

S.V. 1043

C.V. 207

MAKING INSTRUCTIONS: BATCH UNIT

D.V. 313, 322, 330

CG 36 CODE RT-695-D PKG.

PUNCHED & CHECKED

JUL 29 80 36665
EST. WGT. 1350 LBS.

STD. HRS. TIME

PROCESSES	APPROVED BY
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()	()
()	()
TYPED BY	

LEAVE ONE STUMP ONLY

CLEAN UP
AS YOU GO ALONG
NON-BLEEDING

EQUIPMENT	NAME: "BON" RED DARK	USE LBS.	N CODE	ACCT. LBS.
Prep	1 If necessary, clean, dress sparkler & pre-coat with 15#		777-A	
1	2 Obtain for S 6		740-C	
	3 Obtain for 32B		82-C	
313	4 Run 25" (370G) water into V-313			
2	5 Weigh & pour in	49.81	7-D	98
	6 Turn on agitator & steam & dump in from S 2		740-C	500
	Lot 100% 3	98.8		502
	35 50% 98.8			
	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 195°F			
	& Recorder 195°F			
	Record: Start 9:15 AM Total Min 15 Clarity 84			
330	13 Run 1" (125G) water into V-330 207			
3	14 When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at 190-195°F. Record: Start 7:30 Total Min 30 Sample-From Hose			
207	Show to supervisor for OK			
	15 Weigh on Postal Scale & Add Lot	2	584-C	2
322	16 Run in 2" (66G) water into V-322			
4	17 Weigh in plastic lined Drums & Pour in & hold for S 28			
	M 308.5	600	28-D	202
313	18 When S14 complete, close V-313 outlet & stop pump			
5	19 Run in 13" (192G) water & heat to 180-190°F			
	Circulate thru Sparkler until sol'n is clear			
330	20 Pump V 313 thru Sparkler into V-330 207 (Sample)			
6	21 When MTY-blow out Sparkler into V-330 207			
207	22 RECORD: VOLUME 11"			
	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.			

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			32		
	29	Adj to 33" (2277G) at 32-38°F			20x330	57-A	10560
322	30	Run in 22" (755G) water into V-322					
8	31	Weigh & Pour in	M	47.81	480	7-D	239
	32	Dump in from S3		Lot		82-C	448
				486.2	425		425
	33	Weigh on postal scale & add		Lot 80/103	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 5.1 (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	33.12	500	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					
32	48	Stir 30 min at 32-38°F maintaining + Cr, +KI				57-A	
		Record: Time Start 2:45 PM 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 2:35 PM Total min 45					
	50	When S 49 complete, stir 15 min					
		Record: DIAZO (-); BASE + (+); pH 10.9 (11.4-11.8)					
		NOTE: (1) If pH is 5.0-7.0, weigh & dump in 15# "as is" N-7-D AFAP				7-D	
		Assume 50% Record: pH					
	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%		30	28-D	9
		Record: pH 9.3	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					

K 13830 REV.

FORM A

CODE _____ LOT _____ VATS _____ EQUIP. _____

DATE _____ OPER. _____ SUPERVISOR _____

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



