MAKING INSTRUCTIONS: BATCH UNIT

S.V. 107 C.V. 207 D.V. 313, 322, 330

CG 36 CODE RT-695-D PKG. _____

→ SEP-9-80 37064

EST. WGT. 1350 LBS.

STD. HRS. _____ TIME 11PM

PROCESSES		APPROVED BY
( )	( )	
( )	( )	
( )	( )	
( )	( )	
TYPED BY		

- Do NOT USE N-740-C lots 100 or 101
- Take 1 pt sample each N-740-C & N-253C lot used
  Record lot on request

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		253C	
313 2	4	Run 25" (370G) water into V-313			
	5	Weigh & pour in 47.94	204	7-D	98
	6	Turn on agitator & steam & dump in from S 2		740-C	[illegible]
Do NOT		USE Lot 100% %	610		502
		76 502 98.5			
LOTS		100 or 101			
	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 15 min Total Min 15 Clarity OK Clear			
[illegible] 3 207	13	Run 1" (125G) water into V-[illegible] 207			
	14	When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at			
		190-195°F. Record: Start 15 Total Min 10 Sample-From Hose			
		Show to supervisor for OK			
	[illegible]	Weigh on Postal Scale & Add [illegible]	[illegible]	[illegible]	[illegible]
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.			
[illegible] 6 207	20	Pump V 313 thru Sparkler into V-[illegible] 207 (Sample)			
	21	When MTY-blow out Sparkler into V-[illegible] 207			
	22	RECORD: VOLUME 11"			
	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.

EQUIPMENT		PAGE 2 CG 36 CODE RT-695-D EST. WGT. 1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
207	25	~~[illegible]" (69G) water in[illegible]~~			
7	26	~~If S-24 is OK, pump V-330 at 165-170°F into [illegible]~~			
200 Blocks in	27	Heat V-207 to 165-170°F RECORD: 14" "VAT STAKE-1 qt sample			
	28	Run in V-322, N-28-D, from S17 & rinse in			
	29	Adj to 33" (2277G) at 32-38°F	27x330	57-A	89 10
322	30	Run in 22" (755G) water into V-322			
8	31	Weigh & Pour in M 8 .479%	499	7-D	239
	32	Dump in from S3 Lot		253-C	~~[illegible]~~ 425
		498			
		497	378		
	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	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%		27-D	
		Record: pH 4.0			
		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 10 .32.71 %	507	725-A	166
10					
322	45	Adj V-322 to 30" (1031) at 70-80°F & RECORD: TEMP 80 °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 32-38°F maintaining + Cr, +KI		57-A	
		Record: Time Start 8.05 AM CR + KI +			
		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 8.39 AM Total min 41			
	50	When S 49 complete, stir 15 min			
		Record: DIAZO — (-); BASE + (+); pH 12.1 (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	~~[illegible]~~ Assume 50%		7-D	
		Record: pH Assume 32%		28-D	
	52	Adj to pH ~~[illegible]~~ 8.4-8.8 Assume 32%	126	28-D	40
		Record: pH 8.6 Assume 50%		7-D	
		NOTE: Add N-7-D in 20# "as is" increments to approach pH 8.4-8.8 Then use less N-28-D			
		USE ONLY DILUTE N-7-D OR N-28-D FOR ADJUSTMENT			

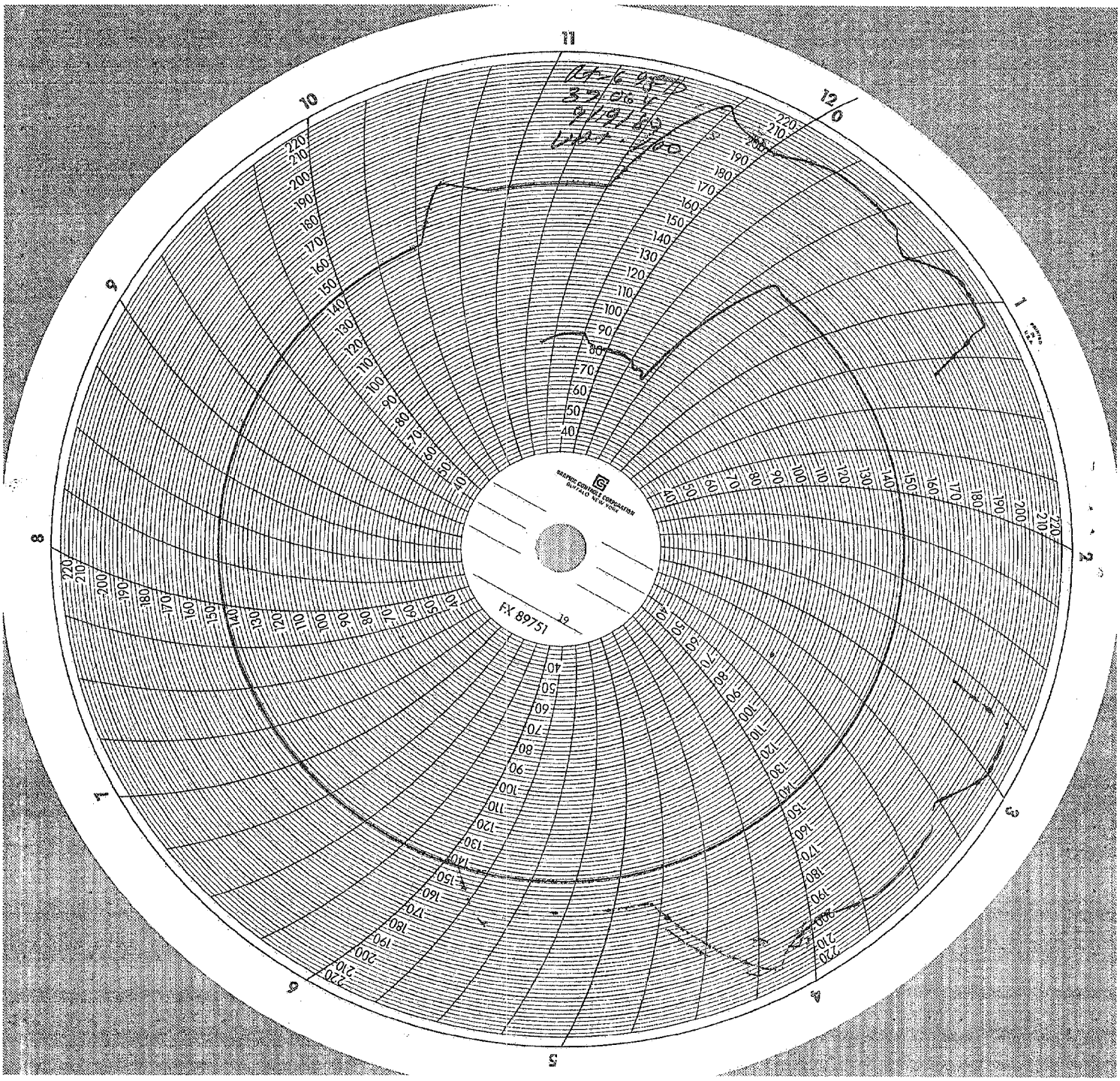
DUP050107370

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-10 to 210, 212°F			
		Prior to start of strike			
	54	Pump V-207 into V-10 in 60-65 min. Let V-10 temp drop to			
		200-205°F, then maintain at 200-205°F for balance of strike			
		Record: Start 12.05 PM Total min 58			
	55	When strike complete heat to 210-212°F			
	56	Stir 15 min at 210-212°F			
	57	Flood to 87" (8648G). Record: pH 7.0 (6.5-7.2)			
	58	Stop agitator			

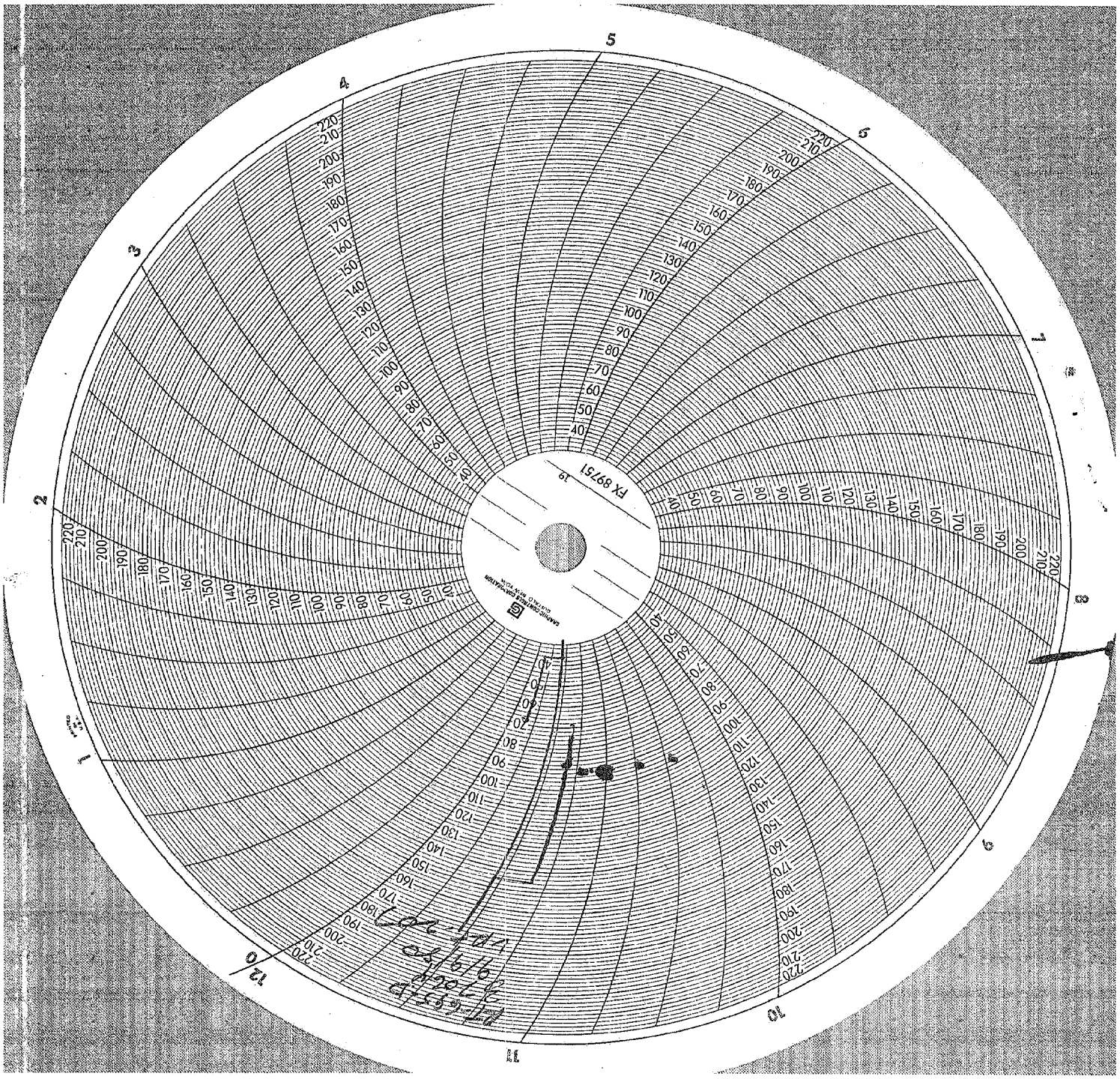
Start	Fin	Optr
11.00 P	7.00 P	126
7.00 AM	1.45 PM	144
5 Rout	meeting	45 min.

K 13830 REV.

DUP050107371



DUP050107372



DUP050107373