

MAR 01 1961
(DATE)

39536 EAST
(LOT NUMBER)

() YT-858-D ()
() ()
() ()

TYPED BY:

ESTIMATED WGT

2313 LBS.

STANDARD HRS.

TIME

R&D TO FOLLOW MODIFIED PROCESS

NOTE: BOIL OUT V-303 WITH N-28-D BEFORE USE IF FC-150N

EQUIP. OTHER VARS & CLARIF PRESS STD CLEANS
MENT NAME: DALAMAR YELLOW
CLEAN CLARIF PUMP? STIR MINER

PREP 1 OBTAIN FOR S20 WT 262 ONLY 4 262 ONLY
1 OBTAIN FOR S'S 6 & 37 LONZA IF AVAILABLE
3 CLEAN, DRESS, CLOSE 24" CLARIF PRESS -
15 FRAMES

303 4 RUN 24" (583G) WATER INTO V-303
2 5 POUR IN M 49.60 % 65
6 WEIGH & DUMP IN FROM S2

NOTE: BREAK UP LUMPS LOT #100% %
3060423 100

STIR 45 MIN TO DISSOLVE FOR S11 AT 55-60°F
DV 8 DURING S7, RUN IN 10" (323 G) WATER
3 INTO V-300

9 DUMP IN & STIR 5 MIN. 5 777-A 5
10 PUMP DV THRU CLARIF PRESS TO PRECOAT
303 11 WHEN S7 STIR COMPLETE WEIGH M 3 32.99 % 79
4 POUR IN & STIR 5 MIN. 725-A 24

12 ADJ TO 60-62 DEG F, RECORD TEMP 6Y DEG F
13 SIPHON IN IN 4-6 MIN. M 2 74.43 % 254
14 ADJ TO 49" (1175G) AT 66-70 DEG. F 57-A 57-A
15 STIR 5 MIN & RECORD: PH 4.1 (4.1-4.5)
16 IF NECESSARY, ADJ TO PH 4.1-4.5 ASSUME 77% 30-D
17 & RECORD: PH 4.1 ASSUME 50% 7-D

STIR 3 HRS MINIMUM FOR S43 MAINTAINING
66-70 DEGREES F 9 AM TOTAL MIN. 330
RECORD: START 57-A

DV 18 DURING S 17 STIR RUN 10" (323 G) WATER
5 INTO V-300

19 WEIGH IN FROM V-324 M 2 32.00 % 1431
20 DUMP IN FROM S1 LOT #100% % 28-D 458
157-C 974

262 124 71.6 173
262 120 69.6 173
262 104 68.0 173
262 136 77.4 173
262 126 72.2 173
262 108 60.3 173
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USE N-157C
WT 262 ONLY 262

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CG 46 CODE YT-858-D PKG
MAR -0-81- 39536

PROCESSES

APPROVED BY

(DATE)^c (LOT NUMBER)

() YT-858-D ()
() ()
() ()

TYPED BY:

ESTIMATED WGT

2313 LBS.

STANDARD HRS.

TIME _____ M

"MODIFIED PROCESS"

[illegible]

EQUIP MENT		PAGE 2 OF 3 CG 46 "CODE" YT-858-D	USE LBS	N-CODE	ACCT LBS
DV	21	STIR 10 MIN OR LONGER TO WET			
5	22	ADJ DV TO 37" (1280 G) AT 20-22 DEG. F	18X330	57-A	
CONT.	23	SIPHON IN IN 12-15 MIN M _____, _____ %		725-A	405
	24	STIR 30 MIN AT 28-32 DEG F MAINTAINING + CR, + KI FOR S 27		57-A	
		RECORD: TIME STRT _____, CR _____ (+), KI _____ (+)			
		NOTE:			
		(1) IF CR-, KI-, ADD 20# "AS IS" INCREMENTS		28-D	
		ASSUME 32% RECORD: CR _____ (+), KI _____ (+)			
		(2) IF CR+, KI-, ADD 20# "AS IS" INCREMENTS		725-A	
		ASSUME 33% RECORD: CR _____ (+), KI _____ (+)			
MISC	25	DURING S24 STIR WEIGH IN DRUMS FOR S31		7-D	444
6		M _____, _____ %			
	26	WEIGH IN BUGGY FOR S40 M _____, _____ %		30-D	689
DV	27	WHEN S 24 STIR COMPLETE, DUMP IN	15	113-A	15
7	28	DUMP IN	10	777-A	10
	29	STIR 30 MIN AT 28-32 DEG. F MAINTAINING +CR, +KI FOR S 34		57-A	
		NOTE:			
		(1) IF CR-, ADD 20# "AS IS" INCREMENTS		28-D	
		ASSUME 32% RECORD: CR _____ (+), KI _____ (+)			
		(2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS		725-A	
		ASSUME 33% RECORD: CR _____ (+), KI _____ (+)			
CV	30	DURING S29 STIR, RUN 10" (970G) WATER			
8		INTO V-_____ & INSTALL TEMP CHART			
	31	POUR IN N-7-D FROM S25			
	32	ADJ TO 30" (2928G) AT 66-70 DEG F	3X330	57-A	
	33	CLOSE STACK DAMPER			
DV	34	WHEN S29 STIR COMPLETE, TEST DV & RECORD:			
9		RECORD: CR _____ (+), KI _____ (+), TEMP _____ DEG F (28-32 DEG F)		57-A	
		NOTE:			
		(1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS		28-A	
		ASSUME 32% RECORD: CR _____ (+), KI _____ (+)			
		(2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS		725-A	
		ASSUME 33% RECORD: CR _____ (+), KI _____ (+)			
	35	PUMP DV THRU CLARIF PRESS INTO V-_____	2X330	57-A	
		MAINTAINING TEMP AT 28-32 DEG F, RECORD: TIME START _____ TOTAL MIN _____			
MISC	36	DISSOLVE IN 20 GAL WATER IN DRUM FOR S 53	67	979-D	67
10					
CV	37	DUMP IN FROM S2 LOT #100% %		46-C	1265
11		NOTE: BRK UP LUMPS _____			

	38	STIR 10 MIN TO DISSOLVE			
	39	OPEN STACK DAMPER			
	40	RUN IN N30D FRM S26 UNDR SURFACE IN 20-25MIN			
	41	STIR 5 MIN & RECORD: PH _____ (5.8-6.3)			
	42	IF NECESSARY, ADJ TO PH 5.8-6.3 ASSUME 50%		7-D	
		& RECORD: PH _____ ASSUME 77%		30-D	
	43	WHEN S17 STIR COMPLETE, RUN IN V-303 ON SURFACE AFAP			

GROUP MENT	PAGE 2 OF 3 CG 46 CODE NT-858-D	USE LBS	R CODE	RE LBS
DV 5	21 STIR 10 MIN OR LONGER TO WET			
CONT.	22 ADJ DV TO 37" (1280 G) AT 20-22 DEG. F	18X330	57-A	
	23 SIPHON IN IN 12-15 MIN M. <u>3</u> <u>32.99</u> %	<u>1228</u>	725-A	405
	24 STIR 30 MIN AT 28-32 DEG F MAINTAINING + CR, + KI FOR S 27		57-A	
	RECORD: TIME START <u>17:05</u> , CR <u>+</u> (+), KI <u>+</u> (+)			
	NOTE:			
	(1) IF CR-, KI-, ADD 20# "AS IS" INCREMENTS		28-D	
	ASSUME 32% RECORD: CR <u>+</u> (+), KI <u>+</u> (+)			
	(2) IF CR+, KI-, ADD 20# "AS IS" INCREMENTS		725-A	
	ASSUME 33% RECORD: CR <u>+</u> (+), KI <u>+</u> (+)			
MISC 6	25 DURING S24 STIR WEIGH IN DRUMS FOR S31	<u>895</u>	7-D	444
	M. <u>4</u> <u>49.60</u> %			
	26 WEIGH IN BUGGY FOR S40 M. <u>2</u> <u>74.43</u> %	<u>976</u>	30-D	689
DV 1132	27 WHEN S 24 STIR COMPLETE, DUMP IN	15	113-A	15
	28 DUMP IN	10	777-A	10
	29 STIR 30 MIN AT 28-32 DEG. F MAINTAINING +CR, +KI FOR S 34		57-A	
	NOTE:			
	(1) IF CR-, ADD 20# "AS IS" INCREMENTS		28-D	
	ASSUME 32% RECORD: CR <u>+</u> (+), KI <u>+</u> (+)			
	(2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS		725-A	
	ASSUME 33% RECORD: CR <u>+</u> (+), KI <u>+</u> (+)			
CV 8	30 DURING S29 STIR, RUN 10" (970G) WATER INTO V- <u>106</u> & INSTALL TEMP CHART			
	31 POUR IN N-7-D FROM S25			
	32 ADJ TO <u>20"</u> (1948 G) AT 66-70 DEG F	3X330	57-A	
	33 CLOSE STACK DAMPER			
DV 9	34 WHEN S29 STIR COMPLETE, TEST DV & RECORD:			
	RECORD: CR <u>+</u> (+), KI <u>+</u> (+),		57-A	
	TEMP <u>28</u> DEG F (28-32 DEG F)			
	NOTE:			
	(1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS.		28-A	
	ASSUME 32% RECORD: CR <u>+</u> (+), KI <u>+</u> (+)			
	(2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS		725-A	
	ASSUME 33% RECORD: CR <u>+</u> (+), KI <u>+</u> (+)			
	35 PUMP DV THRU CLARIF PRESS INTO V- <u>315</u>	2X330	57-A	<u>660</u>
	MAINTAINING TEMP AT 28-32 DEG F. RECORD:			
	TIME START <u>17:10</u> TOTAL MIN <u>115</u>			
MISC 10	36 DISSOLVE IN 20 GAL WATER IN DRUM FOR S 53	67	979-D	67
CV 11	37 DUMP IN FROM S2 LOT #100% <u>90404223</u> <u>1265</u> % <u>100</u>	<u>1265</u>	46-C	1265
	NOTE: BRK UP LUMPS			
	LONZA TYPE ONLY			
	IF AVAILABLE			
	38 STIR 10 MIN TO DISSOLVE			
	39 OPEN STACK DAMPER			
	40 RUN IN N30D FRM S26 UNDR SURFACE IN 20-25MIN			
	41 STIR 5 MIN & RECORD: PH <u>5.4</u> (5.8-6.3)			
	42 IF NECESSARY, ADJ TO PH 5.8-6.3 ASSUME 50%	<u>140</u>	7-D	<u>70</u>
	& RECORD: PH <u>5.8</u> ASSUME 77%		30-D	
	43 WHEN S17 STIR COMPLETE, RUN IN V- <u>30</u>			
	SURFACE AFAP RECORD: TIME START <u>17:20</u>			

EQUIP MENT	PAGE 3 OF 3 CG 46 CODE YT-858-D	USE LBS	N-CODE	ACC LBS
DV 12	44 WHEN S35 COMPLETE, WASH DV LINES, PUMP & PRESS FOR 20 MIN. OR TO A - CR TEST ON A SMPL OF TOTAL PRESS EFFLUENT, WHICH EVER COMES FIRST - COLLECT WASHINGS IN DV (S35)			
	45 STIR 5 MIN & RECD: TEMP (28-32 DEG F) & IF NECESSARY, ADJ TO 28-32 DEG F RECORD: DEG F,	2X	57-A	60
	46 WEIGH IN RUBBER BUCKET & WASH INTO DV	10	395-D	10
	47 STIR 5 MIN & RECORD: KI (-)	50	395-D	50
	48 IF NECESSARY ADJ TO -KI & RECORD: KI RECORD: VAT 49			
CV 13	49 WHEN S48 COMPLETE ADJ CV TO 38" (3708G) AT 80-84 DEG F & RECORD: HT 83 DEG F, RECORD: VAT 38 REC 84 DEG F			
	50 IMMEDIATELY RUN IN DV THRU UNDERSURFACE DISTRIBUTOR IN 60-65 MIN. MAINTAIN CV AT 80-84 DEG F, RECORD: TIME START 4 TOTAL MIN 6.1			
	Note: IMMEDIATELY AFTER COUPLING, BREAK TRANSFER LINE AT CV			
	51 WHEN S50 COMPLETE, STIR 10 MIN			
	52 RECORD: DIAZO, BASE (+) PH 4.25 (4.3-4.7)	32	N7	10
	NOTE: (1) IF DIAZO +, BASE -, & PH BELOW 4.3; (A) ADJ TO PH 4.3-4.7 ASSUME 50% (B) RECORD: PH (2) IF DIAZO +, BASE -, & PH 4.3 OR ABOVE; (A) ADD 8# 100% N-7-D TO A 55 G DRUM (B) ADJ WITH WATER TO #25 G (C) ADD 20# 100% N-46-C (D) STIR TO DISSOLVE (E) POUR INTO CV (F) STIR TO MIN. (3) REPEAT (1) & (2) ABOVE AS NECESSARY TO - DIAZO, + BASE		7-D	
	53 DUMP IN N-979-A FROM S 36			
	54 HEAT TO 200-204 DEG F IN 40-45 MIN			
	55 STIR 30MIN AT 200-204 DEG F RECORD: TIME 640 P 1/4			
	56 SHUT OFF STEAM			
	57 RECORD PH 4.2 (4.2-4.7) RECORD: VAT FIRE BOARD 216"			
	58 FLOOD TO 94" (9174G) & STOP AGITATOR			

START	FIN	OPTR
3 PM	7:25 P	120

EQUIP MENT		PAGE 3 OF 3 CG 46 CODE YT-858-D	USE LBS	N-CODE	ACCT LBS
DV 12	44	WHEN S35 COMPLETE, WASH DV LINES, PUMP & PRESS FOR 20 MIN. OR TO A - CR TEST ON A SMPL OF TOTAL PRESS EFFLUENT, WHICH EVER COMES FIRST - COLLECT WASHINGS IN DV (S35)			
	45	STIR 5 MIN & RECD: TEMP _____ (28-32 DEG F) & IF NECESSARY, ADJ TO 28-32 DEG F RECORD: _____ DEG F, _____ "		57-A	
	46	WEIGH IN RUBBER BUCKET & WASH INTO DV	10	395-D	10
	47	STIR 5 MIN & RECORD: KI _____ (-)			
	48	IF NECESSARY ADJ TO -KI & RECORD: KI _____		395-D	
CV 13	49	WHEN S48 COMPLETE, ADJ CV TO 38" (3708G) AT 80-84 DEG F & RECORD: HT _____ DEG F, REC _____ DEG F			
	50	IMMEDIATELY RUN IN DV THRU UNDERSURFACE DISTRIBUTOR IN 60-65 MIN. MAINTAIN CV AT 80-84 DEG F, RECORD: TIME START _____ TOTAL MIN _____			
CV 15	51	WHEN S50 COMPLETE, STIR 10 MIN			
	52	RECORD: DIAZO _____ (-) BASE _____ (+) PH _____ (4.3-4.7)			
		NOTE:			
		(1) IF DIAZO +, BASE -, & PH BELOW 4.3; (A) ADJ TO PH 4.3-4.7 ASSUME 50% (B) RECORD: PH _____		7-D	
		(2) IF DIAZO +, BASE -, & PH 4.3 OR ABOVE; (A) ADD 8# 100% N-7-D TO A 55 G DRUM (B) ADJ WITH WATER TO #25 G (C) ADD 20# 100% N-46-C (D) STIR TO DISSOLVE (E) POUR INTO CV (F) STIR TO MIN. (3) REPEAT (1) & (2) ABOVE AS NECESSARY TO - DIAZO, + BASE		7-D	
	53	DUMP IN N-979-A FROM S 36		46-C	
	54	HEAT TO 200-204 DEG F IN 40-45 MIN			
	55	STIR 30MIN AT 200-204DEG F RECORD: TIME _____			
	56	SHUT OFF STEAM			
	57	RECORD PH _____ (4.2-4.7)			
	58	FLOOD TO 94" (9174G) & STOP AGITATOR			
		START FIN OPTR			

