F.V. 107 C.V. 100 D.V. 330, 322, 207, 317

CG 36 CODE RT-695-D PKG ___

MAY -0-81- Σ 1174
(DATE) (LOT NUMBER)

PROCESSES
( )RT-695-D (N)
(M)ALTERNATE ( )
( ) ( )
TYPED BY: JLC

APPROVED BY
JJG 3/18/81

ESTIMATED WGT 2781 LBS. STANDARD HRS. _____ TIME _____M

PREPARATION NOTES: Start only on 3rd shift - J Gacze will follow - Will have R & D Lab Coverage on 1st shift - Clarify Red 2B only on 3rd shift & hold

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 Sample 1gt		740-C	
	3	OBTAIN FOR S 42 Sample 1gt		253-C	
317 2	4	RUN 23" (748G) WATER INTO V-317			
	5	WEIGH & POUR IN M-8 49.83	431	7-D	215
	6	TURN ON AGITATOR & STEAM & DUMP IN FROM S 2		740-C	1096
(Use only 1 Lot N740C)		LOT 199 100% 1105 % 99.2	1105		
	7	WEIGH ON POSTAL SCALE & ADD LOT 297	8	584-C	8
	8	DUMP IN	50	113-B	50
	9	DUMP IN	10	777-A	10
	10	HEAT TO 214-216 DEG. F WATCH FOAM			
	11	RECORD: BY + (+), IF NECESSARY ADJUST TO + BY ASSUME 50%		7-D	
	12	STIR 30 MIN. AT 212-214 DEG. F, THEN SHUT OFF STEAM WATCH FOAM NOTE RECORD: SPARKLER PRESSURE 0 PSI IF NOT ZERO, NOTIFY SUPERVISOR			
	13	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR MAINTAIN AT 190-195 DEG. F FOR S 15 RECORD: HT 194 DEG.F & RECORDER 195 DEG.F RECORD: START 4:25AM TOTAL MIN 15 CLARITY ok			
100 3	14	RUN #1 (99G) WATER INTO V-100			
	15	WHEN S-13 COMPLETE, PUMP V 317 THRU SPARKLER. MAINTAIN V-317 AT 190-195 DEG.F RECORD: START 4:40AM TOTAL MIN 20 SAMPLE FROM HOSE. SHOW TO SUPV'R FOR OK			
317 4	16	WHEN S 13 COMPLETE, CLOSE V-317 OUTLET & STOP PUMP			
	17	RUN IN 12" (215G) WATER & HEAT TO 190-195 DEG F			

EQUIPMENT		PAGE 02 OF 04 CG 36 CODE RT-695-D (N)	USE LBS	N-CODE	ACCT LBS
317 CONT'D 4	18	CIRCULATE THRU SPARKLER UNTIL SOLUTION IS CLEAR MAINTAIN AT 190-195 DEG. F FOR S 19 & RECORD: HT 194 DEG. F & RECORDER 195 RECORD: START 5:20 TOTAL MIN 10 CLARITY Sh			
100 5	19	WHEN S 18 IS COMPLETE, PUMP V-317 THRU SPARKLER INTO V-100			
	20	RUN IN 5" (90G) WATER & HEAT TO 190-195 DEG. F			
	21	CIRCULATE 15 MIN THRU SPARKLER, PUMP V-317 THRU SPARKLER INTO V-100			
	22	WHEN MT, BLOW OUT SPARKLER INTO V-100			
	23	HEAT TO 165-170 DEG. F (TAKE 1 QT. SAMPLE) (WITH AGITATION ON) TEST FOR CLARITY OF SOLUTION. SHOW 1 QT. SAMPLE TO SHIFT SUPERVISOR FOR APPROVAL (EXAMPLE OF ACCEPTABLE CLARIFICATION OF N-740-C IS AVAILABLE IN OFFICE TO COMPARE WITH)			
	24	IF S 23 IS OK, CONTINUE WITH S 25. IF S 23 IS NOT ACCEPTABLE, RECLARIFY THRU SPARKLER			
	25	IF S 23 IS OK, REHEAT V-100 TO 165-170 DEG. F FOR S 26			
Complete up to this point on 3rd shift - then stop & hold batch					
10[illegible] 6	26	ADJ TO 16" (1590G)			
	27	HEAT V-100 TO 165-170 DEG. F			
	28	RUN IN V-324 THRU DIRECT M 2 , 32.00% LINE AND RINSE IN	[illegible]	28-D	443
	29	STIR 15 MIN AT 165-170 DEG. F			
	30	ADJ TO 50" (4970G) AT 34-38 DEG. F RECORD: TEMP 34 DEG. F AND IF NECESSARY ADJ TO 34-38 DEG. F &	40 ~~50~~X330	57-A	13200
		RECORD: TEMP 34 DEG. F HT-34° Rec-36°		57-A	
107 7 1st sample of N336	31	RUN 45" (4320G) WATER INTO V-107			
	32	TURN ON AGITATOR AND STEAM AND DUMP IN	1400	336-B	1400
	33	DUMP IN	250	65-A	250
	34	HEAT TO 150-160 DEG. F AND STIR			
	35	RECORD: PH 6.8 (5.0-5.5)			
	36	IF PH ABOVE 5.5, ADJ TO PH 5.5 OR LOWER ASSUME 78%	4	27-D	3
	37	RECORD: PH 4.8			
	38	NOTE: IF PH BELOW 5.0, DO NOT ADJ UPWARD			
	39	HOLD FOR S 58			
207 8	40	RUN IN 23" (1610G) WATER INTO V-207			
	41	WEIGH AND POUR IN M 8 , 49.83%	[illegible]	7-D	470
	42	DUMP IN FROM S 3 LOT 552 536	900 34	253-C	934
	43	WEIGH ON POSTAL BALANCE AND ADD LOT	20	180-C	20

EQUIPMENT		PAGE 03 OF 04 CG 36 CODE RT-695-D (N)	USE LBS	N-CODE	ACCT LBS
~~307~~ 8	44	HEAT TO 70-90 DEG. F			
	45	SIFT IN IN ONE TO TWO MINUTES	27	567-B	27
	46	DUMP IN & STIR 5 MIN OR LONGER TO DISSOLVE	8	479-D	8
313/ ~~307~~ 9	47	WEIGH & POUR INTO V-312 FOR S 50 M 7, 32.93%	1109	725-A	365
~~307~~ 10	48	ADJ V-~~322~~ TO 32° (2240G) AT 77-80 DEG. F (307) & RECORD: TEMP 77 DEG. F			
	49	SLURRY WITH 30 GALS WATER IN DRUM. POUR IN AND STIR 5 MIN.	160	39-A	160
100 11	50	RUN IN N-725-A FROM S 47 AFAP INTO V-100			
	51	STIR 30 MIN AT 36-38 DEG. F MAINTAINING +CR, +KI	2310	57-A	2310
	52	RECORD: TIME START 11:10A, CR + KI + TEMP 36 DEG. F			
		NOTE:			
		(1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS ASSUME 32%		28-A	
		RECORD: CR_____(+), KI_____(+)			
		(2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS ASSUME 32%		725-A	
		RECORD: CR_____(+), KI_____(+) TEMP_____DEG. F			
	53	COUPLE V-~~322~~ 307 THRU UNDERSURFACE DISTRIBUTOR INTO V-100 IN 90-110 MIN (USE 9/16"ORIFICE)			
		RECORD: START 11:50A TOTAL MIN 110			
	54	WHEN S 53 COMPLETE STIR 15 MIN			
	55	RECORD: DIAZO - (-), BASE + (+)			
		PH 8.9 (7.0-8.0) TEMP 61 DEG. F (60-65 F)	SAMPLE		
		NOTE:			
		(1) IF PH IS 5.0-7.0, WEIGH AND DUMP IN 30# "AS IS" N-7-D DILUTED TO 30 GAL AFAP ASSUME 50%		7-D	
		(2) (FOR PH ADJUSTMENTS USE ONLY DILUTED N-28-D AND N-7-D)			
	56	ADJ TO PH 9.0-9.5 (SEE ATTACHED PH ADJ AID	(1×3 gal Sample)		
		AND SHUT OFF AGITATOR ASSUME 32%		28-D	
	57	RECORD: PH 9.2 ASSUME 50%	20	7-D	10
		NOTE: ADD N-28-D IN 5# "AS IS" INCREMENTS TO APPROACH PH 9.0-9.5 THEN USE LESS N-28-D			
		(CONCENTRATED N-28-D & N-7-D AND TOO LOW COUPLING TEMPERATURE CAUSES MASSTONE TO GO TOO LIGHT)			
	58	SHUT OFF AGITATOR			

RT-695-D - V-107

MAKING INSTRUCTIONS: BATCH UNIT

EQUIPMENT		PAGE 04 OF 04 CG 36 CODE RT-695-D (N)	USE LBS	N-CODE	ACCT LBS
107	59	DURING S 53 HEAT V-107 TO 210-212 DEG. F & SHUT OFF STEAM			
		NOTE: IF NECESSARY REHEAT V-107 TO 210-212 DEG. F PRIOR TO START OF STRIKE			
	60	PUMP V-100 INTO V-107 IN 70-75 MIN. LET V-107 TEMP DROP TO 200-205 DEG. F DURING STRIKE THEN MAINTAIN AT 200-205 DEG. F FOR BALANCE OF STRIKE WITH AGITATOR SHUT OFF IN V-100			
		RECORD: START 3:40 P TOTAL MIN 105			
	61	WHEN STRIKE COMPLETE, HEAT TO 210-212 DEG.F			
	62	STIR 15 MIN AT 210-212 DEG. F			
	63	FLOOD TO 180-190° (18240G) → TAKE TWO 5-gal samples (agitator on)			
		RECORD: PH 7.1 (6.5-7.2) AND STOP AGITATOR SAMPLE - 1 gal			

Note Samples

START	FINISH	OPERATOR
8:00 AM	7:00 PM	320
7:00 A.M	3:00 P.M	381
3:00 P	6:00 P	254

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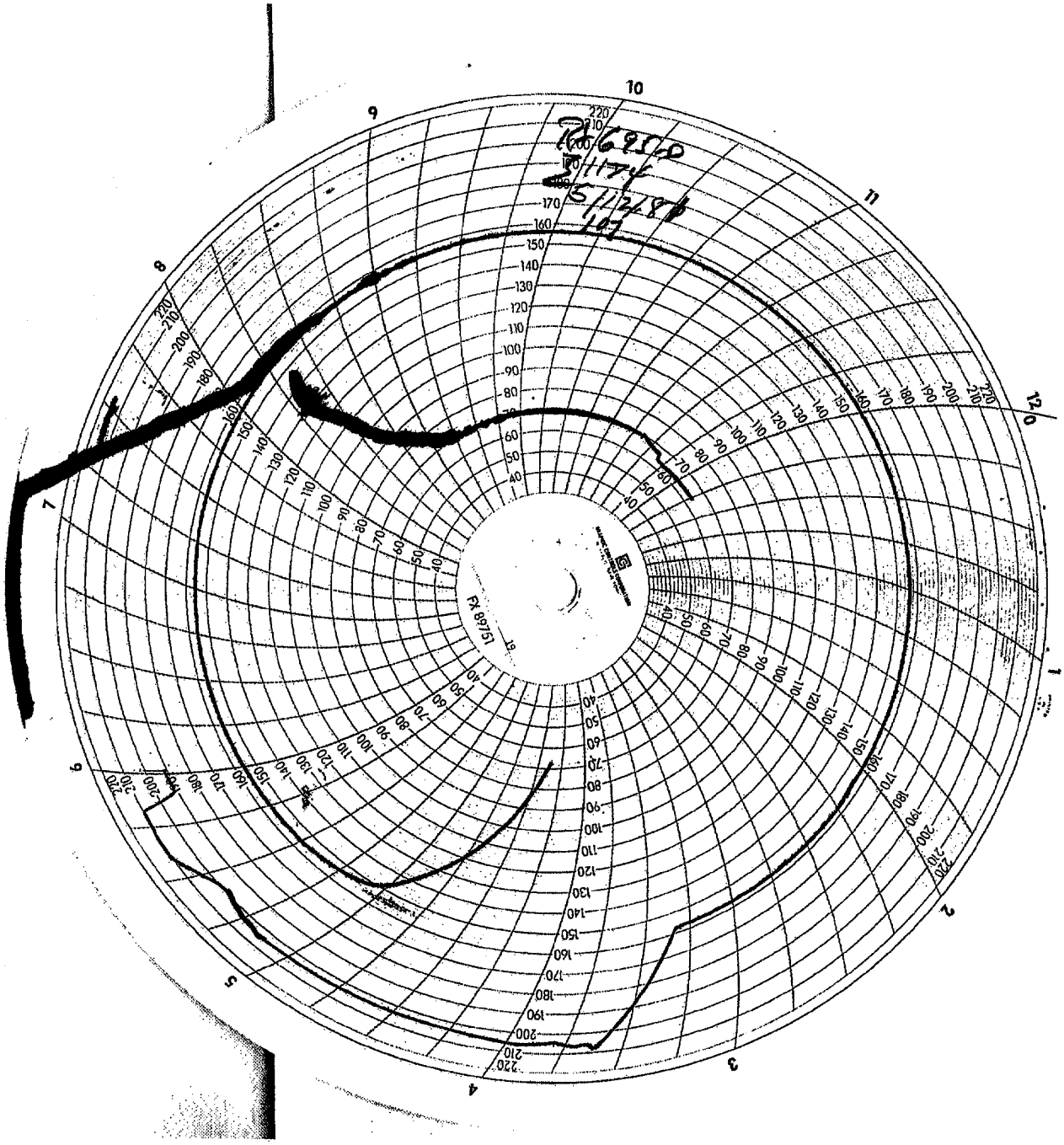
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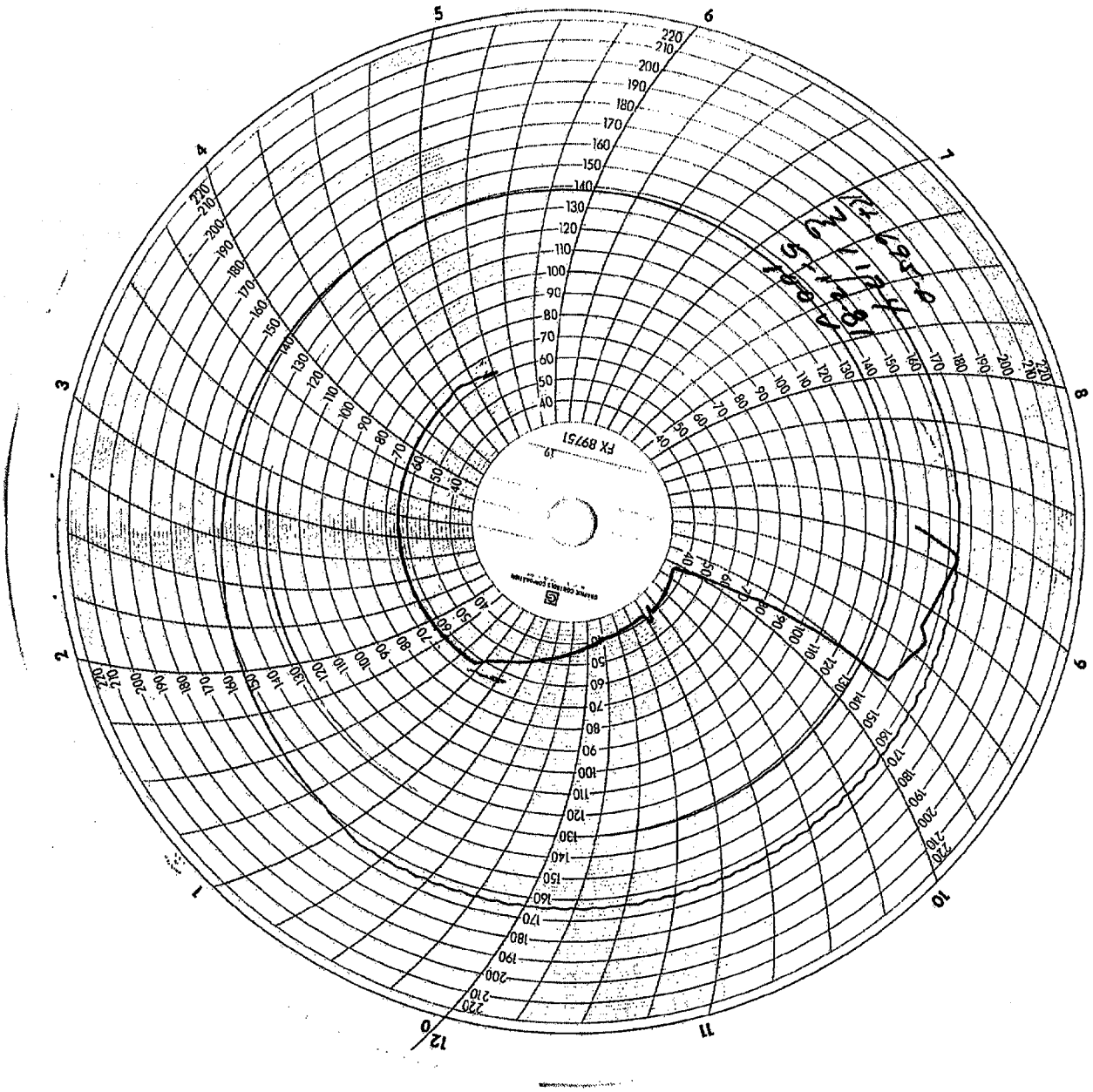
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