V. (107) C.V. 100 D.V. 330, 322

CG 36 CODE RT-695-D PKG.

→ Nov 21 32921

EST. WGT. 2781 LBS.

STD. HRS. _____ TIME 7:AM

FINISHED & CHECKED NOV 27

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

Pre-coat & Sparkler

NOV 21 1979

NON-BLEEDING

UIPMENT		NAME: "BON" RED DARK	USE LBS.	N CODE	ACCT. LBS.
REP 1	1	If necessary, clean, dress Sparkler & pre-coat with 15#	15	777-A	15
	2	Obtain for S 6		740-C	
	3	Obtain for S 34		82-C	
330 2	4	Run 42" (823G) water into V-330			
	5	Weigh & POUR IN M 11, 49.29%	436	7-D	215
	6	Turn on agitator & steam & dump in from S 2		740-C	1102
		Lot 100% %			
		947 641 98.59	650		
		956 320 98.46	325		
		946 141 98.63	143		
	7	Dump in	50	113-B	50
	8	Dump in	10	777-A	10
	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 S 14 & Record: HT 195 °F			
		& Recorder 195 °F			
		Record: Start 1145 Total Min 15 Clarity Clear			
-100 3	13	Run 1" (99G) water into V-100	R+D		
	14	When S 12 complete, pump in V-330 thru Sparkler. Maintain			
		V-330 at 190-195°F. Record: Start 1235 Total Min 25 SAMPLE FROM HOSE-SHOW TO SUPERVISOR FOR OK			
	15	WEIGH ON POSTAL SCALE & ADD LOT [illegible]	2 #	584-C	2 #
330 4	16	WHEN S14 COMPLETE, CLOSE V-330 OUTLET & STOP PUMP			
	17	RUN IN 22" (431G) WATER & HEAT TO 180-190°F			
-100 5	18	PUMP V-330 THRU SPARKLER INTO V-100			
	19	WHEN OUT, BLOW OUT SPARKLER INTO V-100			
	20	ADJ TO 16" (1590G) 3			
	21	HEAT TO 165-170°F (TAKE 1 QT SAMPLE) Sample	OK		
		SHOW 1 QT SAMPLE TO SHIFT SUPERVISOR FOR			
		APPROVAL. (EXAMPLE OF ACCEPTABLE	R+D		
		CLARIFICATION OF N7HD-C IS AVAILABLE			
		IN OFFICE TO COMPARE TO.) - TAKE SAMPLE WITH AGITATION			
	22	IF S-23 IS OK, CONTINUE WITH S-23.			
		IF S-23 IS NOT ACCEPTABLE, RE-CLARIFY			
		THRU SPARKLER			
		[illegible]			
	23	RUN IN FROM V-324 THRU DIRECT M.S. 31.62%	1401	28-D	443
		LINES RINSE IN + & STIR 15 MIN AT 165-170°F			
	24	ADJ TO 50" (4970G) AT 28-32°F	65x330	57-A	21450
		+ RECORD: TEMP 30°F			

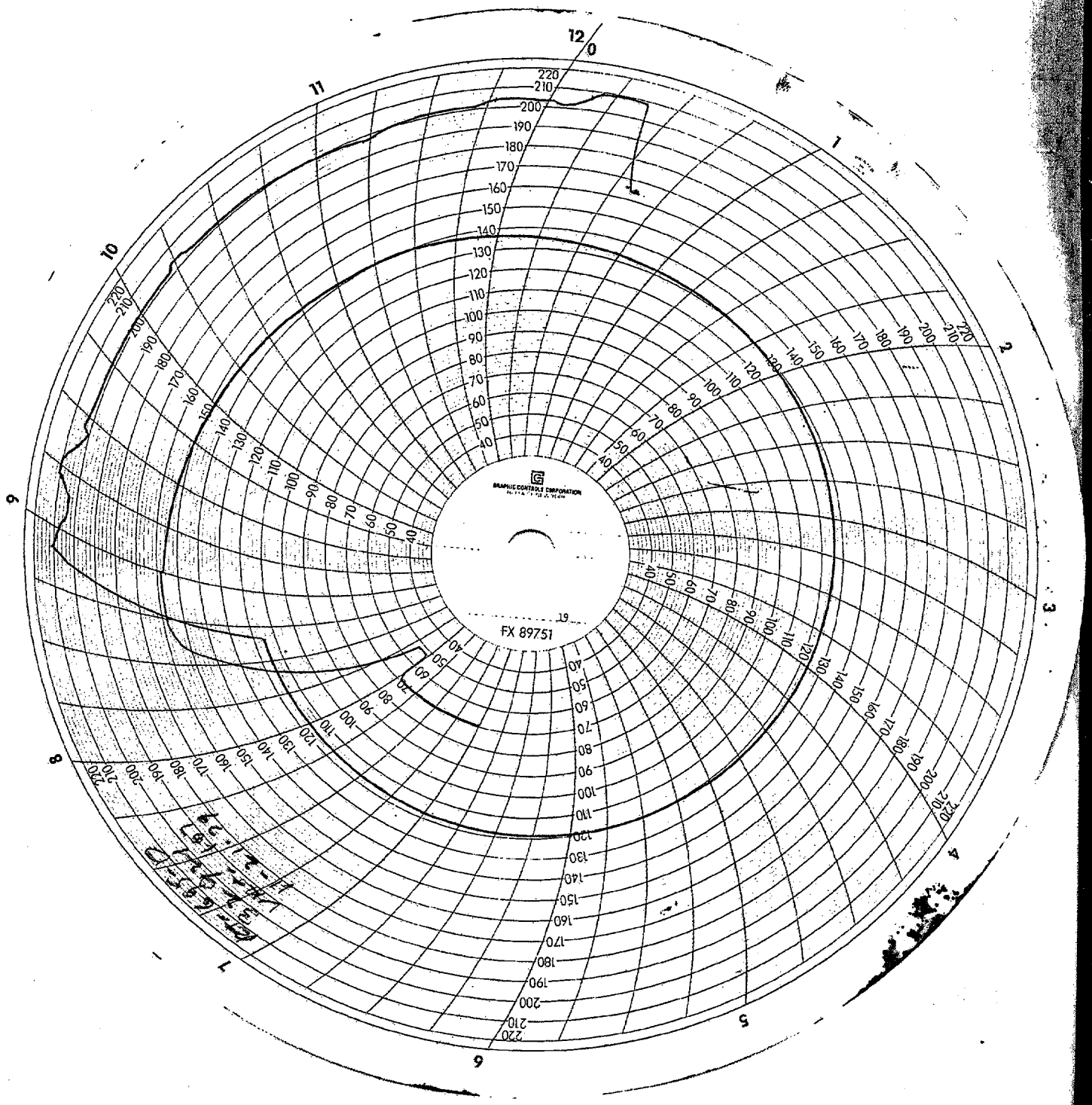
UIPMENT		PAGE 2 CG 36 CODE RT-695-D EST. WGT. 2781 LBS.	USE LBS.	N CODE	ACCT LBS.
07	25	RUN 25" (2400G) WATER INTO V-107			
7	26	TURN ON AGITATOR & STEAM & DUMP IN	1400	336-B	1400
	27	DUMP IN	250	65-A	250
	28	HEAT TO 150-160°F & STIR			
	29	RECORD: pH 4.5 (5.0-5.5)			
	30	IF pH ABOVE 5.5, ADJ TO pH 5.5 OR LOWER ASSUME 78%	—	27-D	—
		RECORD: pH —			
		NOTE: IF pH BELOW 5.0, DO NOT ADJ UPWARD			
	31	HOLD FOR [illegible] S47			
322	32	RUN IN 47" (1610G) WATER INTO V-322			532
4	33	WEIGH & POUR IN M 11 49.29%	1079	7-D	~~[illegible]~~
	34	DUMP IN FROM S3 LOT		82-C	~~[illegible]~~
		2728	500		968
		3166	221		
		2687	167		
	35	WEIGH & ADD LOT 90703	18	180-C	18
	36	HEAT TO 70-90°F			
	37	SLOW IN IN 1-2 MIN	27	567-B	27
	38	DUMP IN & STIR 5 MIN OR LONGER TO DISSOLVE	8	479-D	8
02/330	39	WEIGH & POUR INTO V330 FOR S42 M 16 32.68%	1127	725-A	~~[illegible]~~
6				+	365
22	40	ADJ V322 TO 65" (2240G) AT 70-80°F			
7	41	SLURRY WITH 30 GAL WATER IN DRUM, POUR IN & STIR 5 MIN	160	39-A	160
100	42	RUN IN N-725-A FROM S30 AFAP INTO V-100			
8	43	STIR 30 MIN AT 32-38°F MAINTAINING + CR + KI	—	57-A	—
		Record: Time Start 6:25 P, CR +, KI +			
		NOTE: 1. If CR -, KI - add 20# asis increments Assume 32%		28-A	
		Record: CR (+), KI (+)			
		2. If CR +, KI - add 20# asis increments Assume 33%		725-A	
		Record: CR (+), KI (+), Temp °F			
	44	COUPLE V322 THRU UNDERSURFACE DISTRIBUTOR			
		INTO V-100 IN 90-110 MIN (Use 9/16" ORIFICE)			
		RECORD: START 7:10 PM TOTAL MIN —			
	45	WHEN S44 COMPLETE STIR 5 MIN			
		RECORD: DIAZO — (-); BASE + (+). pH 11.7 (11.4-11.8) (SAMPLE)			
		Note: 1. IF pH IS 5.0-7.0 WEIGH & DUMP IN 30#			
		"ASIS" N-7-D AFAP ASSUME 50%	—	7-D	—
		RECORD: pH —			
		2. IF NECESSARY, ADJ TO pH 11.4-11.8 ASSUME 50%	—	7-D	—
		RECORD: pH — ASSUME 32%	—	28-D	—
	46	ADJ TO pH ~~[illegible]~~ 10.4-10.6 ASSUME 32%	60	28-D	20
		RECORD: pH 10.4 ASSUME 50%	—	7-D	—
		Note: ADD N-28-D IN 5# "AS IS" INCREMENTS TO			
		APPROACH pH ~~[illegible]~~ (10.4-10.6) THEN USE LESS N-28-D			
		(VERY IMPORTANT NOT TO DROP pH			
		BELOW 10.4. ONCE IT GOES BELOW			
		10.2 MASSTONE 8 GOES TOO LIGHT.			
		ADJUSTING BACK UP WILL NOT CORRECT)			

DUP050292419

QUIPMENT		PAGE 2 CG 36 CODE RT-695-D EST. WGT. 2781 LBS.	USE LBS.	N CODE	AC LB
107 9	47	DURING S44 HEAT V-107 TO 210-212°F & SHUT OFF STEAM			
		NOTE: IF NECESSARY, REHEAT V-107 TO 210-212°F PRIOR TO START OF STRIKE			
→	48	PUMP V-100 INTO V-107 IN 70-75 MIN. LET V-107 TEMP DROP TO 200-205°F DURING STRIKE THEN MAINTAIN AT 200-205°F FOR BALANCE OF STRIKE			
		RECORD: START 9:30p TOTAL MIN 180			
	49	WHEN STRIKE COMPLETE, HEAT TO 210-212°F			
	50	STIR 15 MIN AT 210-212°F			
	51	FLOOD TO 180-190" (18,240 G). RECORD: pH 7.0 (6.5-7.2) & STOP AGITATOR			
		SAMPLE			

START	FIN	OPT'R
2:00 AM	3:00 P	126
3:00 P	11:00 P	101
11:00 PM	1:10 AM	301

DUP050292420



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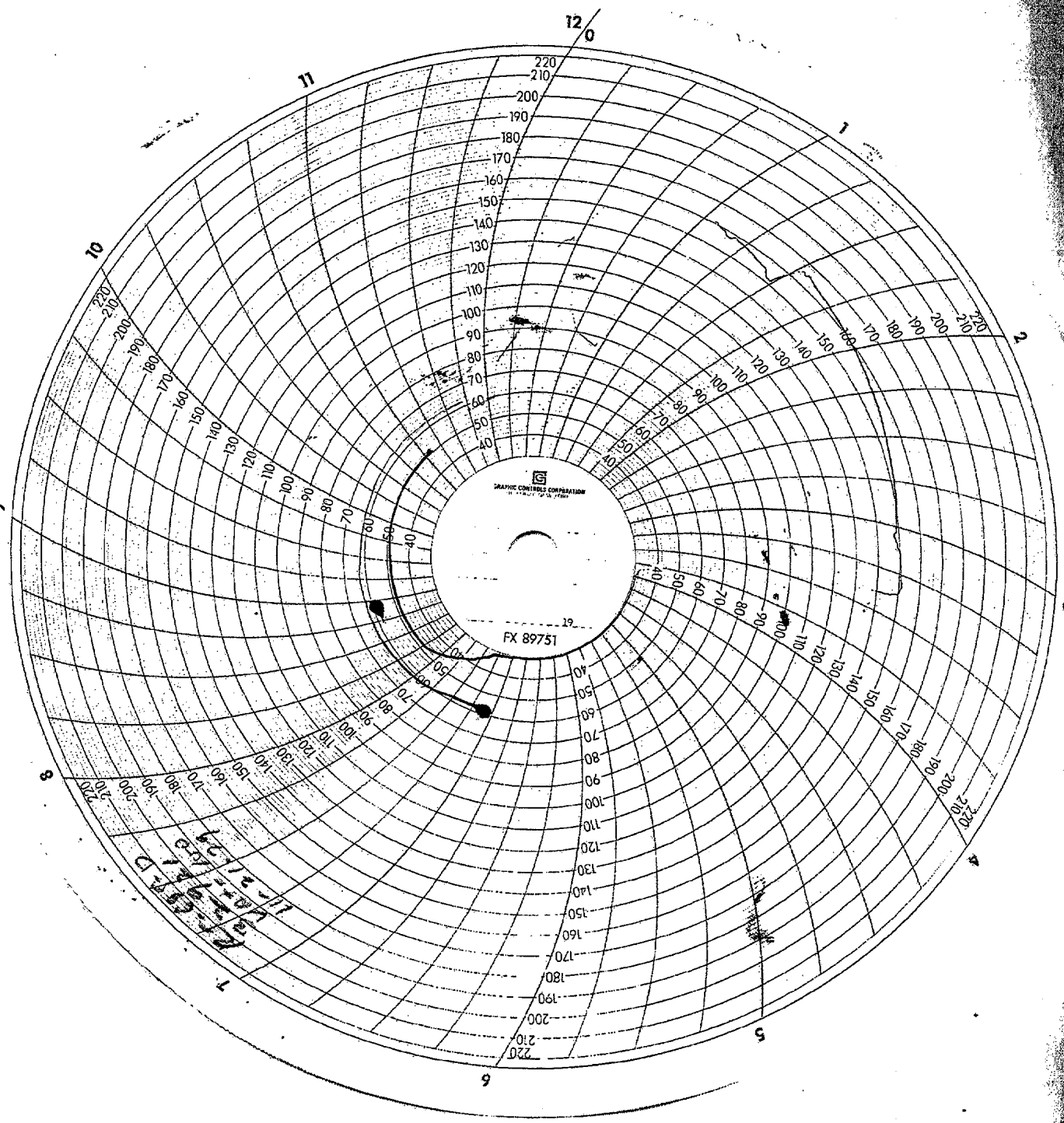
N 31833.01



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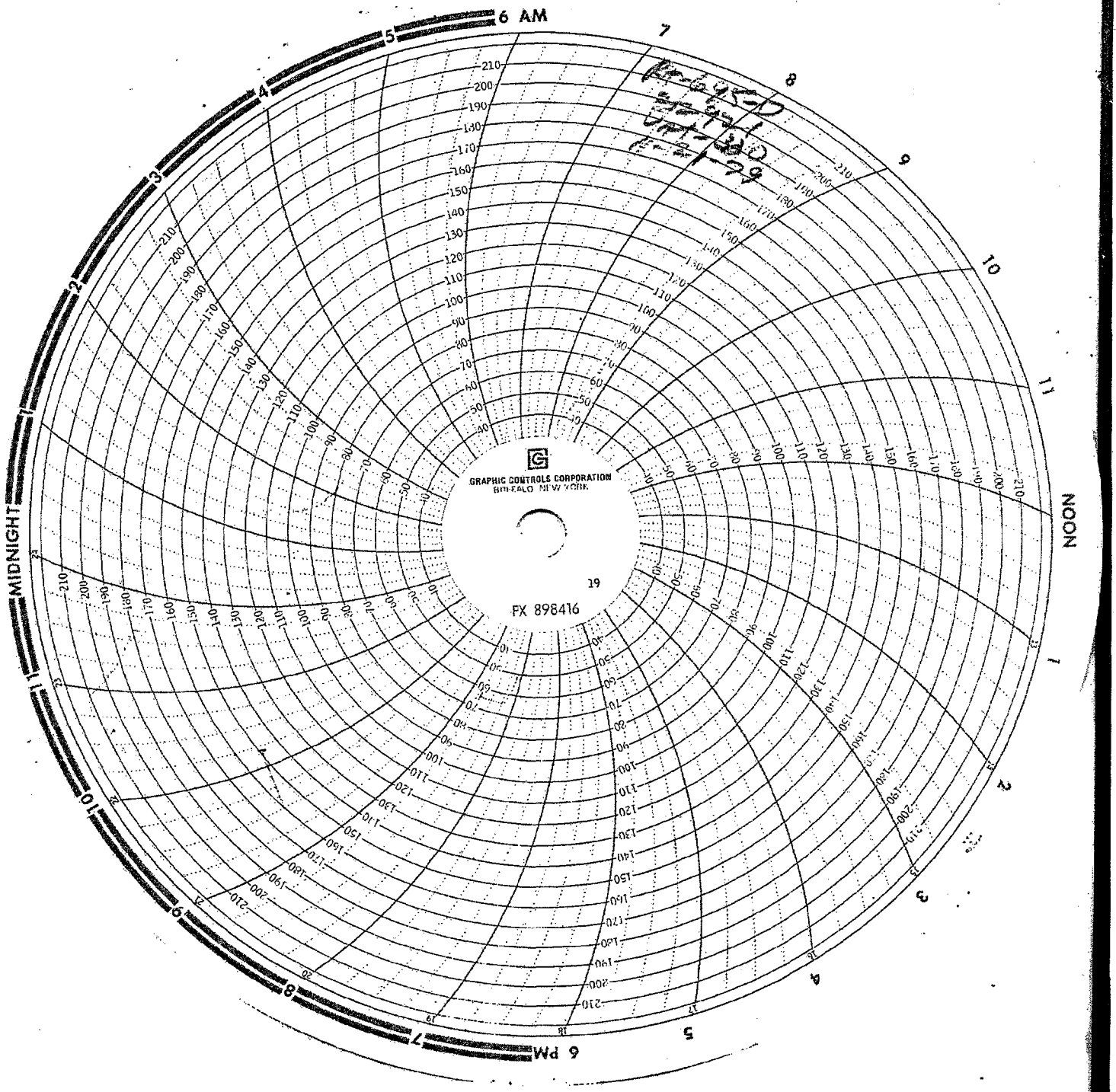

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N 31833.03

MD-3-A

PACKAGE TICKET RT695 (DRY AND PASTE ONLY)

CODE _____ LOT 32921

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PQ
	23	2717	27-29	

STUMP

TOTAL NET WT. 2717 PKG. N—CODE _____

PROD. 18PVR. [illegible] DATE 11 27 WHSE. OPER. 292

N 31833.04

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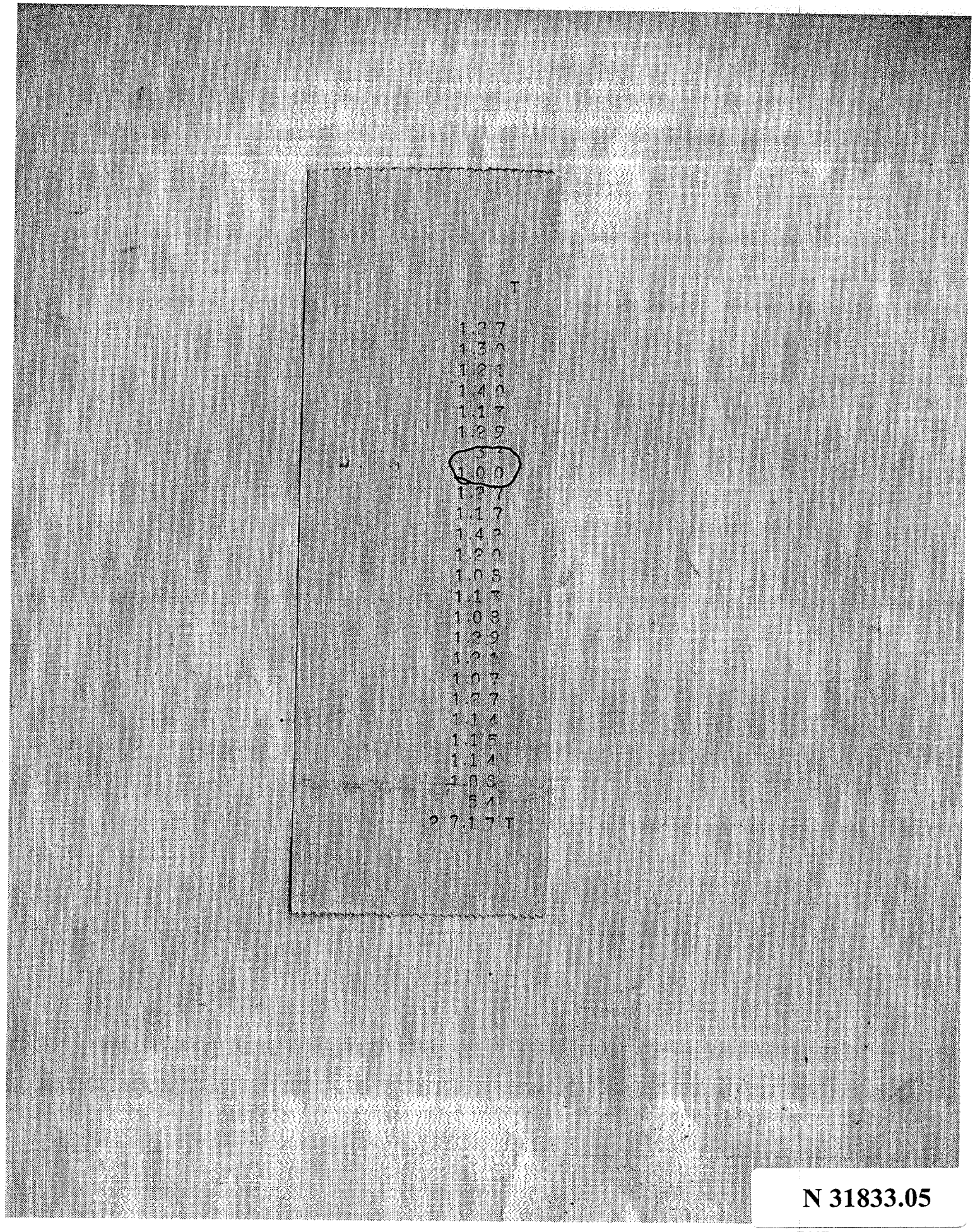

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DUP050292425

35/107

CG 36 CODE RT-695-D PKG. ____

NOV 21 32921

EST. WGT. 2781 LBS.

2 yr

PROCESSING INSTRUCTIONS: BATCH UNIT

PROCESSES	APPROVED BY
TYPED BY	

MAKING NOTES

REMARKS

CXN OK 197

NAME: "BON" RED DARK NON-BLEEDING

INSTRUCTIONS -PRESSING- RECORD

MAT	107				
DATE	11-21-79				
TIME	1:10 AM				
RELEASED BY					
PRESS	32	33	35	37	
NO. OF CAKES	60	60	60	60	

PRESS WITHOUT AGITATION

WASH TO 4000 OHMS

TEST AFTER 16 HOURS with 35-75 F water

LOAD on 8 cars

CLEAN PUMP STRAINER & MAGNETIC SEPERATOR AFTER FILLING

CLEAN: BY TGT TIME 5:30 PM

SAMPLES

DELIVER TO

PRESSLOAD	1ST	2ND	3RD	4TH	5TH
STARTED	930AM				
CAKES USED	60				
WATER ON	3200				
HRS. WASHED	16			4	
OHMS	4000				
HRS. WASHED					
OHMS					
HRS. WASHED					
OHMS					
CAKE CONDITION					
NO. CARS LOADED	6				
EXPLAIN LOSSES					
SAMPLED BY		RELEASED BY			

-DRYING-

XXXXXX	XXX	XXX
XXXX	XXX	XXF

DRY 12 HOURS AT 220 F

DRY 12 HOURS AT 180 F

Mn COLOR

CO2 USAGE 11-11-11 %

SAMPLES

DELIVER TO OXYGEN

LUMP: - OK - WET - SALTS - CONTAMINAT

ADDITIONAL DRYING HOURS REQUIRED

NO. DRUMS 15

NO. CARS PULLED LUMP WGT. 2220

SAMPLED BY RELEASED BY

-GRINDING-

MILL 4 HSP 1/8" RP SCREEN 4600 RPM

MAX. TEMP. 170 °F

MN COLOR

SAMPLE XXXXXX WITHOUT MIXING

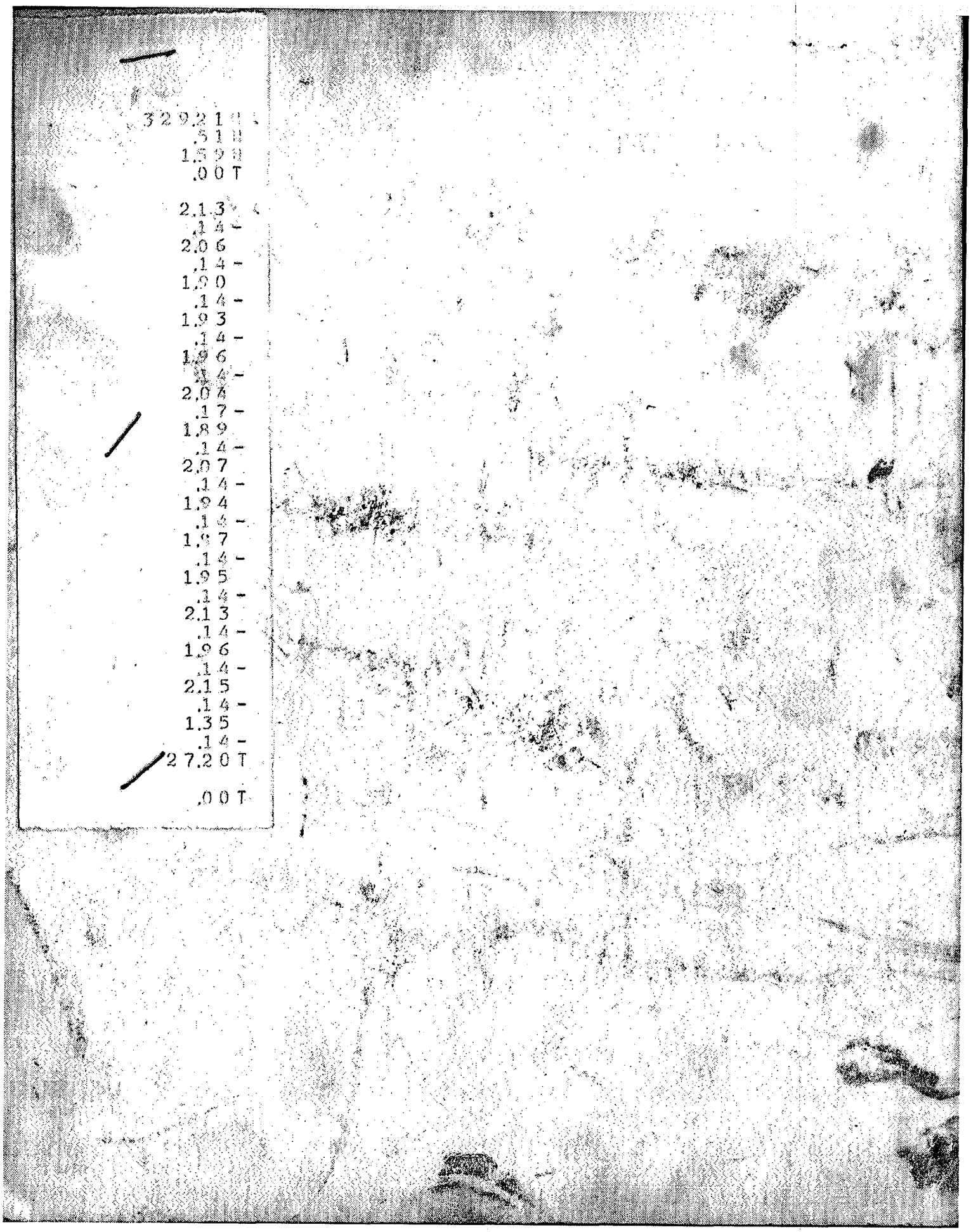
SAMPLES 1 ENV & 3 PT CANS

DELIVER TO C T L

SCREEN	RPM
MAX. TEMP.	°F
EXPLAIN LOSSES	
DATE MIXED	11-27
SAMPLED BY	RELEASED BY

DUP050292426

N 31833.06



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N 31833.07