AUG 5 1980

MAKING INSTRUCTIONS: BATCH UNIT

V. 100 C.V. 207 D.V. 313, 322, 330

CG 36 CODE RT-695-D PKG.

→ AUG:-7·80 36772

EST. WGT. 1350 LBS.

STD. HRS. . TIME 11 PM

PROCESSES		APPROVED BY
( )	( )	
( )	( )	
( )	( )	
( )	( )	
TYPED BY		
PUNCHED & CHECKED		

AUG - 6 1980

NON-BLEEDING

EQUIPMENT		NAME: "BON" RED DARK	USE LBS.	N CODE	ACCT. LBS.
Prep 1	1	If necessary, clean, dress sparkler & pre-coat with 15#		777-A	
	2	Obtain for S 6		740-C	
	3	Obtain for 32B Lot 496 or 404, 383, 381		753 -C	
313 2	4	Run 25" (370G) water into V-313			
	5	Weigh & pour in M 7 48.04	204	7-D	98
	6	Turn on agitator & steam & dump in from S 2		740-C	502
		Lot 100% %			
		65 239 98.68	242		
		78 161 98.5	163		
		35 102 98.8	103		
	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 2:45 Total Min 15 Clarity cl			
	13	Run 1" (125G) water into V-207			
3 207	14	When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at			
		190-195°F. Record: Start 3:20 Total Min ___ Sample-From Hose			
		Show to supervisor for OK			
	15	Weigh on Postal Scale & Add ___ Lot ___		584-C	
322 4	16	Run in 2" (66G) water into V-322			
	17	Weigh in plastic lined Drums & Pour in & hold for S 28			
		M 7 31.62 %	639	28-D	202
313 5	18	When S14 complete, close V-313 outlet & stop pump			
	19	Run in 13" (192G) water & heat to 180-190°F			
		Circulate thru Syarkler until sol'n is clear.			
6 207	20	Pump V 313 thru Sparkler into V-207 (Sample)			
	21	When MTY-blow out Sparkler into V-207			
	22	RECORD: VOLUME 12"			
	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 S-23 is not acceptable			
		re-clarify thru sparkler.			
K 13829 REV.					

EQUIPMENT		PAGE 2 CG 36 CODE RT-695-D EST. WGT. 1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
207	~~25~~	~~Run 1# (68G) 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			
	~~29~~	Adj to 33" (2277G) at 32-38°F	27x330	57-A	8910
322	~~30~~	Run in 22" (755G) water into V-322			
	~~31~~	Weigh & Pour in M 7 ,25.04%	498	7-D	239
8	~~32~~	Dump in from S3 Lot 496,404,383,285 Lot 496	253	~~C~~ C	~~180~~ 419
	~~33~~	Weigh on postal scale & add Lot 9/2.37	15	180-C	~~15~~
	~~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
100	~~37~~	Run in 14" (1391G) water into V-100			
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 5.5 (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 9 ,33 1/2 %	501	725-A	166
10					
322	~~45~~	Adj V-322 to 30" (1031) at 70-80°F ✓ RECORD: TEMP 77°F	330x2		660
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			
12	~~48~~	Stir 30 min at 32-38°F maintaining + Cr, +KI	—	57-A	—
		Record: Time Start 5:30 PM CR + KI + TEMP 32 °F			
		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 As sume 33%		725-A	
		RECORD: CR (+), KI (+)			
	~~49~~	Couple V-322 thru under surface distributor into V-207 in			
		40-45 min Record: Start 9:30 PM Total min 45			
	~~50~~	When S 49 complete, stir 15 min			
		Record: DIAZO — (-); BASE + (+); pH 11.7 (11.0-11.8) TEMP 60°F			
		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%	92	28-D	31
	~~52~~	Adj to pH ~~9.5-10.0~~ 9.5-10.0 Assume 32%	—	28-D	—
		Record: pH 9.7 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			
		Use only diluted N7 or N28 for pH adjustments			

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EQUIPMENT		PAGE 3 CG 36 CODE RT-695-D EST. WGT. 1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
10	53	During S 49, heat to 210-212°F & shut off steam			
12		NOTE: If necessary, reheat V-100 to 210, 212°F			
		Prior to start of strike			
	54	Pump V-207 into V-100 in 60-65 min. Let V-100 temp drop to			
		200-205°F, then maintain at 200-205°F for balance of strike			
		Record: Start 11:45 Pm Total min 70			
	55	When strike complete heat to 210-212°F			
	56	Stir 15 min at 210-212°F			
	57	Flood to 87" (8648G). Record: pH 7.2 (6.5-7.2)			
	58	Stop agitator			

Start	Fin	Optr
12:45 P	200 P	126
3:00 PM	11:00 Pm	237
11:00 Pm	1:45 Pm	342

K 13930 REV.

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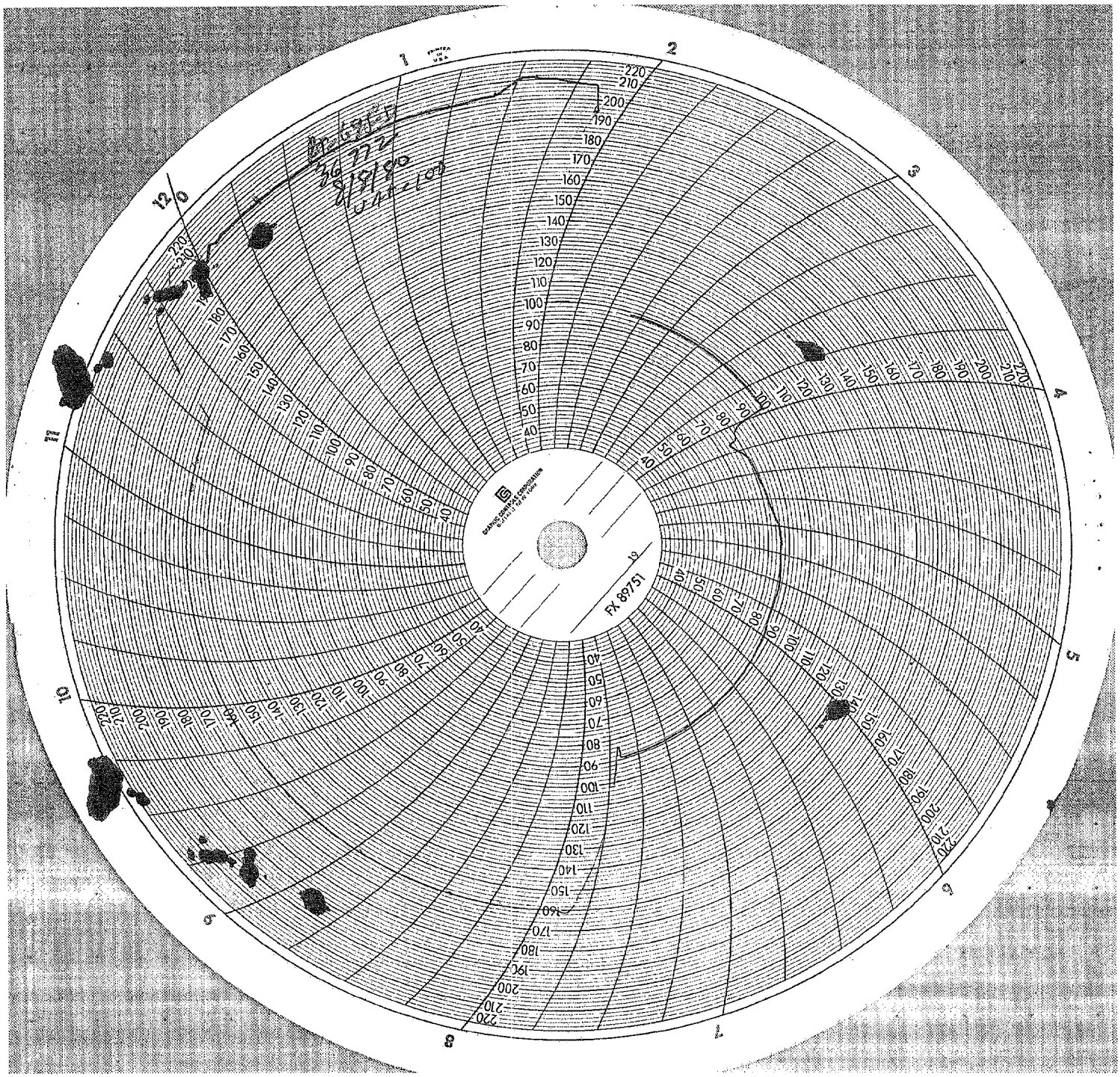

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