MAKING INSTRUCTIONS: BATCH UNIT

I.V. 107 (100) C.V. 207 PUMPED & CHECKED D.V. 313, 322, [redacted]

CG 36 CODE RT-695-D PKG. _____

→ NOV -5 80 37737

EST. WGT. 1350 LBS.

STD. HRS. _____ TIME [redacted] 11 Pm

9 JJ

NOV 7

PROCESSES		APPROVED BY
( )	( )	
( )	( )	
( )	( )	
( )	( )	
[redacted] TYPED BY		

① Only Clarify and wash N740c sol into V-207 + Stop ② Make up N253c with all ingredients and stop shut off agitators

J Gacze will follow rest of batch on 1st ship

NON-BLEEDING

QUIPMENT		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		253 ~~82~~-C	
		Boiled out V-322	25	721-D	25
313 2	4	Run 25" (370G) water into V-313			
	5	Weigh & pour in	98	72[illegible]-D	98
	6	Turn on agitator & steam & dump in from S 2		740-C	500
		Lot 100% %			
		109 222 98.67	225		
		108 278 99.45	280		
	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 30%~~		72[illegible]-D	
	11	Stir 30 min. at 212-214°F, then shut off steam WATCH FOAM	12A - Record: Sparkler		
	12	Circulate 15 min or longer thru Sparkler until sol'n is clear	Pressure 2 PSI		
		Maintain at 190-195°F for S14 Record: HT 194°F			
		& Recorder 195 °F	If not zero report		
		Record: Start 1:00 AM Total Min 15 Clarity 84	to Supervisor		
~~330~~ 3 207	13	Run 1" (125G) water into V-~~330~~ 207			
	14	When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at			
		190-195°F. Record: Start 1:15 AM Total Min 40 Sample-From Hose			
		Show to supervisor for OK			
	15	Weigh on Postal Scale & Add Lot 297	2	584-C	2
32~~3~~ 4	16	Run in 2" (66G) water into V-322			
	17	Weigh in plastic lined Drums & Pour in & hold for S 28			
		M 10 31.35%	644	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~~ 190-195F			
		Circulate thru Syarkler until sol'n is clear. PUMP V313 THRU SPARKLER INTO V-330			
	19A	RUN IN 5" (80G) WATER & HEAT TO 190-195F CIRCULATE THRU SPARKLER UNTIL CLEAR			
~~330~~ 6 207	20	Pump V 313 thru Sparkler into V-~~330~~ 207 (Sample)			
	21	When MTY-blow out Sparkler into V-~~330~~ 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 2-23 is not acceptable			
		re-clarify thru sparkler.			

K 13829 REV.

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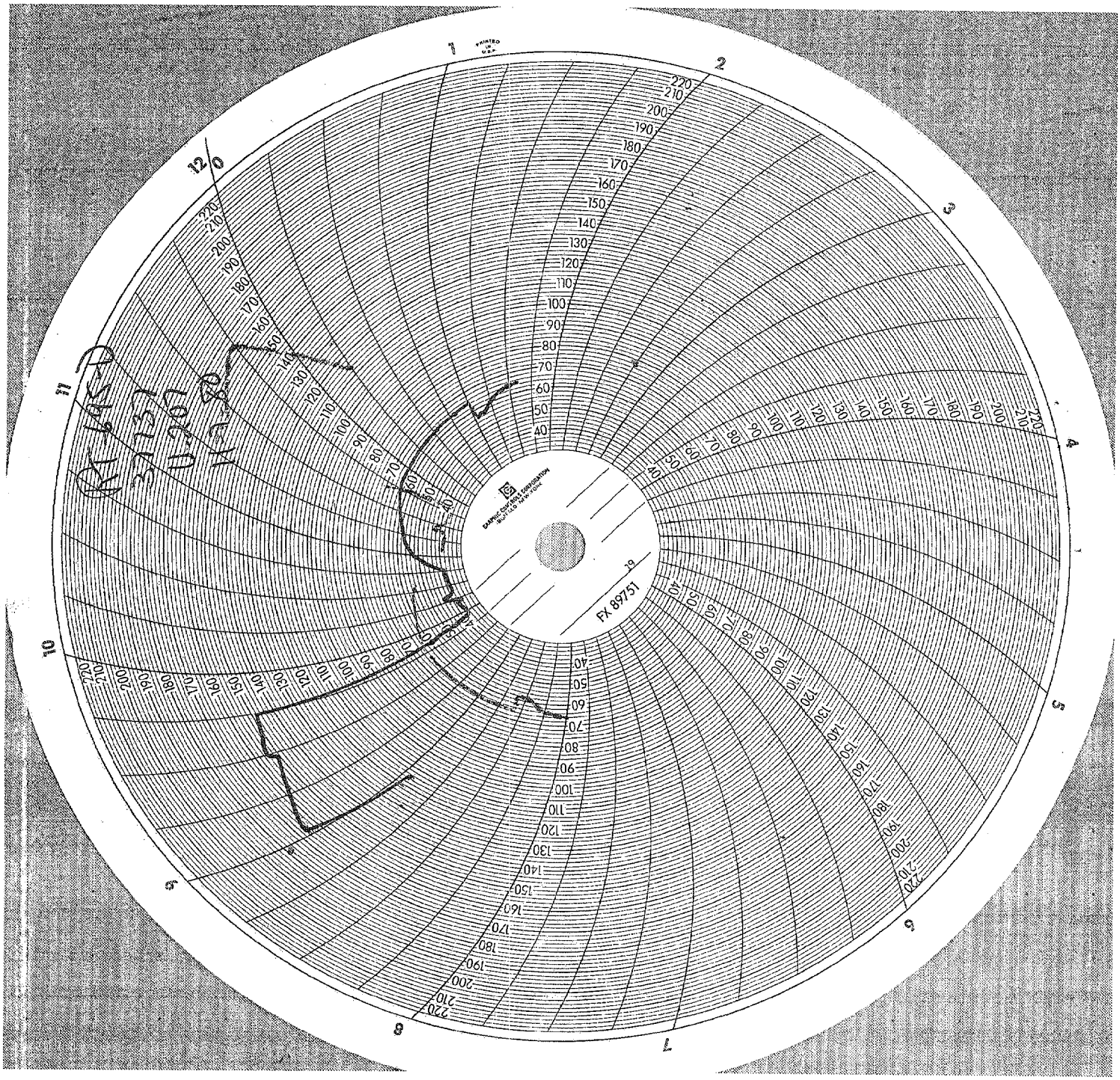
EQUIPMENT		PAGE 2 CG 36 CODE RT-695-D EST. WGT. 1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
207	25	~~Run 1" (68G) water into V-207~~			
7	26	~~If S-24 is OK, pump V-330 at 165-170°F into V-207~~			
	27	Heat V-207 to 165-170°F			
	28	Run in V-322, N-28-D, from S17 & rinse in			
	29	Adj to 33" (2277G) at 32-38°F (35°F)	20x330	57-A	6600
322	30	Run in 22" (755G) water into V-322			
8	31	Weigh & Pour in M , %	[illegible]	721-D	239
	32	Dump in from S3 Lot	N-253	[illegible]-C	[illegible]
		500	425		425
	33	Weigh on postal scale & add Lot 00316	9	180-C	9
	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 5.7 (5.0-5.5)			
	42	If pH above 5.5, adj to pH 5.5 or lower Assume 78%	1	27-D	1
		Record: pH 5.4			
		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 12 , 33.16 %	501	725-A	166
10					
323	45	Adj V-323 to 30" (1031) at 78-80°F & RECORD: TEMP 78 °F			
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 34-38°F maintaining + Cr, +KI	2x330	57-A	660
		Record: Time Start 10:05 A CR + KI + TEMP 37 °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 10:37 A Total min 60 MIN			
	50	When S 49 complete, stir 15 min			
		Record: DIAZO — (-); BASE + (+); pH 9.8 (11.0-11.8) TEMP 63 °F			
		NOTE: (1) If pH is 5.0-7.0, weigh & dump in 15# "as is" N-7-D AFAP		721-D	
		Assume 50% Record: pH			
	51	~~If necessary, adj to pH 11.4-11.8~~ Assume 50%		721-D	
		~~Record: pH~~ Assume 32%		28-D	
		IF pH IS ABOVE 11.2 ONLY			
	52	Adj to ~~pH 9.0-9.5~~ pH 10.8-11.2 Assume 32%		28-D	
		Record: pH Assume 50%		721-D	
		NOTE: Add N-7-D in 20# "as is" increments to approach pH 9.0-9.5 Then use less N-28-D			

EX 321

DUP050107198

EQUIPMENT		PAGE 3 CG 36 CODE RT-695-D EST. WGT. 1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
107	53	During S 49, heat to 210-212°F & shut off steam			
12		NOTE: If necessary, reheat V-107 to 210, 212°F			
		Prior to start of strike			
	54	Pump V-207 into V-107 in 60-65 min. Let V-107 temp drop to			
		200-205°F, then maintain at 200-205°F for balance of strike			
		Record: Start 12:05 P Total min 50			
	55	When strike complete heat to 210-212°F			
	56	Stir 15 min at 210-212°F			
	57	Proof to 87" (8648G). Record: pH 7.1 (6.5-7.2)			
	58	Stop agitator Sample - 2 gal			
		Start Fin Optr			
		11:00 AM 1:00 PM 320			
		1:00 PM 1:50 PM 351			

K 13830 REV.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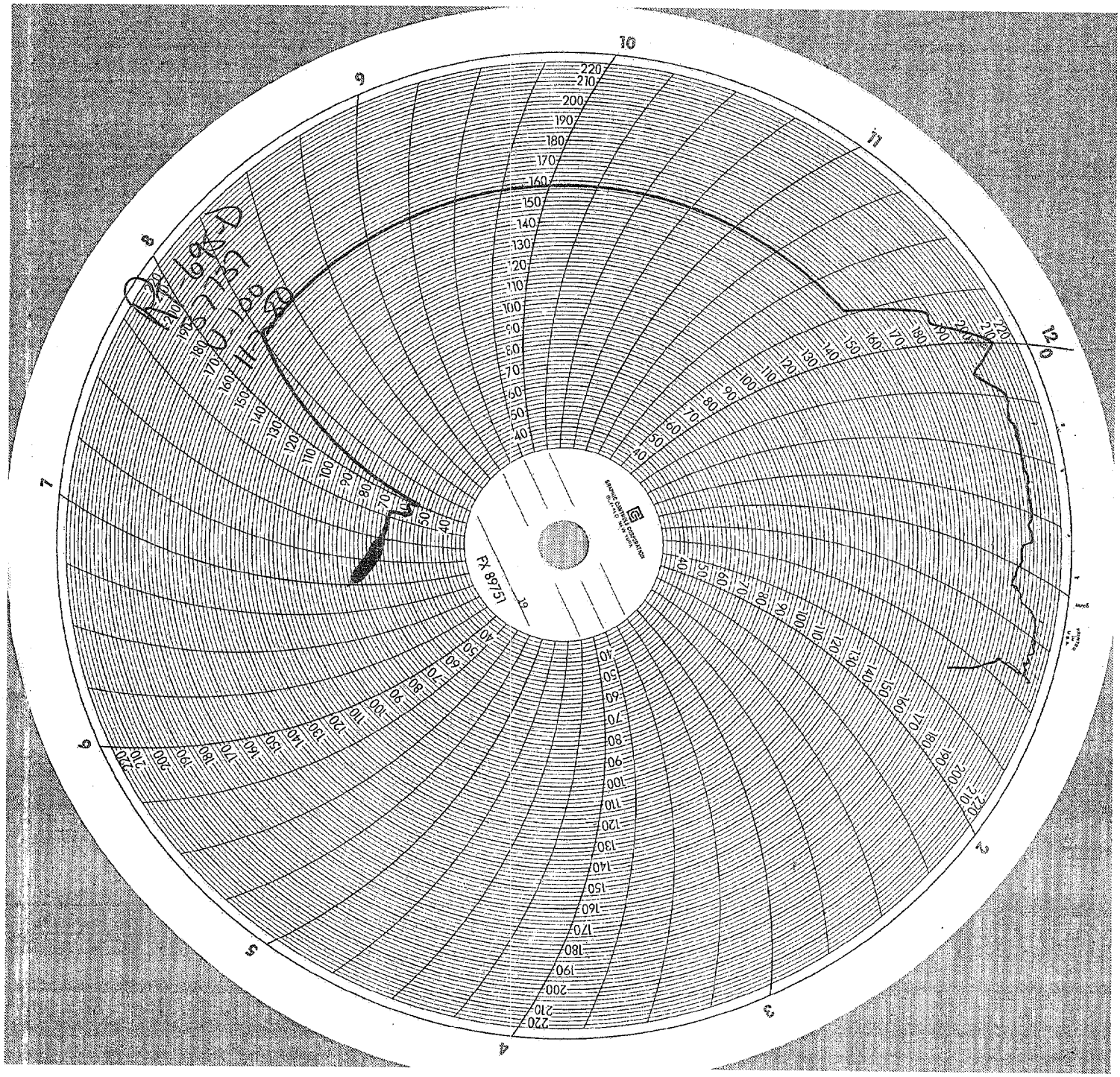

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