

EST. WGT.

NOV-10-80

1350

LBS

STD. HRS.

TIME

11 PM

27

PROCESSES

APPROVED BY

()	()
()	()
()	()
()	()
TYPED BY	

NON-BLEEDING

EQUIPMENT	NAME: "BON" RED DARK	USE LBS.	N CODE	ACCT. LBS.
Prep 1	1 If necessary, clean, dress sparkler & pre-coat with 15#		777-A	
	2 Obtain for S 6		740-C	
	3 Obtain for 32B		82-C	
313 2	4 Run 25" (370G) water into V-313			
	5 Weigh & pour in		7-D	98
	6 Turn on agitator & steam & dump in from S 2		740-C	500
	Lot 100% %			
	7 Dump in	23	113-B	23
	8 Dump in	5	777-A	5
	9 Heat to 212-214°F WATCH FOAM			
	10 Record: BY (+), if necessary adj to + BY Assume 50%		7-D	
	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			
330 3	13 Run 1" (125G) water into V-330			
	14 When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at 190-195°F. Record: Start Total Min Sample-From Hose			
	Show to supervisor for OK			
	15 Weigh on Postal Scale & Add Lot	2	584-C	2
322 4	16 Run in 2" (66G) water into V-322			
	17 Weigh in plastic lined Drums & Pour in & hold for S 28			
	M %		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.			
330 6	20 Pump V 313 thru Sparkler into V-330 (Sample)			
	21 When MTV-blow out 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 if OK, continue with S-25. If 2-23 is not acceptable re-clarify thru sparkler.			

NOV 6 1980

CG 36 CODE RT-695-D PKG.
 → NOV-10 80 37797
 EST. WGT. 1350 LBS.

PROCESSING INSTRUCTIONS: BATCH UNIT

PROCESSES	APPROVED BY
RT-695-D (M)	DCG 1-12
	IHD 2-25
TYPED BY	
LG 5-15-72	

Retyped 2-27-80
Mm

MAKING NOTES

REMARKS

NAME: BON RED DARK

NON-BLEEDING

INSTRUCTIONS

-PRESSING-

RECORD

VAT						PRESSLOAD	1ST	2ND	3RD	4TH	5TH
DATE						STARTED					
TIME						CAKES USED					
RELEASED BY						WATER ON					
PRESS	32	33	35	38	39	HRS. WASHED					
NO. OF CAKES	60	60	60	60	60	OHMS					
PRESS without						HRS. WASHED					
WASH TO 4000						OHMS					
TEST AFTER 16						HRS. WASHED					
LOAD on 8 cars						OHMS					
						CAKE CONDITION					
						NO. CARS LOADED					
						EXPLAIN LOSSES					

SAMPLES

DELIVER TO

SAMPLED BY

RELEASED BY

-DRYING-

HOURS Dry 24 hours at L.V.	H.V.	LUMP: - OK - WET - SALTS - CONTAMINATE
TEMP. 180 °F	°F	
SE 15-30		
Mn Color		

ADDITIONAL DRYING HOURS REQUIRED

SAMPLES

DELIVER TO

NO. CARS PULLED

LUMP WGT.

SAMPLED BY

RELEASED BY

-GRINDING-

MILL 5 HSP 1/8" RP	SCREEN 4600	RPM	SCREEN	RPM
MAX. TEMP.	°F		MAX. TEMP.	°F
Mn Color				
			EXPLAIN LOSSES	

SAMPLE AFTER / WITHOUT MIXING

DATE MIXED

SAMPLES Env & 2 pt cans

DELIVER TO C T L

SAMPLED BY

RELEASED BY

DUP050107213

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-24 is OK, pump V-330 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				
	29	Adj to 33" (2277G) at 32-38°F	27x330	57-A		
322	30	Run in 22" (755G) water into V-322				
8	31	Weigh & Pour in M %		7-D	239	
	32	Dump in from S3 Lot		82-C	445	
	33	Weigh on postal scale & add Lot	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	
107	37	Run in 14" (1391G) water into V-107				
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 (5.0-5.5)				
	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 %		725-A	166	
10						
322	45	Adj V-322 to 30" (1031) at 70-80°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 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 (+)				
	49	Couple V-322 thru under surface distributor into V-207 in 40-45 min Record: Start Total min				
	50	When S 49 complete, stir 15 min				
		Record: DIAZO (-); BASE (+); pH (11.4-11.8)				
		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%		7-D		
		Record: pH Assume 32%		28-D		
	52	Adj to pH 9.0-9.5 Assume 32%		28-D		
		Record: pH 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				

MD-3-A

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE R4695 LOT 37737

NET WT/PKG NO. PKG PACK. WGT LOCATION PQ

9 1353 7**STUMP** 1353TOTAL NET WT. 1353 PKG. N-CODE

PROD. SPVR. DATE WHSE. OPER.

RP 11/17/80 23

Q.T

158.+

177.+

144.+

156.+

176.+

197.+

163.+

144.+

38.+

1353.T