0-9.5)			
		6) IF PH IS ABOVE 9.5, DO NOT ADJUST			
		RECORD: PH <u>9.2</u> ASSUME 50%		7-D	
		NOTE: ADD N-28-D IN 5# "AS IS" INCREMENTS			
		TO APPROACH PH 9.0-9.5 THEN USE			
		LESS N-28-D			
		(CONCENTRATED N-28-D & N-7-D AND TOO LOW			
		COUPLING TEMPERATURE CAUSES MASSTONE TO			
		GO TOO LIGHT)			
		SHUT OFF AGITATOR			
107	59	DURING S 53 HEAT V-107 TO 210-212 DEG. F			
12		& SHUT OFF STEAM			
		NOTE: IF NECESSARY REHEAT V-107 TO 210-			
		212 DEG. F PRIOR TO START OF STRIKE			
	60	PUMP V-100 INTO V-107 IN 70-75 MIN.			
		LET V-107 TEMP DROP TO 200-205 DEG. F			
		DURING STRIKE THEN MAINTAIN AT 200-205 DEG.			
		F FOR BALANCE OF STRIKE WITH AGITATOR SHUT			
		OFF IN V-100			
		RECORD: START <u>4:20 AM</u> TOTAL MIN <u>180</u>			
	61	WHEN STRIKE COMPLETE, HEAT TO 210-212 DEG. F			
	62	STIR 15 MIN AT 210-212 DEG. F			
	63	FLOOD TO 180-190" (18240G)			
		RECORD: PH <u>6.8</u> (6.5-7.2) AND STOP			
		AGITATOR			
		START <u>4:20 PM</u>	FINISH <u>11:00 PM</u>	OPERATOR <u>301-</u>	
		<u>1:00 PM</u>	<u>7:00 PM</u>	<u>27</u>	
		<u>2:0</u>	<u>8:30 A</u>	<u>223</u>	



