

CG 20
JUNE 1
1982
 (DATE)

CODE BC-2-A

PKG ---

F2H59

(LOT NUMBER)

PROCESSES
 (C) BC-2-A

APPROVED BY
 BBK 11/20/81

JOB NAME: 20BC002AMC

TYPED BY: DB

ESTIMATED WGT ²²⁶⁵ LBS.

STANDARD HRS. _____

TIME _____ M

PREPARATION NOTES:

note 23 Changes

EQUIP MENT		NAME: "MONASTRAL" BLUE B	04 PAGES	USE LBS	N-CODE	ACCT LBS
PREP	1	INSTALL TEMP & AMPS CHARTS DAILY				
	2	WEIGH BC-2-A BORAX SLUDGE FOR S-5 + 11, RECORD WGT. IN S-23 PER CALC S-3 NOTE: TOTAL WGT INCLUDES LIQUID. AFTER WEIGHING, DIPPER OFF EXCESS LIQUID & POUR INTO V-291 THRU CLASSIFIER				
	3	CALC FOR S-10, 12 & 23 660# -(0.7 X _____ ÷ SLUDGE S-2) = #N-972-A				
HF MILL	4	START AGITATOR WITH COOLING WATER OFF				
	5	DUMP IN 1 BUGGY OF SLUDGE FROM S-2 & ADD		14	567-B	0
	6	DUMP IN & STIR 10-15 MIN TO UNIFORMITY NOTE: TURN ON WATER SPRAYS WHEN MILL TEMP REACHES 120 DEG F OMIT S-7-9 ON 1ST CHARGE OF 1ST BATCH OF A CAMPAIGN.		100	8520-A	0
CLASS	7	DURING S-6 STIR, BACKWASH LINES FROM CLASSIFIER TO V-391 & PLACE CART UNDER SLUDGE DISCHARGE				
391 A	8	ADJ TO 24" (293 G) & TURN ON AGITATOR				
291 5	9	RUN V-391 AT 3.0-3.5 GPM (85-100 MIN) THRU CLASSIFIER INTO V-291.				
HF MILL	10	DURING S-9 DUMP IN ALL BUT 50# N-972-A CALC IN S-3			972-A	0
	11	ADD 2ND BUGGY OF SLUDGE FROM S-2 & STIR 3-6 MIN TO UNIFORMITY				
	12	ADD 50# N-972-A FROM S-10 & ADJ TO 27-32 AMPS WITH N-972-A OR WATER			972-A	0
	13	WHEN 27-32 AMPS REACHED WITH + OR - 15" VORTEX STIR FOR 3 HRS AT 27-32 AMPS & BELOW 130 DEG F A. ADD N-972-A WATER OR ICE TO MAINTAIN 27-32 AMPS BELOW 130 DEG F. B. RECORD ALL N-CODE INGREDIENTS USED IN TABLE S 23. C. RECORD DATA IN TABLE S-40.				
	14	WHEN S-13 STIR COMPLETED, ADD 5-10" WATER. AVOID OVERFLOWING HF-MILL				

JUN 11 1982

(Signature)

EQUIP MENT		PAGE 02 OF 04 CG 20 CODE BC-2-A (C)	USE LBS	N-CODE	ACCT LBS
CONT.	15	STOP AGITATOR & COOLING WATER SPRAYS			
CLASS 7	16	WHEN S-9 COMPLETE & V-391 MTY CLOSE CLASS- IFIER FEED VALVE & BACKWASH LINE TO V-391 FOR 30 SECS.			
	17	OPEN FEED VALVE & DRAIN V-391 TO CLASSIFIER NOTE: DO NOT WASH IN V-391			
	18	STOP V-391 AGITATOR & CLOSE CLASSIFIER FEED VALVE			
391 8	19	WHEN S-15 DONE TURN ON AGITATOR & PUMP IN CHARGE FROM HF-MILL CONTINUOUSLY DILUTING MILL CHARGE WITH + OR - 100 GAL WATER			
	20	WASH IN MILL & FLUSH PUMPING LINES INTO V-391.			
180 9	21	PUMP V-291 TO V-180 NOTE: V-381 MAY BE USED AS AN AUXILIARY COLLECTION VAT UP TO 10 CHARGES. IF USED HEAT V-382 TO 15-160°F BEFORE RUNNING INTO V-180.			
MISC 10	22	REPEAT S 1-21 UNTIL 23 CHARGES ARE COLLECT- ED IN V-180			
	23	CHARGE OUT RAW MATERIALS IN TABLE 1 BELOW: TABLE 1			

CHGE	N-567-B	REC SLUDGE	N-972-A	N-8520-A					
NO.	LBS	AS IS	100%	#S3	#S13	TOTAL	LOT NO	LBS	OPTR
1	14	845	682	78	22	100	3592	100	101
2	14	880	462	196	-	196	3592	100	106
3	14	580	406	254	-	254	3592	100	105
4	14	680	416	184	-	184	3592	100	322
5	14	670	466	194	-	194	3592	100	322
6	14	630	441	219	-	219	3592	100	101
7	14	620	434	226	-	226	3592	100	88
8	14	785	550	110	-	110	3594	100	166
9	14	670	469	192	-	192	3594	100	105
10	14	665	466	194	-	194	3594	100	166
11	14	660	462	198	-	198	3594	100	322
12	14	630	441	219	-	219	3594	100	322
13	14	428	300	360	-	360	3592	100	101
14	14	650	455	205	-	205	3592	100	101
15	14	720	504	256	-	256	3594	100	438
16	14	785	560	100	-	100	3594	100	166
17	14	615	466	194	-	194	3594	100	105
18	14	675	472	187	-	187	3594	100	86
19	14	775	515	145	-	145	3594	100	86
20	14	650	455	205	-	205	3592	100	322
21	14	745	522	138	-	138	3594	100	101
22	14	720	504	256	-	256	3594	100	101
23	14	815	571	89	-	89	3594	100	438
TOTALS		322		4376		2300			

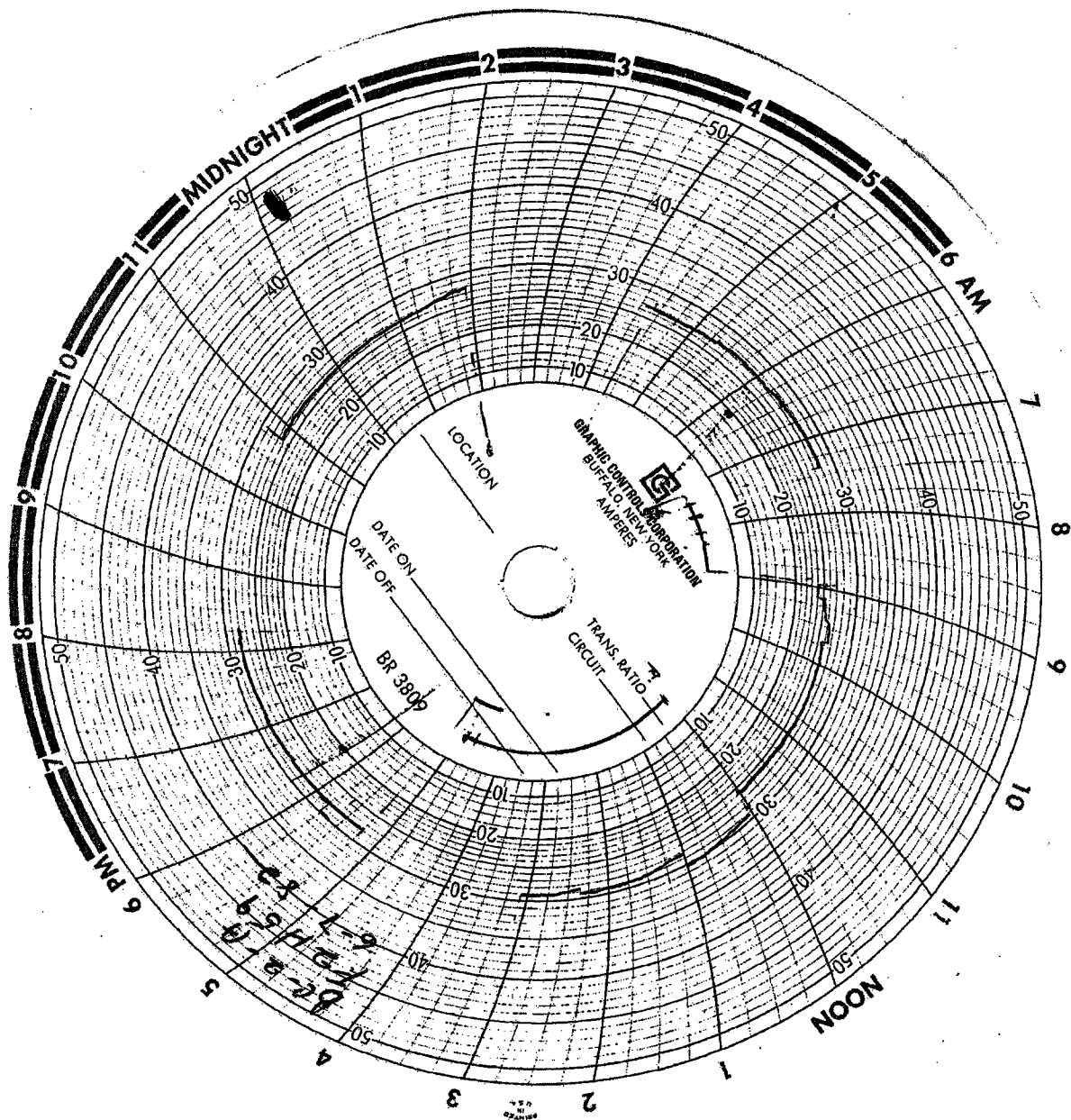
24 ENTER TOTAL LBS OF R/MS IN ACCT LBS COLUMN
NOTE: ENTER CHGE. NO. BEING MILLED. EXTRA
SPACES INCLUDED IN TABLE FOR USE IF MORE
THAN 1 LOT N-8520-A USED IN A CHARGE.

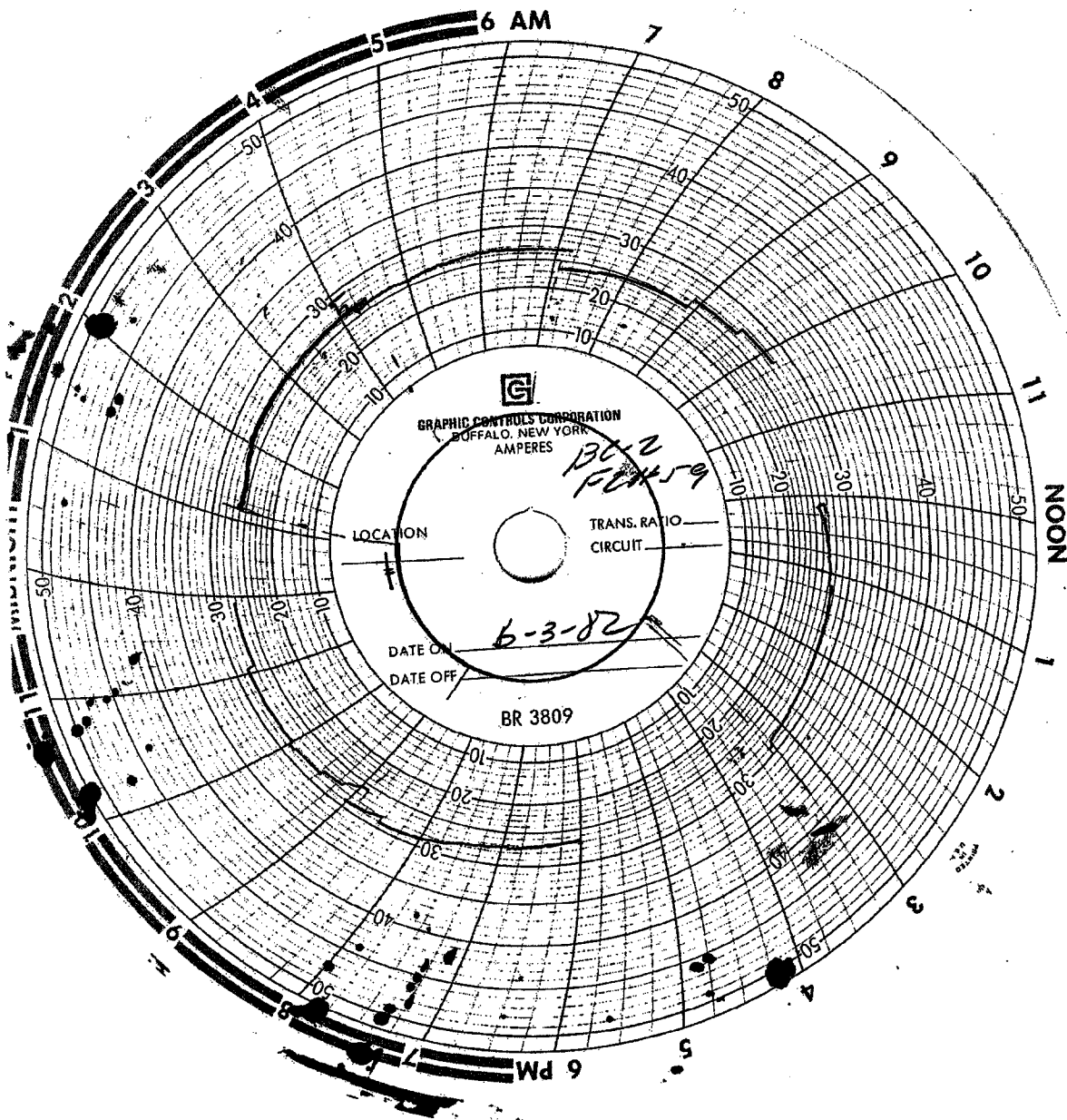
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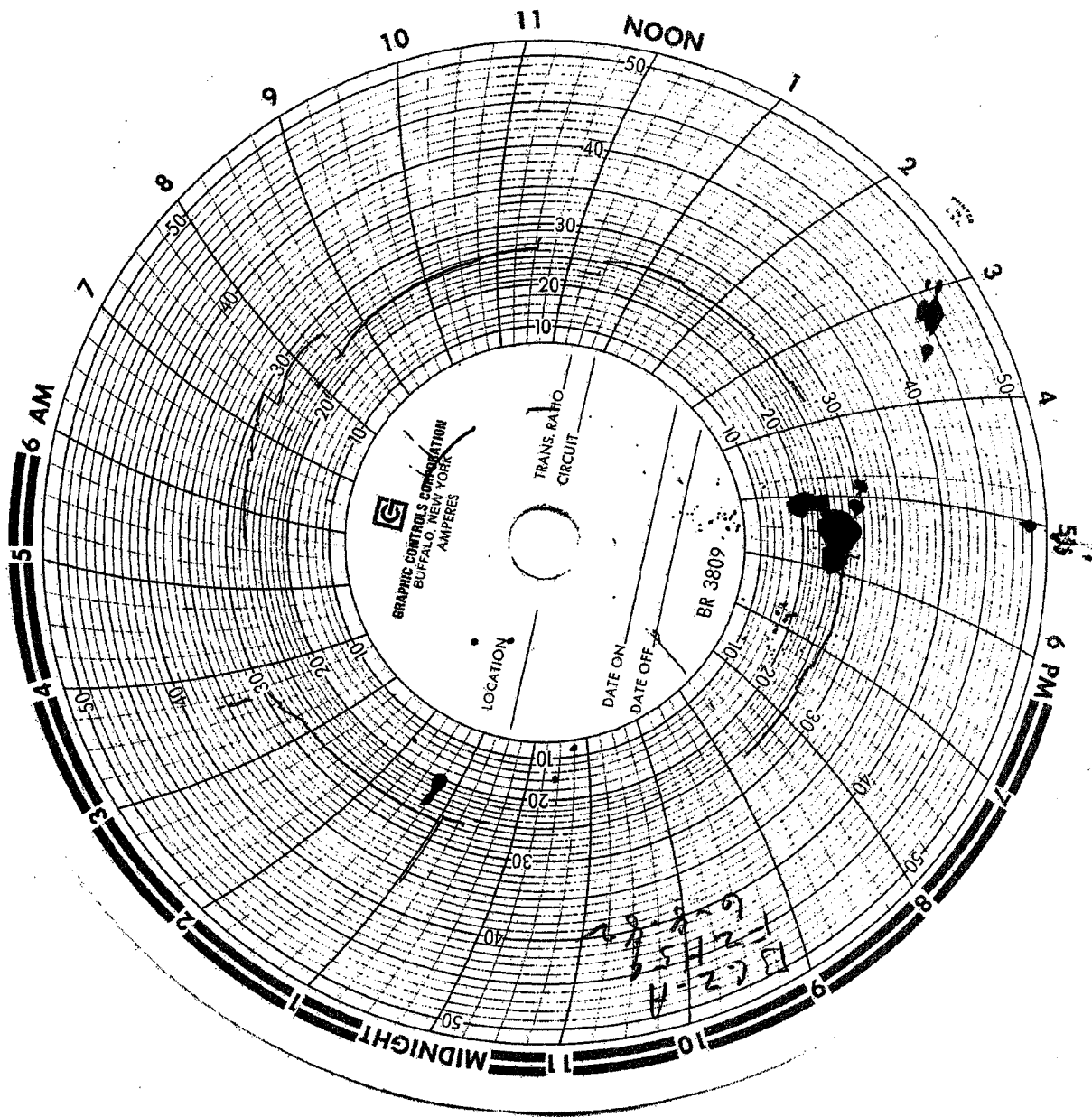
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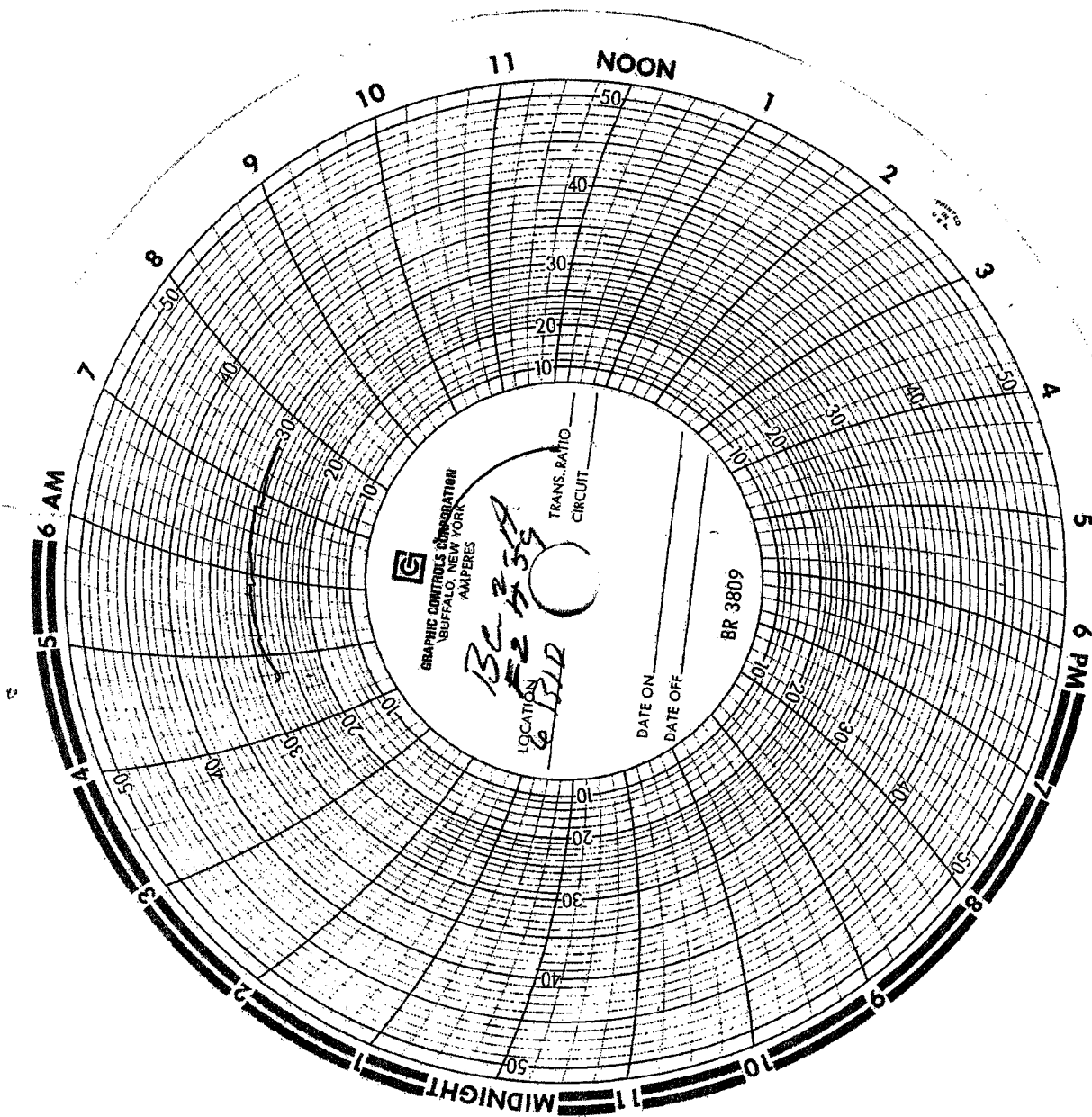
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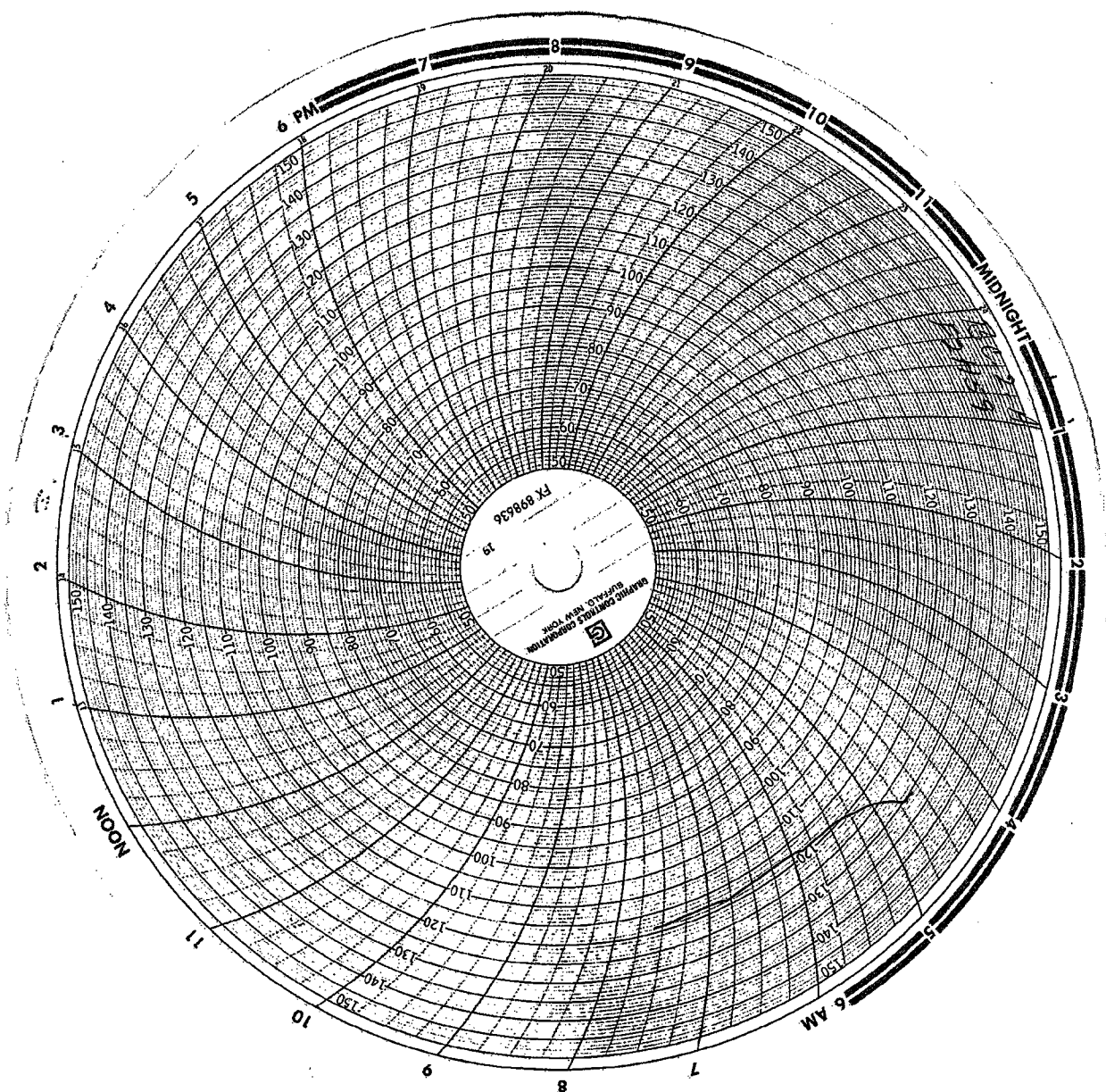


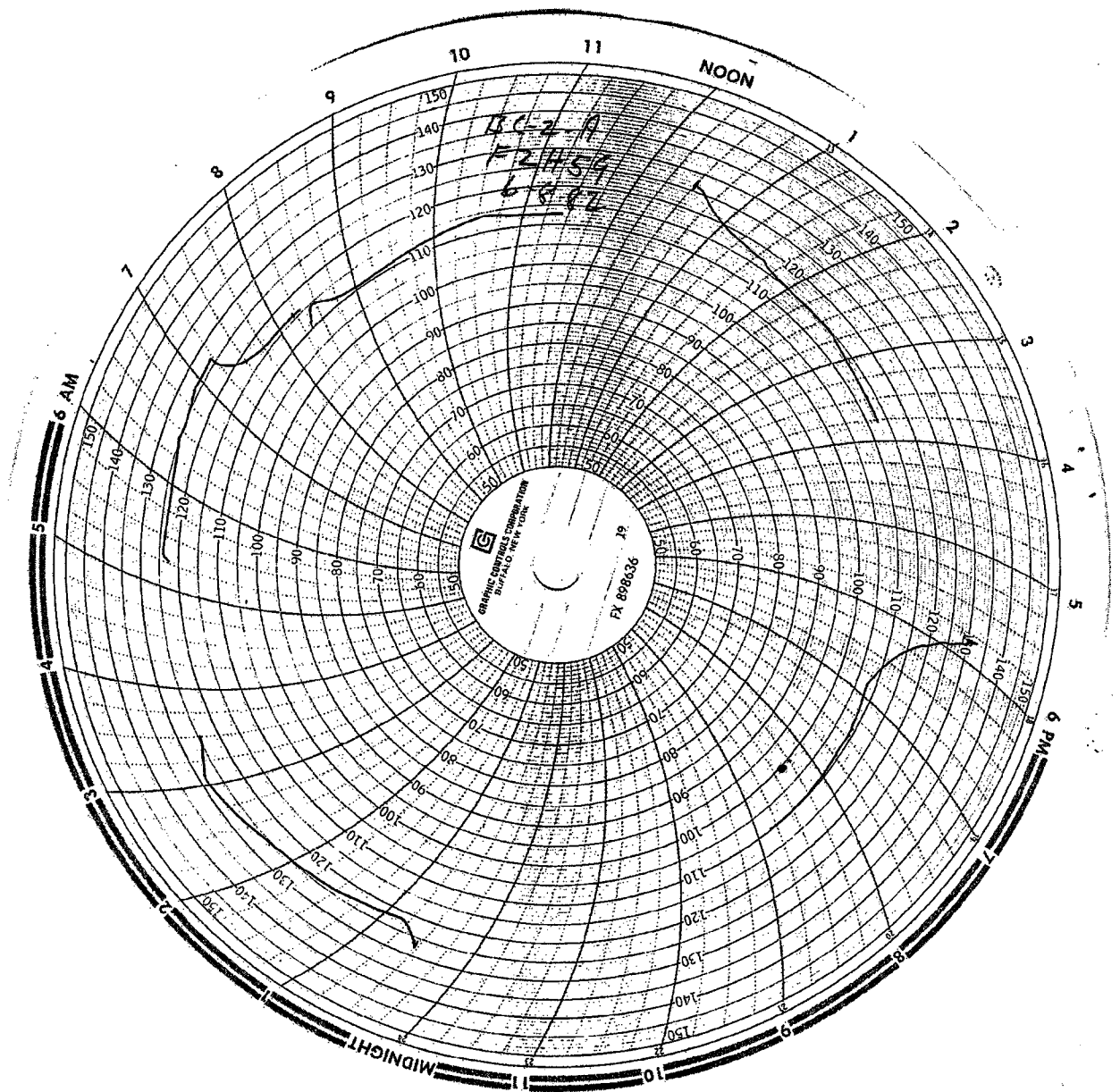


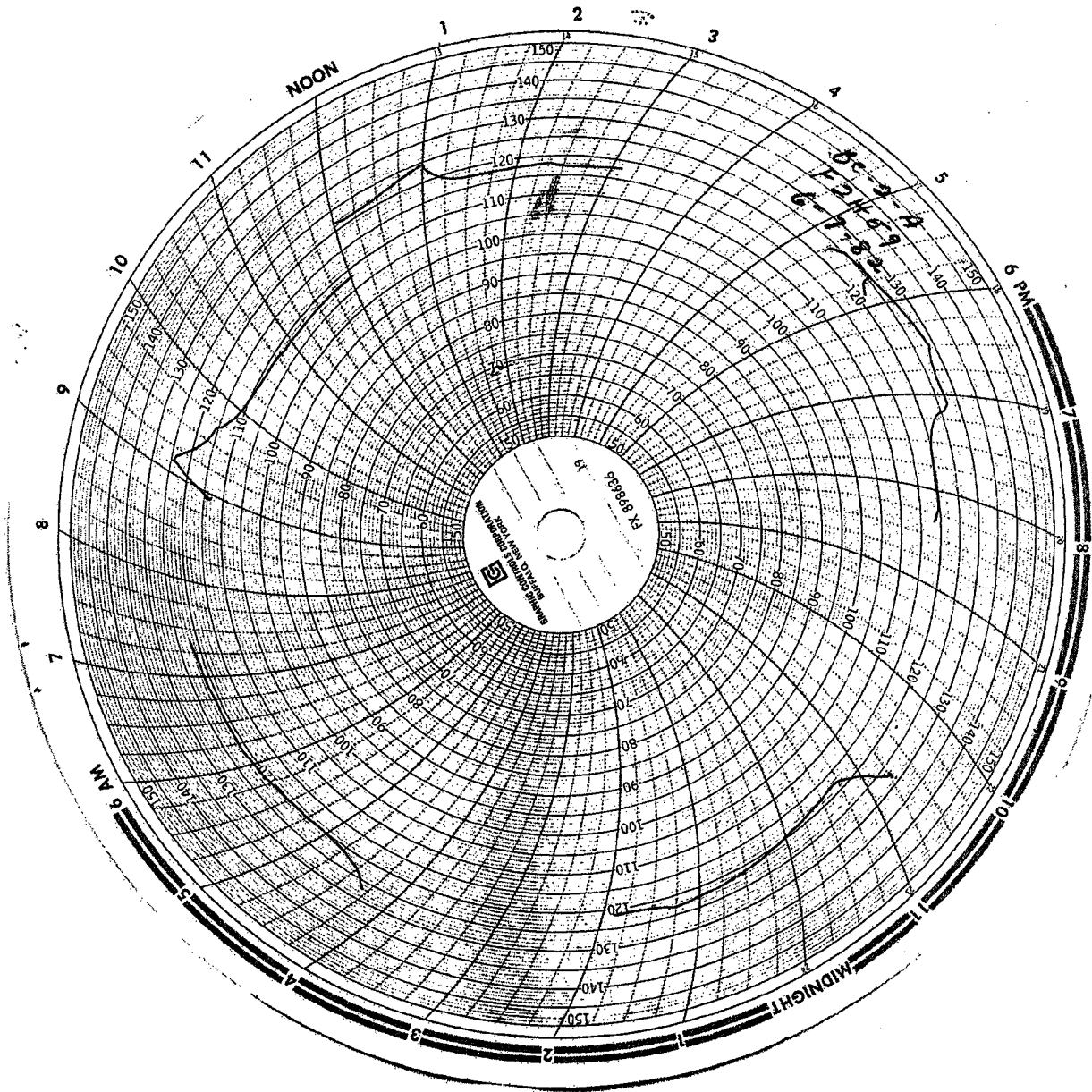
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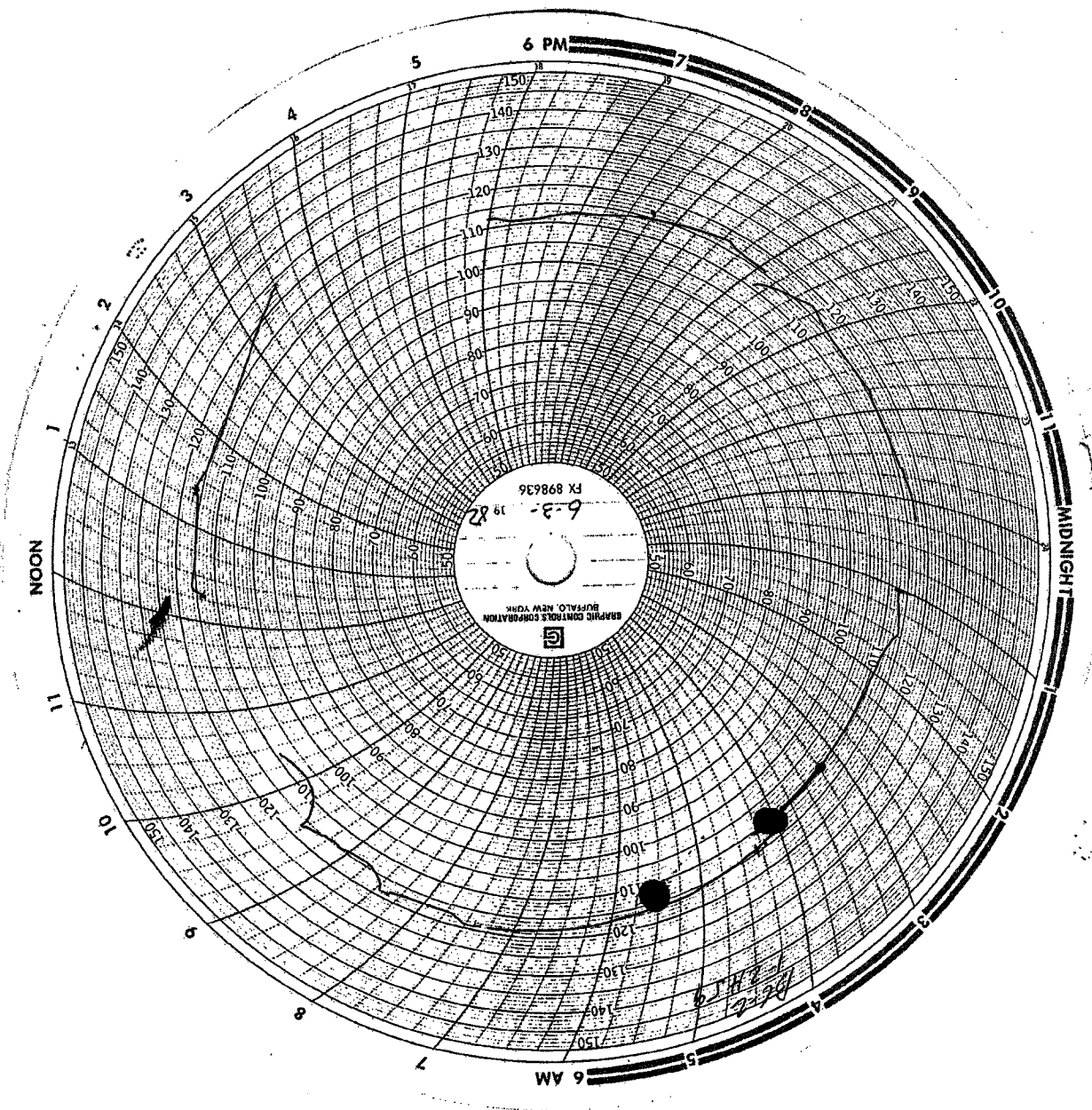


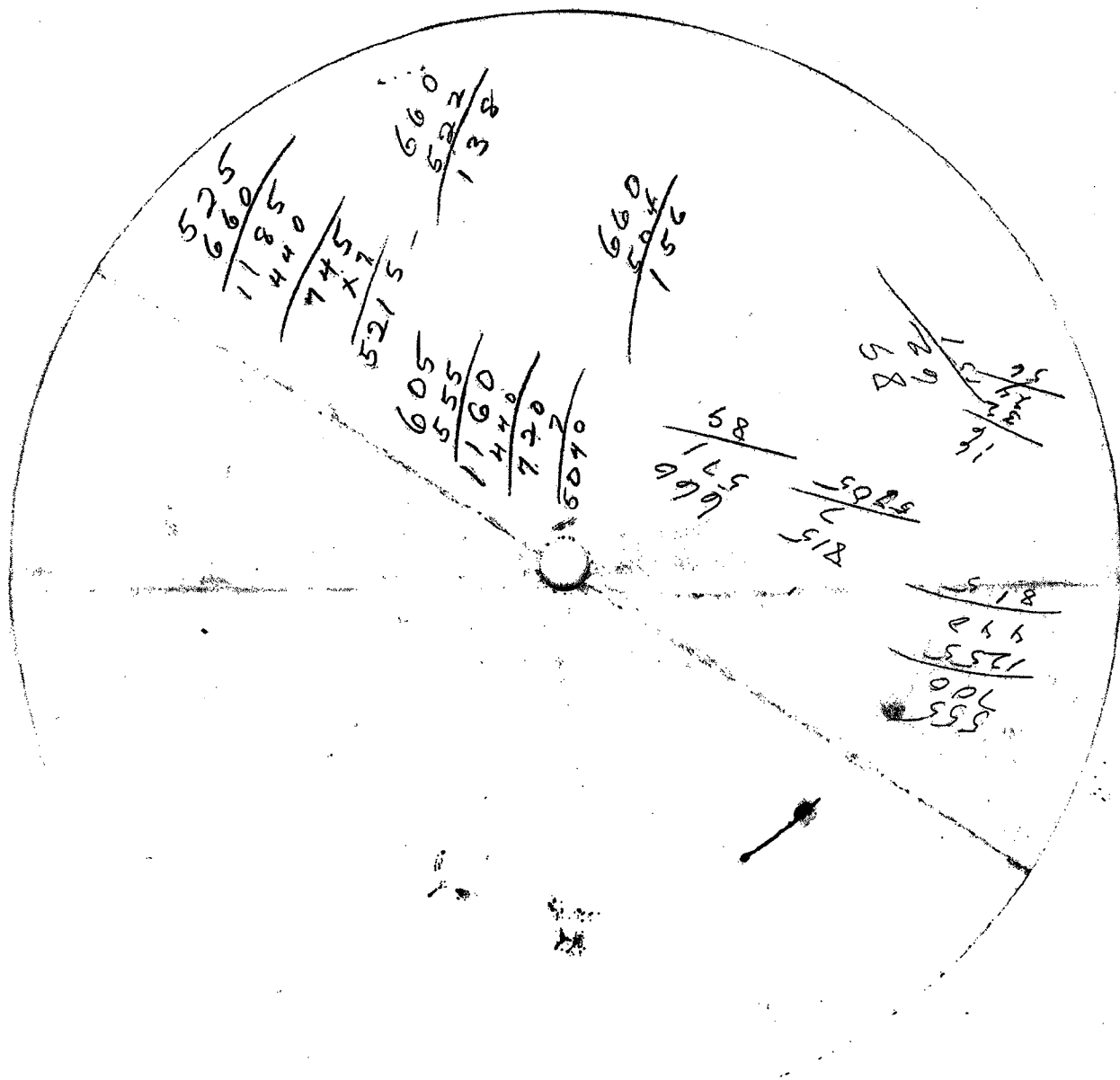












EQUIP MENT		PAGE 03 OF 04 CG 20 CODE BC-2-A (C)	USE LBS	N-CODE	ACCT LBS
180	25	TURN ON AGITATOR & INSTALL TEMP CHART			
11	26	RUN IN FROM V-386 M <u>17</u> <u>74.40</u> %	<u>1281</u>	27-D	1325
	27	RECORD: PH <u>1.5</u> (1.0-2.0)			
	28	IF NECESSARY ADJ TO PH 1.0-2.0 ASSUME 78X		27-D	
		RECORD: PH <u>✓</u>			
	29	HEAT TO 178-182 DEG F IN 40-45 MIN			
384	30	RUN IN 2200# WATER INTO V-384			
12	31	WEIGH IN ACID-DRUM & POUR IN M <u>1</u> <u>22.89</u> %	<u>171</u>	28-D	51
	32	TURN ON AGITATOR & STEAM			
	33	WEIGH & ADD IN 3-5 MIN LOT <u>2851</u> <u>2900</u> ¹⁰⁰ %		365-B	155
	34	HEAT TO 130-140F & STIR TO DISSOLVE FOR S35			
180	35	WHEN S-29 COMPLETE RUN V-384 AT 130-140°F			
13		INTO V-180 AT 178-182°F IN 10-15 MIN.			
	36	STIR 30 MIN AT 178-182 DEG F			
	37	RECORD: SPOT TEST (+) <u>✓</u> (-) <u>✓</u>			
		IF (-), CONTACT SUPERVISOR			
	38	FLOOD TO 86" (9159 G) AT 178-182 DEG F			
	39	STOP AGITATOR			
		NOTE: DURING PRESSING, REHEAT SV TO 178-182°F AT THE START OF EACH SHIFT			
MISC	40	RECORD DATA WHILE MILLING (ONCE EACH CHARGE)			
14		TABLE 2			

CHGE	TIME	MILL	ACCURACY					
			AMPS	* F				
NO.	DATE	START	FIN	HRS	TIME	AMMETER	REC	REC
1	6/1/82	9:00	12:00	3	11:00	29	29	115
2	6-2-82	1:00 AM	4:00 AM	3				
3	6-2	9 AM	12 PM	3	10:30 A	29	29	114
4	6/3/82	12:30 PM	3:30 PM	3	1:00 PM	30	28	121
5	6/3/82	6:10 AM	9:10 AM	3	8:00 AM	29	29	120
6	6/3/82	1:00 PM	4:00 PM	3	3:00 PM	30	28	119
7	6-3-82	6:00 PM	9:00 PM	3	7:30 PM	30	30	114
8	6-3-82	1:00 AM	4:00 AM	3	3:00 AM	28	28	110
9	6-4	9 AM	12 PM	3	10:30 A	28	28	118
10	6-5-82	12:15 PM	3:15 PM	3	2:00 PM	29	29	115
11	6-7-82	9:00 AM	12:00 PM	3	11:00 AM	30	28	115
12	6-7-82	1:00 PM	4:00 PM	3	2:30 PM	28	27	115
13	6-7-82	5:30 PM	9:30 PM	3	7:30 PM	29	28	123
14	6-7-82	10:45 AM	1:45 PM	3	12:45 PM	27	26	119
15	6-7-82	4:00 PM	7:00 PM	3	5:20 PM	29	25	120
16	6-8-82	9:00 AM	12:00 PM	3				
17	6/8	6:30 PM	9:30 PM	3	8 PM	30	30	118
18	6-8	1:15 PM	3:15 PM	2	2 AM	29	24	124
19	6-8	5:15 PM	8:15 PM	3	6:45 PM	27	28	125
20	6-8-82	9:45 AM	12:45 PM	3	11:00 AM	29	27	112
21	6-9-82	5:00 PM	8:00 PM	3	7:30 PM	28	26	115
22	6-9-82	10:15 AM	1:15 PM	3	11:00 AM	27	26	110
23	6-9-82	4:30 PM	7:30 PM	3	5:00 PM	30	29	118
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Note: 23 charges

EQUIP MENT	PAGE 04 OF 04 CG 20 CODE BC-2-A (C)	USE LBS	N-CODE	ACCT LBS																																																																		
V-180 15	SUPPLEMENT TO BC-2-A LOT _____ NOTE: THIS PAGE TO REMAIN IN MAKING UNTIL V-180 IS EMPTY																																																																					
1	AT START OF EACH SHIFT DURING PRESS-FILLING CYCLE: REHEAT SV TO 178-182 DEG F																																																																					
2	NOTE: USE TEMP CONTROLLER ABOVE 16" IN VOL USE MANUAL CONTROLLER FROM 9 1/2" TO 16" (CANNOT HEAT BELOW 9 1/2") RECORD																																																																					
	<table border="1"> <thead> <tr> <th>V-180 INITIAL</th> <th>TEMP FINAL</th> <th>BY OPTR</th> <th>DATE</th> <th>TIME</th> <th>APPROVED SUPV'R</th> </tr> </thead> <tbody> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table>	V-180 INITIAL	TEMP FINAL	BY OPTR	DATE	TIME	APPROVED SUPV'R																																																															
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3	WHEN VAT EMPTY, ATTACH RECORDER CHART TO THIS CARD & DELIVER CARD TO PROCESS ENGINEERING																																																																					