

DEC 15 80 88204

EST. WGT. 1714 LBS.

STD. HRS. TIME M

PROCESSES	APPROVED BY
(E) SF-88	() BBK 9-28-77
()	() DCG 10-3-77
()	() MTW 10-5-77
()	()
TYPED BY	
NSA 10-6-77	

V-322
 100 1-1-80
 B-1-1-80

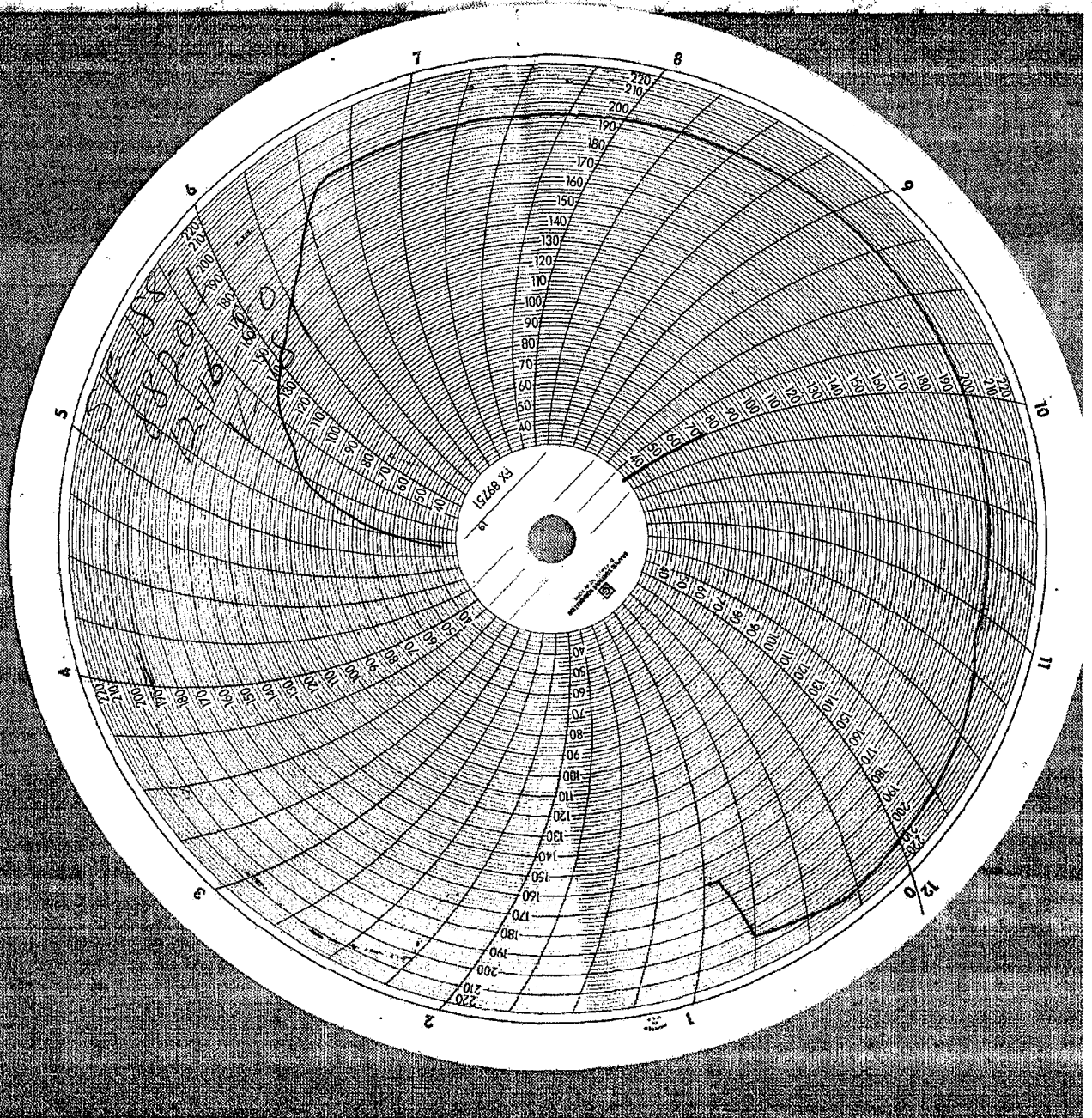
DEC 22 1980

NON-BLEEDING

EQUIPMENT	NAME: QAO	USE LBS.	N CODE	ACCT. LBS.
Prep 1	1 Check availability of N-57-A: Need ±60 blocks 9 Bldg. Need ±35 blocks 6 Bldg.			
	2 Check availability of N-7-D for S 26			
	3 Obtain 21 drums, weigh & record gross, tare & net wgt for S 16			
	Record: Lot	±2100	7557-A	
	GROSS WGT TARE NET WGT			
	1			
	2			
	3			
	4			
	5			
	6			
	7			
	8			
	9			
	10			
	11			
	12			
	13			
	14			
	15			
	16			
	17			
	18			
	19			
	20			
	21			
	TOTAL			
	Note: Enter total net wgt under "Acct Lbs"			
	4 Obtain 7 drums, weigh & record gross, tare & net wgt for S 7 & 22	±2600	120-D	
	GROSS WGT TARE NET WGT			
	1			
	2			
	3			
	4			
	5			
	6			
	7			
315/317 2	5 Run 10" (330 G) water into V-315/317			
	6 Add	2x330	57-A	
	7 Dump in 5 drums N-120-D from S 4	2000	120-D	2000
	Note: Remaining N-120-D will be added at S 22			
	Record tare wgt in S 4			

EQUIPMENT		PAGE 2 CG 88 CODE (E) SE-88	EST. WGT. 2255	LBS.	USE LBS.	N CODE	ACC LBS.
181	8	Rinse inside of V-181 top with high pressure water and drain					
3	9	Close outlet, install temp chart & put up safety chain					
	10	Start Rotocline					
	11	Set agitator at 20 RPM					
	12	Run in from V-386, Record vol. " M %				27-D	19160
	13	Start agitator					
	14	Add			46x330	57-D	
	15	Adj to 36" (3600 G) at 44°F or below				57-D	
		Note: Use ice only to adj - DO NOT ADD ANY WATER					
		Record: HT °F, Rec. °F, " Vol					
		Note: Volume must not exceed 36"					
		STOP AGITATOR - Take 1 qt samples					
181	16	Start agitator, Dump in N-7557 from S 3					
4	17	Weigh & record tare wgt & calc total net wgt N-7557-A in S 3					
	18	Rinse vat chute, sides, & agitator post with minimum water					
		Note: Use "Water Saver" nozzle					
	19	Stir 10 min Record: Temp °F, Vol " (36-38")					
Misc.	20	Calc for S 21					
5		# Net wgt N-7557-A (S 3) x 1.196 = # N-120					
	21	Calc for S 22					
		# N-120-D (S 20) + 2000 = # N-120-D					
315/317	22	Dump in & charge out N-120-D calculated in S 21				120-D	
6	23	Stir 15 min or longer to dissolve					
181	24	When S 19 and S 23 stir complete, immediately run in DV AFAP (30-60Min) Maintain V-181 temp below 120°F					
7		Note: Run in AFAP until temp reaches 110°F then if necessary, reduce addition rate to maintain 120°F					
		Record: Time Start Total Min					
		Max Temp					
	25	When DV MTY, rinse sides & wash in					
	26	Immediately heat to 190-194°F in 60-65 min. Watch foam					
		Record: HT °F, Rec. °F					
		Note: If foaming excessive, shut off agitator & steam, resume when foam stops					
	27	Stir 2-½ hours at 190-194°F. Record Start					
315/317	28	During S 27, stir, run 8" (265 G) water into V-315/317					
8	29	Add M %				7-D	8000
	30	Adj to 67" (2310 G) at 75-80°F & Record °F			31x330	57-A	
181	31	When S 27 complete, immediately run in DV (S-28) at a rate to minimize splashing (50-70 min)					
9	32	Flood to 160-170 F at ±80" (8000 G)					
	33	Stop agitator & take 1 quart sample					
		START FINISH OPTR					

EQUIPMENT		PAGE 2 CG 88 CODE (E) SF-88	EST. WGT. 1714	LBS.	USE LBS.	N CODE	ACC LBS.
181	8	Rinse inside of V-181 top with high pressure water and drain					
3	9	Close outlet, install temp chart & put up safety chain					
	10	Start Rotocione. CHECK DAMPER SETTING - OPEN WIDE					
	11	Set agitator at 20 RPM					
	12	Run in from V-386, Record vol 16 " M 28 .71.32%		20415	27-D	14.56	
	13	Start agitator					
	14	Add.		35x330	57-A	11.53	
	15	Adj to 27" (2700 G) at 44°F or below			57-A		
		Note: Use ice only to adi - DO NOT ADD ANY WATER					
		Record: HT 30 °F, Rec 30 °F 29 " Vol					
		Note: Volume must not exceed 28"					
		STOP AGITATOR					
		ONCE DUMP EVERY 2 MINUTES (MINIMUM TIME)					
181	16	Start agitator. Dump in N-7557 from S 3 GROUND EACH DRUM BEFORE DUMPING					
4	17	Weigh & record tare wgt & calc total net wgt N-7557-A in S 3					
	18	Rinse vat chute, sides, & agitator post with minimum water					
		Note: Use "Water Saver" nozzle					
	19	Stir 10 min Record: Temp 37 °F, Vol 24 " (27-29")					
Misc.	20	Calc for S 21					
5		1614 # Net wgt N-7557-A (S 3) x 1.196 = 1930 # N-120					
	21	Calc for S 22					
		1930 # N-120-D (S 20) - 1600 = 330 # N-120-D					
	22	Dump in & charge out N-120-D calculated in S 21		330	120-D	33	
	23	Stir 15 min or longer to dissolve					
181	24	When S 19 and S 23 stir complete, immediately run in DV AFAP					
7		(30-60 min) Maintain V-181 temp below 120°F					
		Note: Run in AFAP until temp reaches 110°F then if necessary, reduce addition rate to maintain 120°F					
		Record: Time Start 5:10:00 Total Min 30					
		Max Temp 115					
	25	When DV MTY, rinse sides & wash in USE MINIMUM WATER					
	26	Immediately heat to 190-194°F in 60-65 min. Watch foam					
		Record: HT 193 °F, Rec 191 °F					
		Note: (1) If foaming excessive, shut off agitator & steam,					
		TURN ON WATER SPRAYS FOR MIN AMOUNT OF TIME,					
		WHEN FOAM STOPS, TURN OFF WATER SPRAYS, TURN					
		ON AGITATOR & RESUME HEATING					
		(2) REPEAT NOTE 1 AS REQUIRED (SPRAYS ON					
		FOR MINIMUM TIME)					
	27	Stir 2-1/2 hours at 190-194°F. Record Start 6:40 P.M.					
		322					
	28	During S 27, stir, run 2" (51 G) water into V-386 ONLY					
	29	Add M. 14 49.19 % 12360		7-D	608		
	30	Adj to 59" (3026 G) at 75-80°F & Record 75 °F 50 " 23x330		57-A	759		
181	31	When S 27 complete, immediately run in DV (S-28) at a rate to					
9		minimize splashing (50-70 min)					
	32	Cool to 160-170°F WITH ICE		15x330	57-A		
	33	Stop agitator					
	34	HOSE OFF AGITATOR COUPLING					
	35	RECORD VAT FREEBOARD: 11 "					
		START FINISH OPTR					
		3/11 11/11 120					
		11:00 AM 7:00 P.M. 37					
		7:00 AM 12:50 PM 101					



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