

PUNCH • CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

I.V. 100

C.V. 207

AUG - 1980

D.V. 313 322 330

CG 36 CODE RT-695-D PKG.

EST. WGT. 1350 LBS.

STD. HRS. TIME

11 AUG 5 1980

JUL 31 1980

PROCESSES	APPROVED BY
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()	()
TYPED BY	

Note - N-205-C is pre-accake - sales sheet is attached

LEAVE ONE STUMP ONLY CLEAN UP AS YOU GO ALONG

EQUIPMENT	NAME	RED	DARK	LB.	CODE	ACCT.
						LB.
Prep 1	1	If necessary, clean, dress sparkler & pre-coat with 15#				
	2	Obtain for S 6				
	3	Obtain for 32B (Note 431 or 433)				
313 2	4	Run 25" (370G) water into V-313				
	5	Weigh & pour in				
	6	Turn on agitator & steam & dump in from S 2 (ASSUME 9.1/2)				
		Lot	100%	%		
		403	204	220	55.0	
	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 °F				
		& Recorder °F				
		Record: Start	Total Min	Clarity		
207 3	13	Run 1" (125G) water into V-313 (Sample)				
	14	When S-12 complete, pump V 313 thru sparkler. Maintain V-313 at 190-195°F. Record: Start Total Min Sample From Hose				
	15	Weigh on Postal Scale & Add Lot				
322 4	16	Run in 2" (66G) water into V-322				
	17	Weigh in plastic lined Drums & Pour in & hold for S 28				
		M	30.85			
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				
230 6	20	Pump V 313 thru sparkler into V-330 (Sample)				
	21	When S-23 complete, pump V 330 thru sparkler into V-330				
	22	RECORD: VOLUME				
	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 is 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" (69G) water into V-207					
7	26	If S-29 is OK, pump V-207 at 180-190°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		35	25x330	57-A	14550
322	30	Run in 22" (755G) water into V-322					
8	31	Weigh & Pour in M .4281%		410	7-D	239	
	32	Dump in from S3 (used at 431 or 433 only) Lot		225	253-C	419	
				194			
	33	Weigh on postal scale & add Lot		15	180-C	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	
107	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 5.2 (5.0-5.5)					
	42	If pH above 5.5, adj to pH 5.5 or lower Assume 78%			27-D		
		Record: pH 5.1					
		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 .33.12%		301	725-A	166	
10							
322	45	Adj V-322 to 30" (1031) at 70-80°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 9:25 AM CR 1 KI TEMP 35°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 Assume 33%			725-A		
		RECORD: CR (+), KI (+)					
	49	Couple V-322 thru under surface distributor into V-207 in					
		40-45 min Record: Start 9:55 AM Total min 4.5					
	50	When S 49 complete, stir 15 min					
		Record: DIAZO (-); BASE (+); pH 11.9 (11.0-11.8) TEMP 62°F					
		NOTE: (1) If pH is 5.0-7.0, weigh & dump in 15# "as is" N-7-D AFAP Assume 50% Record: pH			7-D		
	51	If necessary, adj to pH 11.4-11.8 Assume 50% Record: pH			7-D		
		Record: pH Assume 32%			28-D		
	52	Adj to pH 8.2-8.6 Assume 32%		80	28-D	26	
		Record: pH 8.3 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 or N28 to adj pH					

FORM A

CODE

RT-695-P

LOT

36723

VATS

100-107-302 EQUIP.

DATE

7-31

OPER.

M. PETRUKHOS

SUPERVISOR

IAE

- ~~1. Used all stumps, leave 1 stump identified.~~
- ~~2. Clean shovel.~~
- ~~3. Chute washed & top replaced.~~
- ~~4. Water hose coiled.~~
- ~~5. Steam ejector turned off after finished in vat.~~
- ~~6. Scale left clean.~~
- ~~7. Added ice to vat only when volume reaches agitator.~~
- ~~8. Floor cleaned around vats used.~~
- ~~9. Hoses coiled or on rack on diazo press.~~
- ~~10. Hoses not crossing walkway after finished.~~
- ~~11. Pump shut off after removing hose from intake.~~
- ~~12. Ice blower shut off after using.~~
- ~~13. All spills in area worked clean.~~
- ~~14. Door on instruments closed.~~
- ~~15. All empty drums removed from area & discarded.~~
- ~~16. Corrosive containers properly covered.~~
- ~~17. Top of vats cleaned of color, paper cups, strings, etc.~~
- ~~18. Vat door closed after finished - hatches on abbe's.~~
- ~~19. All tools cleaned & placed in rack or proper places.~~
- ~~20. Ice house clean - tools on racks.~~
- ~~21. Revolvator cleaned - platform & pit.~~

ATTACH TO MAKE CARD



