

CG 36 CODE RT-695-D PKG

PROCESSES

APPROVED BY

MAY -0.81-21284

() RT-695-D (N)

JJG 3/18/81

(M) ALTERNATE ()

() ()

TYPED BY: JLC

ESTIMATED WGT

2781

LBS.

STANDARD HRS.

TIME M

PREPARATION NOTES:

Start on 3rd Shift. Prepare W 740-C
Classification, N 253-C Sol & N 336 sol

I. Large will follow Coupling on 1st shift

EQUIP MENT	NAME: "BON" RED DARK	USE LBS	N-CODE	ACCT LBS
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PREP	1	IF NECESSARY, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15#		
	2	OBTAIN FOR S 6	777-A	
	3	OBTAIN FOR S 42	740-C	
			253-C	

317	4	RUN 23" (748G) WATER INTO V-317		
2	5	WEIGH & POUR IN	7-D	215
	6	TURN ON AGITATOR & STEAM & DUMP IN FROM S 2	740-C	10.94
		LOT 100 100% 48.5 2 98.58		
		199 199 45.7 2 99.2		
		197 197 45.7 2 99.2		
	7	WEIGH ON POSTAL SCALE & ADD LOT	584-C	10
	8	DUMP IN	113-B	50
	9	DUMP IN	777-A	10
	10	HEAT TO 214-216 DEG. F WATCH FOAM		
	11	RECORD: BY (+), IF NECESSARY ADJUST TO + BY ASSUME 50%	7-D	
	12	STIR 30 MIN. AT 212-214 DEG. F, THEN SHUT OFF STEAM WATCH FOAM		
		NOTE RECORD: SPARKLER PRESSURE PSI		
		IF NOT ZERO, NOTIFY SUPERVISOR		
	13	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR		
		MAINTAIN AT 190-195 DEG. F FOR S 15		
		RECORD: HT 145 DEG. F & RECORDER 145 DEG. F		
		RECORD: START 130 TOTAL MIN 130 CLARITY 0.1		

100	14	RUN #1 (99G) WATER INTO V-100		
3	15	WHEN S-13 COMPLETE, PUMP V 317 THRU SPARKLER. MAINTAIN V-317 AT 190-195 DEG. F		
		RECORD: START 110 TOTAL MIN 30		
		SAMPLE FROM HOSE. SHOW TO SUPV'R FOR OK		

317	16	WHEN S 13 COMPLETE, CLOSE V-317 OUTLET & STOP PUMP		
4	17	RUN IN 12" (215G) WATER & HEAT TO 190-195 DEG F		

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 02 OF 04 CG 36 CODE RT-695-D (N)	USE LBS	N-CODE	ACCT LBS
317 CONT'D 4	18	CIRCULATE THRU SPARKLER UNTIL SOLUTION IS CLEAR MAINTAIN AT 190-195 DEG. F FOR S 19 & RECORD: HT <u>190</u> DEG. F & RECORDER <u>19</u> <u>OK</u> RECORD: START <u>230</u> TOTAL MIN <u>12</u> CLARITY <u>OK</u>			
100 5	19	WHEN S 18 IS COMPLETE, PUMP V-317 THRU SPARKLER INTO V-100			
	20	RUN IN 5" (90G) WATER & HEAT TO 190-195 DEG. F			
	21	CIRCULATE 15 MIN THRU SPARKLER, PUMP V-317 THRU SPARKLER INTO V-100			
	22	WHEN MT, BLOW OUT SPARKLER INTO V-100			
	23	HEAT TO 165-170 DEG. F (TAKE 1 QT. SAMPLE) (WITH AGITATION ON) TEST FOR CLARITY OF SOLUTION. SHOW 1 QT. SAMPLE TO SHIFT SUPERVISOR FOR APPROVAL (EXAMPLE OF ACCEPTABLE CLARIFICATION OF N-740-C IS AVAILABLE IN OFFICE TO COMPARE WITH)			
	24	IF S 23 IS OK, CONTINUE WITH S 25. IF S 23 IS NOT ACCEPTABLE, RECLARIFY THRU SPARKLER			
	25	IF S 23 IS OK, REHEAT V-100 TO 165-170 DEG. F FOR S 26			
100 6	26	ADJ TO 18" (1590G)			
	27	HEAT V-100 TO 165-170 DEG. F <u>2</u> <u>32100</u> % <u>1385</u>		28-D	443
	28	RUN IN V-324 THRU DIRECT M			
	29	LINE AND RINSE IN			
	30	STIR 15 MIN AT 165-170 DEG. F			
	31	ADJ TO 50" (4970G) AT 34-38 DEG. F			
	32	RECORD: TEMP <u>34</u> DEG. F AND IF NECESSARY 50X330		57-A	<u>16500</u>
	33	ADJ TO 34-38 DEG. F &			
	34	RECORD: TEMP <u>37</u> DEG. F		57-A	
107 7	31	RUN 45" (4320G) WATER INTO V-107			
	32	TURN ON AGITATOR AND STEAM AND DUMP IN	1400	336-B	1400
	33	DUMP IN	250	65-A	250
	34	HEAT TO 150-160 DEG. F AND STIR			
	35	RECORD: PH <u>6.7</u> (5.0-5.5)			
	36	IF PH ABOVE 5.5, ADJ TO PH 5.5 OR LOWER ASSUME 78%		27-D	<u>1</u>
	37	RECORD: PH <u>5.0</u>			
	38	NOTE: IF PH BELOW 5.0, DO NOT ADJ UPWARD			
	39	HOLD FOR S 58			
322 8	40	RUN IN 47" (1610G) WATER INTO V <u>322</u>			
	41	WEIGH AND POUR IN M <u>9</u> <u>5030</u> % <u>935</u>		7-D	470
	42	DUMP IN FROM S 3 LOT <u>552</u>		253-C	<u>932</u>
	43				
	44	WEIGH ON POSTAL BALANCE AND ADD LOT <u>85201</u>	<u>22</u>	180-C	<u>20</u> <u>22</u>

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 03 OF 04 CG 36 CODE N-695-D (N)	USE LBS	N-CODE	ACCT LBS
322 B	44	HEAT TO 70-90 DEG. F			
	45	SIFT IN IN ONE TO TWO MINUTES	27	567-B	27
	46	DUMP IN & STIR 5 MIN OR LONGER TO DISSOLVE	8	479-D	8
313/ 30	47	WEIGH & POUR INTO V- <u>313</u> FOR S 50 M <u>7</u> <u>32.93</u> % <u>1108</u>		725-A	365
322 10	48	ADJ V-322 TO 65" (2240G) AT 77-80 DEG. F & RECORD: TEMP <u>87</u> DEG. F			
	49	SLURRY WITH 30 GALS WATER IN DRUM. POUR IN AND STIR 5 MIN.	160	39-A	160
100 11	50	RUN IN N-725-A FROM S 47 AFAP INTO V-100			
	51	STIR 30 MIN AT 36-38 DEG. F MAINTAINING +CR, +KI		57-A	
	52	RECORD: TIME START <u>9:40</u> AC R <u>+</u> KI <u>+</u> TEMP <u>38</u> DEG. F			
		NOTE: (1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS ASSUME 32% RECORD: CR _____ (+), KI _____ (+)		28-A	
		(2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS ASSUME 33% RECORD: CR _____ (+), KI _____ (+) TEMP _____ DEG. F		725-A	
	53	COUPLE V-322 THRU UNDERSURFACE DISTRIBUTOR INTO V-100 IN 90-110 MIN (USE 9/16" ORIFICE)			
	54	RECORD: START <u>10:15</u> TOTAL MIN <u>100</u>			
	55	WHEN S 53 COMPLETE STIR 15 MIN			
	56	RECORD: DIAZO _____ (-), BASE <u>+</u> _____ (+) PH <u>6.7</u> (7.0-8.0) TEMP <u>69</u> DEG. F (60-65 F)			
		NOTE: (1) IF PH IS 5.0-7.0, WEIGH AND DUMP IN 30# "AS IS" N-7-D DILUTED TO 30 GAL AFAP ASSUME 50% (2) (FOR PH ADJUSTMENTS USE ONLY DILUTED N-28-D AND N-7-D)		7-A	
	57	ADJ TO PH 9.0-9.5 (SEE ATTACHED PH ADJ AID AND SHUT OFF AGITATOR ASSUME 32%		28-D	
	58	RECORD: PH <u>9.2</u> ASSUME 50%	42	7-D	21
		NOTE: ADD N-28-D IN 5# "AS IS" INCREMENTS TO APPROACH PH 9.0-9.5 THEN USE LESS N-28-D (CONCENTRATED N-28-D & N-7-D AND TOO LOW COUPLING TEMPERATURE CAUSES MASSTONE TO GO TOO LIGHT)			
	59	SHUT OFF AGITATOR			

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT			USE LBS	N-CODE	ACCT LBS
		PAGE 04 OF 04 CG 36 CODE RT-695-D (N)			
107	157	DURING S 53 HEAT V-107 TO 210-212 DEG. F			
12		& SHUT OFF STEAM			
		NOTE: IF NECESSARY REHEAT V-107 TO 210-			
		212 DEG. F PRIOR TO START OF STRIKE			
60		PUMP V-100 INTO V-107 IN 70-75 MIN.			
		LET V-107 TEMP DROP TO 200-205 DEG. F			
		DURING STRIKE THEN MAINTAIN AT 200-205 DEG. F			
		FOR BALANCE OF STRIKE WITH AGITATOR SHUT			
		OFF IN V-100			
		RECORD START <u>1:50 P</u> TOTAL MIN <u>85</u>			
61		WHEN STRIKE COMPLETE, HEAT TO 210-212 DEG. F			
62		STIR 15 MIN AT 210-212 DEG. F			
63		FLOOD TO 180-190" (18240G)			
		RECORD: PH <u>7.0</u> (6.5-7.2) AND STOP			
		AGITATOR			
		<i>1 gal Sample (for in office)</i>			
		START <u>11 Pm</u>			
		<u>7:00 A</u>			
		<u>3:40 P.M</u>			
		FINISH <u>7 A</u>			
		<u>12:00 P</u>			
		<u>3:00 P.M</u>			
		<u>4:10 P.M</u>			
		OPERATOR <u>120</u>			
		<u>27</u>			
		<u>144</u>			
		<u>381</u>			



