MAKING INSTRUCTIONS: BATCH UNIT

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

C.V. 105, 106

CO 46 CODE YT-858-D PKG. _____

→ FEB 15 34384

EST. WGT. 2287 LBS.

STD. HRS. _____ TIME 7:AM M

PROCESSES		APPROVED BY
( ) YT-858-D	(A)	EWK 10-18-76
( )	( )	EAS 05-24-78
( )	( )	DCG 05-30-78
( )	( )	MW 05-30-78
TYPED BY emw080778		

Note: R&D to Follow

DONT MOVE UPON BATCH

WEST-PRESS

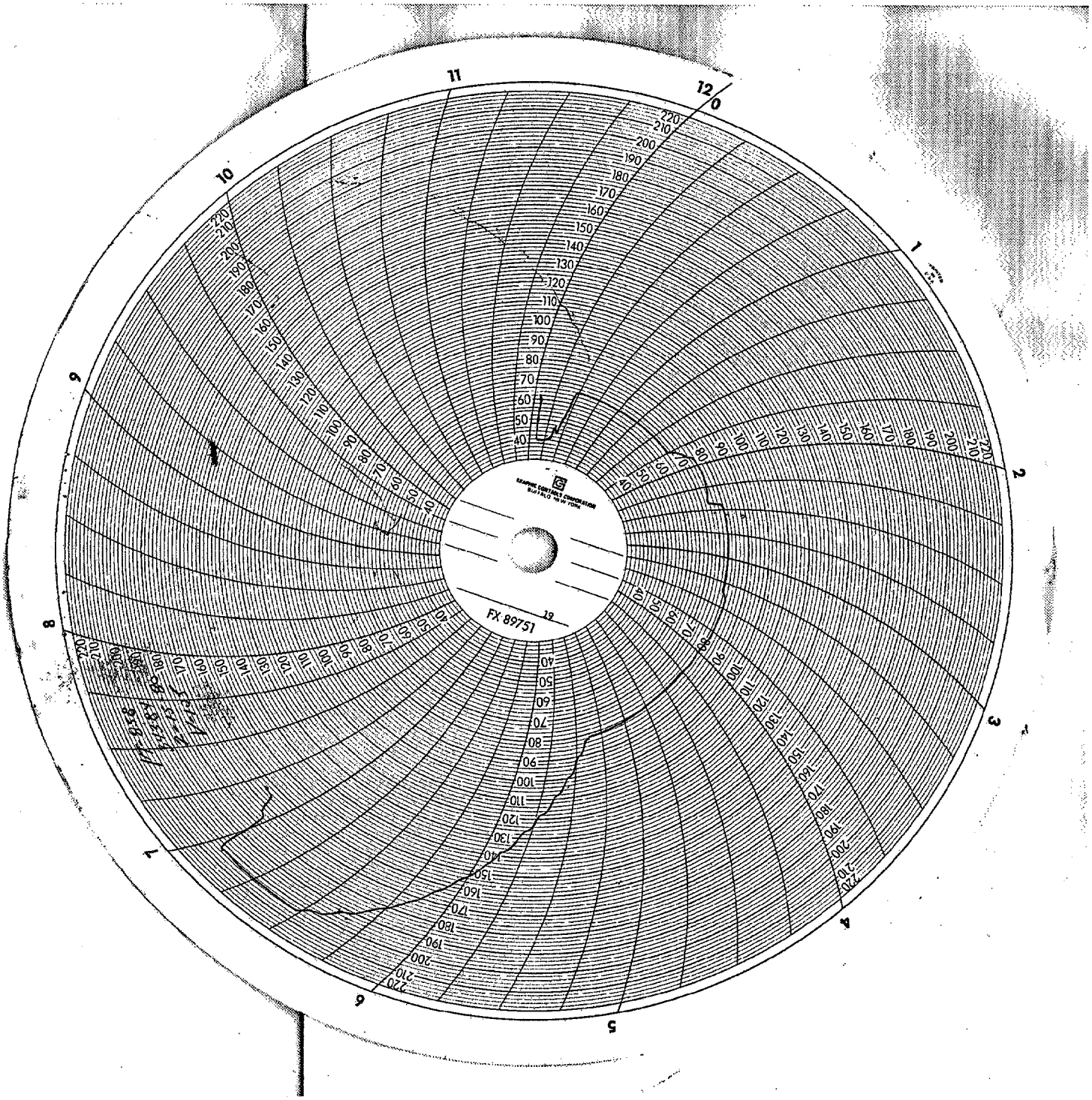
EQUIPMENT		NAME: DALAMAR® YELLOW				USE LBS.	N CODE	ACC LBS.
Prep	1	Obtain for S 20					157-C	
1	2	Obtain for S's 6 & 38					46-C	
	3	Clean, dress, close 24" clarif press - 15 frames						
	3A	OBTAIN FOR S 38A					126-C	
303	4	Run 18" (442 G) water into V-303						
2	5	Pour in		M 3 , 48.04 %		50	7-D	24
	6	Dump in from S 2	Lot	#100%	%		46-C	66
		Note: break up lumps	41960	66	95.6	69		
8:15A	7	Stir 45 min to dissolve for S 11 start 8:15AM						
DV	8	During S 7 stir, 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 S 7 stir complete, pour in & stir 5 min M , 33.46 %				60	725-A	20
4	12	Adj to 60-62°F		Record: 60 °F			57-A	
	13	Siphon in in 4-6 min		M 4 , 72.64 %		194	30-D	141
	14	Adj to 32" (773 G) at 66-70°F					57-A	
	15	Stir 5 min & Record: pH 4.3 (4.1-4.5)						
	16	If necessary, adj to pH 4.1-4.5			Assume 77%		30-D	
		& Record: pH 4.3			Assume 50%		7-D	
	17	Stir 3 hrs minimum for S 44 maintaining at 66-70°F						
		Record: Start: 9:25AM Total Min: 270					57-A	
DV	18	During S 17 Stir, run 10" (323 G) water into V- 800						
5	19	Weigh in from V-324		M 3 , 30.96 %		1479	28-D	458
	20	Dump in from S 1	Lot	#100%	%		157-C	974
	1		192	57	54.8	104		
			165	142	55.8	255		
			165	146	57.4	255		
			165	147	57.8	254		
			165	149	58.6	255		
			175	21	63.0	33		
			175	16	65.8	25		
			192	101	51.6	196		
			192	112	56.6	197		
			192	83	56.4	162		

EQUIPMENT		PAGE 2 CG 46 CODE YT-858-D (A) EST. WGT. 2287 LBS.	USE LBS.	N CODE	ACCT. LBS.
DV 5 con't	21	Stir 10 min or longer to wet			
	22	Adj DV to 37" (1280 G) at 20-22°F	18 x 330	57-A	4620
	23	Siphon in in 12-15 min M 3, 33.96 %	1210	725-A	405
	24	Stir 30 min at 28-32°F maintaining +CR, +KI for S 27		57-A	
		Record: Time Start 1120A 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 S 31 M 3, 48.04 %	920	7-D	442
	26	Weigh in buggy for S 41 M 4, 72.64 %	964 ✓	30-D	700
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	
		Record: Time Start 1200P, 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 (+)		4	
CV 8	30	During S 29 stir, run 10" (970 G) water into V-105 & install temp chart			
	31	Pour in N-7-D from S 25			
	32	Adj to 30" (2928 G) at 66-70°F	3 x 330	57-A	990
	33	Close stack damper			
DV 9	34	When S 29 stir complete, test DV & Record:			
		CR + (+), KI + (+), Temp 26 °F (28-32°F)		57-A	
		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 (+)			
	35	Pump DV thru clarif press into V-815 maintaining temp at 28-32°F Record: Time Start 1235P Total Min 60	2 x 330	57-A	
Misc 10	36	[redacted]	[redacted]	[redacted]	[redacted]
	37	Dissolve in 20 Gal water in drum for S 53	67	979-D	67
CV 11	38	Dump in from S 2 91930 Lot [redacted] #100% 206 %94.8	217	46-C	1138
		Note: Break up lumps 91905 321 91.6	351		
		92150 407 91.4	446		
		91970 204 95.4	214		
	38A	DUMP IN FROM S 3A LOT 60100	127	126-C	127
	39	Stir 10 min to dissolve			
	40	Open stack damper			
	41	Run in N-30-D from S 26 undersurface in 20-25 min			
	42	Stir 8 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 S 17 stir complete, run in V-303 on surface AFAP (20 mm)			

EQUIPMENT		PAGE 3 CG 46 CODE YT-858-D (A) EST. WGT. 2287 LBS.	USE LBS.	N CODE	ACCT LBS.
DV 12	45	When S 35 complete, wash DV lines, dump & press for 20 min or to a -CR test on a sample of total press effluent, which-ever comes first - collect washings in DV (S 35)			
	46	Stir 5 min & Record: Temp 28 (28-32°F) & if necessary, adj to 28-32°F Record: 28 °F, 5/3 "		57-A	
CV 13	47	When S 46 complete, adj CV to 38" (3708 G) at 80-84°F & Record: HT 80 °F, Rec 81 °F			
	48	Immediately run in DV thru undersurface distributor in 60-65 min. Maintain CV at 80-84°F. Record: Time Start 3:15 PM Total Min 65 min			
~~mise 14~~	~~50~~	~~[illegible]~~			
CV 15	51	When S 48 complete, stir 10 min			
	52	Record: Diazo — (-), Base T (+), pH 4.25 (4.3-4.7)			
		NOTE:			
		(1) If Diazo +, Base -, and pH below 4.3:			
		(a) adj to pH 4.3-4.7 Assume 50%	6	7-D	3
		(b) Record: pH 4.3			
		(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 10 min			
		(3) Repeat (1) & (2) above as necessry to - Diazo, + Base			
	53	DUMP IN N-979-D FROM S 37			
	54	HEAT TO 200-204°F IN 40-45 MIN			
	55	SOAK 30 MIN AT 200-204°F RECORD: START 6:30			
	56	SHUT OFF STEAM			
	57	RECORD: PH 4.2 (4.2-4.7)			
	58	FLOOD TO 94" (9174G) & STOP AGITATOR			

START 7:00 AM 3:00 PM — FIN 3:00 PM 7:15 PM — OPTR 259-188 29

* V-315 almost 1/2 less than 1/2" in VW conveying line to V-105 plugged with ice Freeflow was 10 min plugged again. too much ice in V-315 (3 floors) Also water added to V-315.



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