

→ SEP--8-80 37047
EST. WGT. 1350 LBS.

STD. HRS. TIME

315	322	330
PROCESSES		APPROVED BY
()	()	
()	()	
()	()	
()	()	
TYPED BY		

Do NOT USE N-740-C lots 53, 66 n/100

Take 1 qt sample each N-740-C, N-253-C w. Indicate lot in report

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
Prep 1	"BON" RED DARK			
	1 If necessary, clean, dress sparkler & pre-coat with 15#		777-A	
	2 Obtain for S 6		740-C	
	3 Obtain for 32B		253-C	
313 2	4 Run 25" (370G) water into V-313			
	5 Weigh & pour in		7-D	98
	6 Turn on agitator & steam & dump in from S 2	4794	740-C	502
	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 of			
	Record: Start 845 Total Min 15 Clarity OK			
330 3	13 Run 1" (125G) water into V-330			
	14 When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at 190-195°F. Record: Start 914M Total Min 20 Sample-From Hose			
	Show to supervisor for OK			
	15 Weigh on Pot Still			
207 4	16 Run in 2" (66G) water into V-313	207		
	17 Weigh in plastic lined Drums & Pour in & hold for S 28	M 7 3162	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 Sparkler until sol'n is clear.			
207 6	20 Pump V 313 thru Sparkler into V-313 (Sample)	207		
	21 When MTV-blow out Sparkler into V-313	207		
	22 RECORD: VOLUME 13 "			
	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.			

EQUIPMENT		PAGE 2 CG 36 CODE RT-695-D	EST. WGT.	1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
207	7	25 Run in 22" (696G) water into V-207					
		26 Heat V-207 to 165-170°F & RECORD: VAT 15 "role sample"					
		27 Run in V-322, N-28-D, from S17 & rinse in					
		28 Adj to 33" (2277G) at 32-38°F		27x330	57-A	8910	
322	8	30 Run in 22" (755G) water into V-322					
		31 Weigh & Pour in M 8 .4794		499	7-D	239	
		32 Dump in from S3 Lot 497		425	253-C	495	
		33 Weigh on postal scale & add Lot 90804		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	9	37 Run in 14" (1391G) water into V-100					
		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 5.2 (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	10	44 Weigh and pour into V-302 for S 47 M 10 .3271		507	725-A	166	
322	11	45 Adj V-322 to 30" (1031) at 70-80°F & RECORD: TEMP 80°F					
		46 Slurry with 30 Gal water in drum, pour in & stir 5 min		73	39-A	73	
207	12	47 Run in N-725-A from S44 AFAP into V-207					
		48 Stir 30 min at 32-38°F maintaining + Cr, +KI			57-A		
		Record: Time Start 12:30/CR + KI + 10P 32 OF					
		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 Assume 33%			725-A		
		RECORD: CR (+), KI (+)					
		49 Couple V-322 thru under surface distributor into V-207 in					
		40-45 min Record: Start 1:20/A Total min 44					
		50 When S 49 complete, stir 15 min					
		Record: DIAZO - (-); BASE + (+); pH 12.1 (11.8-11.8) TEMP 62.9					
		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 11.8			7-D		
		Record: pH			28-D		
		52 Adj to pH 8.2-8.6		50	N-370	39	
		Record: pH 8.4		45	28-D	14	
		NOTE: Add N-7-D in 20# "as is" increments to approach pH 8.2		8	7-D	4	
		8.6 Then use less N-28-D					

EQUIPMENT	PAGE 3	CG 36 CODE RT-695-D	EST. WGT.	1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
100	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 5:05/A, Total min 75					
	55	When strike complete heat to 210-212°F					
	56	Stir 15 min at 210-212°F					
	57	Flood to 87" (8648G). Record: pH 6.1 (6.5-7.2)					
	58	Stop agitator					
		Start	Fin	Optr			
		7:00 AM	6:30 A.M.	2:24			

K13830 REV.

DUP050107321



