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

CG 36 CODE RT-695-D PKG. _____

NOV 14 32649

EST. WGT. 2781 LBS.

STD. HRS. _____ TIME _____ M 3/4

PUNCHED & CHECKED

NOV 16

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

N-725 3 DRUMS (3)

NOV 15 1979

NON-BLEEDING

EQUIPMENT		NAME: "BON" RED DARK	USE LBS.	N CODE	ACCT LBS.
REP 1	1	If necessary, clean, dress Sparkler & pre-coat with 15#		777-A	
	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% %			
		938 1102 98.67	1117		
	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 4 (+), 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 190°F			
		& Recorder 195°F			
		Record: Start 6:30 PM Total Min Clarity			
V-100 3	13	Run 1" (99G) water into V-100			
	14	When S 12 complete, pump in V-330 thru Sparkler. Maintain V-330 at 190-195°F. Record: Start TOTAL MIN. SAMPLE FROM HOSE-SHOW TO SUPERVISOR FOR OK	R+D		
	15	WEIGH ON POSTAL SCALE & ADD LOT 282	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			
V-100 5	18	PUMP V-330 THRU SPARKLER INTO V-100			
	19	WHEN MT, BLOW OUT SPARKLER INTO V-100			
	20	ADJ TO 16" (1590G) 3			
	21	HEAT TO 165-170°F (TAKE 1 QT SAMPLE) R+D			
		SHOW 1 QT SAMPLE TO SHIFT SUPERVISOR FOR APPROVAL. (EXAMPLE OF ACCEPTABLE CLARIFICATION OF N740-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 5, 31.62%	1401	28-D	443
		LINES RINSE IN & STIR 15 MIN AT 165-170°F	60X330		
	24	ADJ TO 50" (4970G) AT 28-32°F	65X330	57-A	19800

J.M

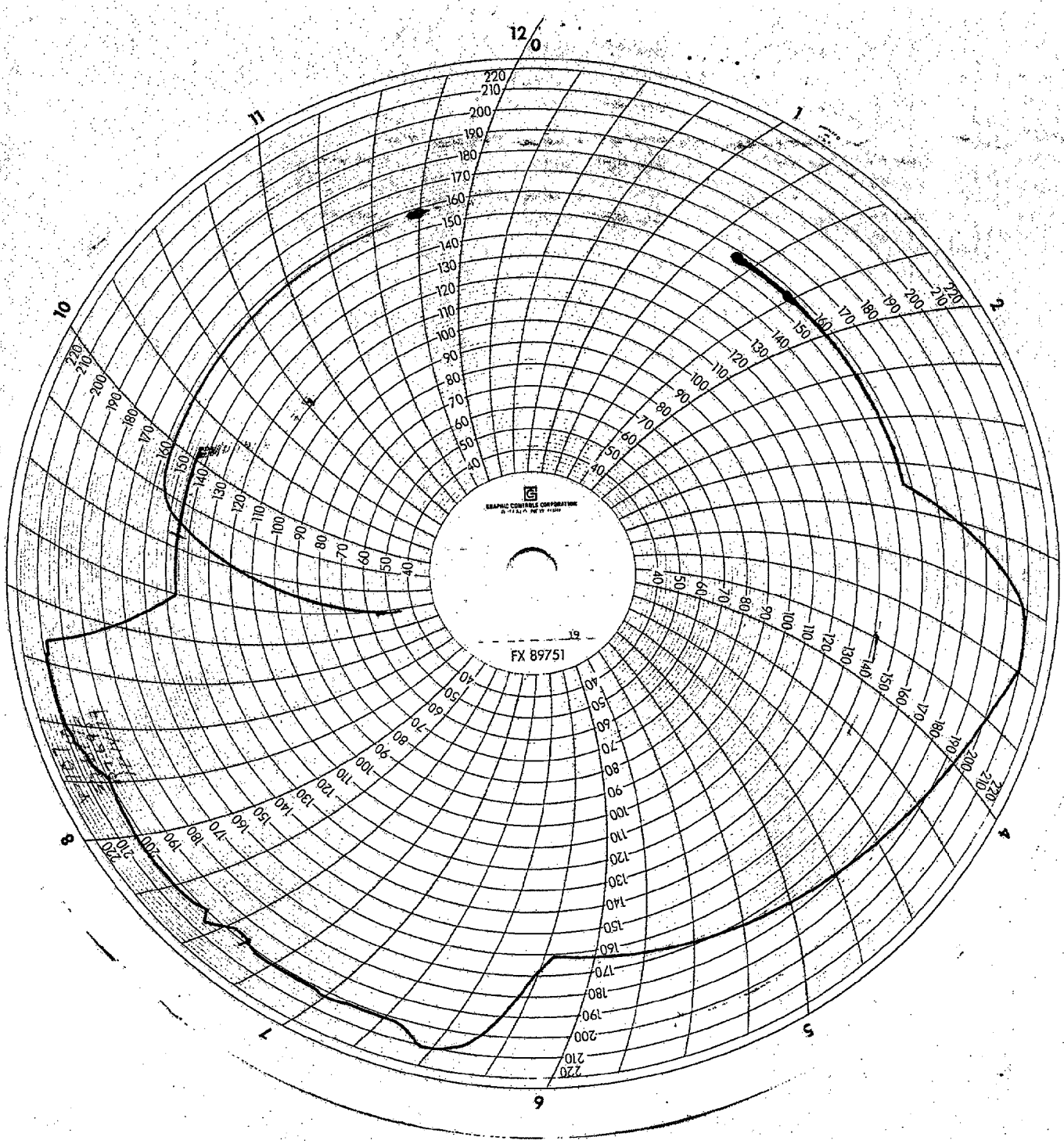
UIPMENT		PAGE 2 CG 36 CODE RT-695-D EST. WGT. 2781 LBS.	USE LBS.	N CODE	ACCT LBS.
07	25	RUN 25" (2400G) WATER INTO V-107			
7	26	TURN ON AGITATOR & STEAM & DUMP IN	1400	336-B	1400
	27	DUMP IN	250	65-A	250
	28	HEAT TO 150-160°F & STIR			
	29	RECORD: pH 5.4 (5.0-5.5)			
	30	IF pH ABOVE 5.5, ADJ TO pH 5.5 OR LOWER ASSUME 78%		27-D	
		RECORD: pH			
		NOTE: IF pH BELOW 5.0, DO NOT ADJ UPWARD			
	31	HOLD FOR S47			
322	32	RUN IN 47" (1610G) WATER INTO V-322			
4	33	WEIGH & POUR IN M 11, 49.2%	1065	7-D	525
	34	DUMP IN FROM S3 LOT 2687	968	82-C	968
	35	WEIGH & ADD LOT 90607	18	180-C	18
	36	HEAT TO 70-90°F			
	37	SIFT IN IN 1-2 MIN	27	567-B	27
	38	DUMP IN & STIR 5 MIN OR LONGER TO DISSOLVE	8	479-D	8
3 6	39	WEIGH & POUR INTO V 313 FOR S42 M 16, 32.68%	1,117	725-A 4	365
322	40	ADJ V 322 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 3:15 AM, 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 35°F			
	44	COUPLE V 322 THRU UNDERSURFACE DISTRIBUTOR INTO V-100 IN 90-110 MIN (use 9/16" Orifice)			
		RECORD: START 3:50 AM TOTAL MIN 90			
	45	WHEN S44 COMPLETE STIR 5 MIN			
		RECORD: DIAZO — (-); BASE + (+). pH 12.1 (11.4-11.8)	SAMPLE		
		Note: 1. IF pH IS 5.0-7.0, WEIGH & DUMP IN 30# "AS IS" 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 11.6 ASSUME 32%	60	28-D	19
ERE	46	ADJ TO pH 10.2-10.6 ASSUME 32%	34	28-D	11
		RECORD: pH 10.4 ASSUME 50%		7-D	
		Note: ADD N-28-D IN 5# "AS IS" INCREMENTS TO APPROACH pH 10.2-10.6 THEN USE LESS N-28-D			

Note Very important not to overshoot pH below 810.2, Masstone goes too light

DUP050292411

EQUIPMENT		PAGE 2 CG 36 CODE RT-695-D EST. WGT. 2781 LBS.	USE LBS.	N CODE	AC LB
107 9	82	DURING S+H, 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			
	88	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			
		LINE RECORD: START 9:00AM TOTAL MIN 110			
	40	WHEN STRIKE COMPLETE, HEAT TO 210-212°F			
	50	STIR 15 MIN AT 210-212°F			
	51	FLOOD TO 180-190" (18,246). RECORD: pH 7.4 (6.5-7.2) & STOP AGITATOR			
		SAMPLE			
		START 7:00 PM — FIN 11:00 PM — OPIR 237			
		11:00 PM — 7:00 AM — 409			
		7:00 AM — 11:15 AM — 101			
				4	

DUP050292412



DUP050292413

N 31832.01

MD-3-A

PACKAGE TICKET (DRY AND PASTE ONLY)

CODE RE695 LOT 32649

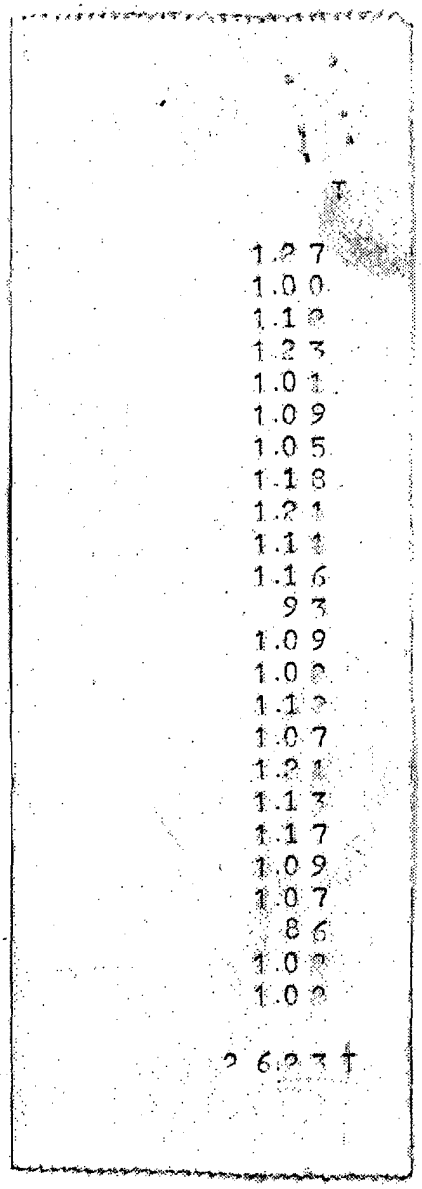
NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PO
	24	2623	60	
	STUMP	Lump	2405	

TOTAL NET WT. 2623 PKG. N-CODE

PROD. SPVR.	DATE	WHSE. OPER.
[illegible]	11-12-41	160

DUP050292414

N 31832.02



DUP050292415

N 31832.03

CG 36 CODE RT-695-D PKG.

→ NOV 14 32649

EST. WGT. 2781 LBS.

2 yrs

PROCESSING INSTRUCTIONS - BATCH UNIT

PROCESSES	APPROVED BY
TYPED BY	

MAKING NOTES

REMARKS

N+C. ok. 169

NAME: "BON" RED DARK

NON-BLEEDING

INSTRUCTIONS -PRESSING- RECORD

VAT			102		
DATE			11-15-79		
TIME			11:15 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 [illegible] TIME 11-15

SAMPLES

DELIVER TO

PRESSLOAD	1ST	2ND	3RD	4TH	5TH
STARTED	12				
CAKES USED	60				
WATER ON	[illegible]				
HRS. WASHED	[illegible]				
OHMS	4000				
HRS. WASHED					
OHMS					
HRS. WASHED					
OHMS					
CAKE CONDITION					
NO. CARS LOADED	7				

EXPLAIN LOSSES

SAMPLED BY RELEASED BY [illegible]

-DRYING-

XXXXXX XXX XXX

XXXXX XXX XX

DRY 12 HOURS AT 220 F

DRY 12 HOURS AT 180 F

Mn COLOR

CO_2 USAGE

OXYGEN 3-9-12 %

SAMPLES

DELIVER TO

LUMP: - OK - WET - SALTS - CONTAMINAT

No More color in Area

No Record of any Processing losses

ADDITIONAL DRYING HOURS REQUIRED

NO. DRUMS 17

NO. CARS PULLED LUMP WGT. 2205

SAMPLED BY RELEASED BY [illegible]

-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

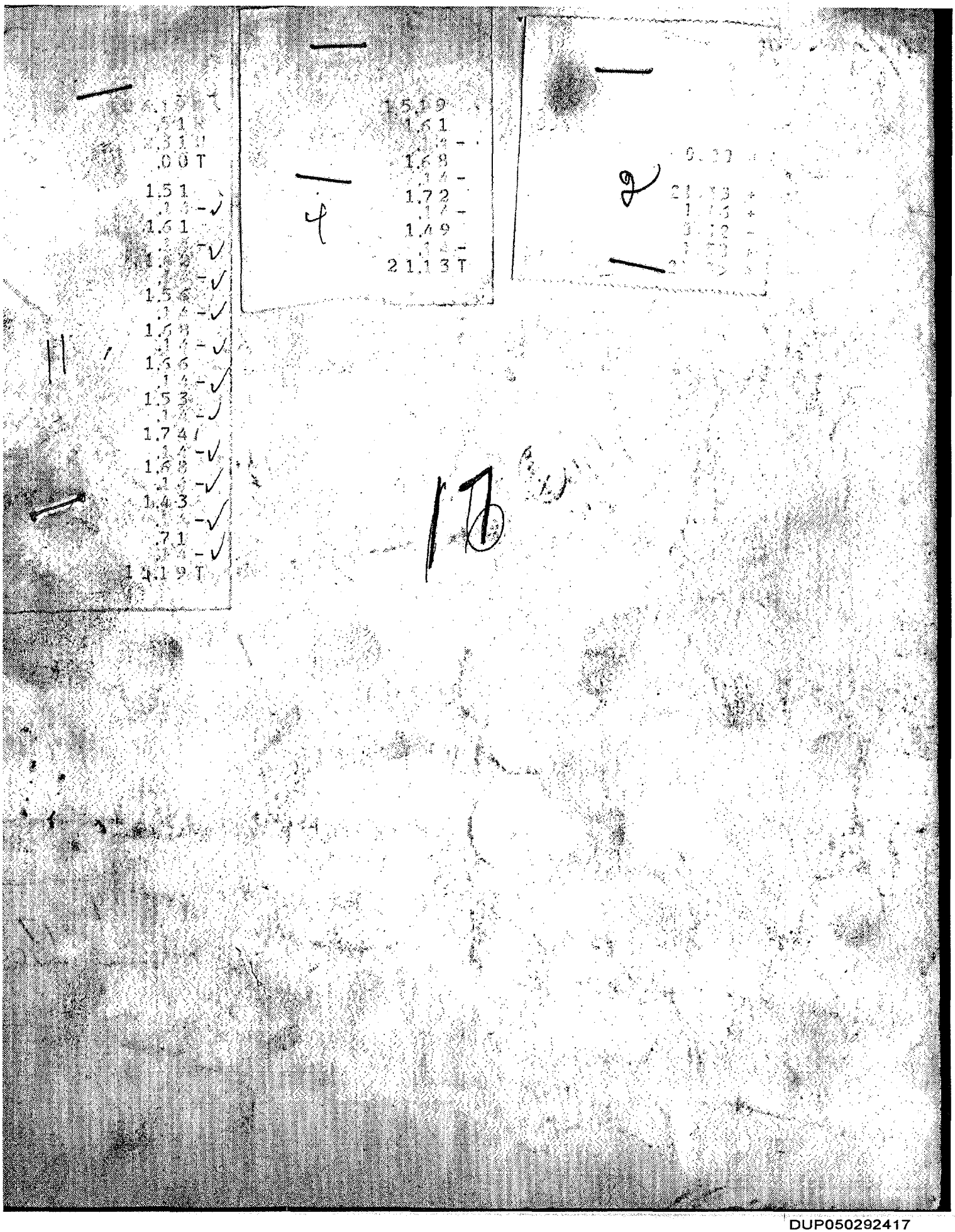
EXPLAIN LOSSES

DATE MIXED

SAMPLED BY 298 11-18-79 RELEASED BY

DUP050292416

N 31832.04



.19 T
.51 R
.31 U
.00 T
1.51
.14 - ✓
1.61
.14 - ✓
1.62
.14 - ✓
1.56
.14 - ✓
1.68
.14 - ✓
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.71
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14.19 T

11

15.19
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1.72
.14 -
1.49
.14 -
21.13 T

4

0.33
21.13 +
1.16 +
3.12 -
1.53 +
21.13 +

2

17

DUP050292417

N 31832.05