AUG 21 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 100 C.V. 207 D.V. 313, 322, 330

CG 36 CODE RT-695-D PKG. _____

→ AUG-26-80 36905

EST. WGT. 1350 LBS.

STD. HRS. _____ TIME 7AM

| PROCESSES | | APPROVED BY |
|---|---|---|
| ( ) | ( ) | |
| ( ) | ( ) | |
| ( ) | ( ) | |
| ( ) | ( ) | |
| TYPED BY | | |

[illegible] ED

~~PRECOAT SPARKLER~~ Done

SEP - [illegible] 1980

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 [illegible]-C | |
| 313 2 | 4 | Run 25" (370G) water into V-313 | | | |
| | 5 | Weigh & pour in 48.04 | [illegible] | 7-D | 98 |
| | 6 | Turn on agitator & steam & dump in from S 2 | | 740-C | [illegible] 502 |
| | | Lot 100% % | | | |
| | | 71 319 98.27 | 325 | | |
| | | 54 183 98.53 | 186 | | |
| | 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 190°F | | | |
| | | & Recorder 195°F | | | |
| | | Record: Start 7:00 AM Total Min 15 Clarity [illegible] | | | |
| [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 7:15 P Total Min 180 Sample-From Hose | | | |
| | | Show to supervisor for OK | | | |
| | 15 | Weigh on Postal Scale & Add Lot | ~~[illegible]~~ | ~~504-C~~ | ~~[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 % | [illegible] | 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 | Run 1" (69G) 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 | 31 X 330 | | 10,230 |
| | 29 | Adj to 33" (2277G) at 32-38°F | 27 ~~330~~ | 57-A | |
| 322 | 30 | Run in 22" (755G) water into V-322 | | | |
| 8 | 31 | Weigh & Pour in M 7 .48.04% | | 7-D | 239 |
| | 32 | Dump in from S3 Lot | | 253 ~~22~~-C | ~~[illegible]~~ |
| | | 496 | 422 | | 422 |
| | 33 | Weigh on postal scale & add Lot 90 804 | 12 | 180-C | 12 |
| | 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 5.5 (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 | 44 | Weigh and pour into V-302 for S 47 M 9 .33.12% | 501 | 725-A | 166 |
| 10 | | | | | |
| 322 | 45 | Adj V-322 to 30" (1031) at 70-80°F & RECORD: TEMP 82°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 3.3 + A CR + KI + TEMP 30 °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 4.05A Total min | | | |
| | 50 | When S 49 complete, stir 15 min | | | |
| | | Record: DIAZO — (-); BASE VST (+); pH 12.0 (11.0-11.8) TEMP °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 | ~~If necessary, adj to pH 11.4-11.8~~ Assume 50% | | 7-D | |
| | | Record: pH Assume 32% | 730 | 28-D | 41 |
| | 52 | Adj to pH ~~[illegible]~~ 8.2-8.6 Assume 32% | | 28-D | |
| | | Record: pH 8.4 Assume 50% | | 7-D | |
| | | NOTE: Add N-7-D in 20# "as is" increments to approach pH 9.0-9.5 Then use less N-28-D | | | |

Use only diluted N7 & N28 for pH adjustments

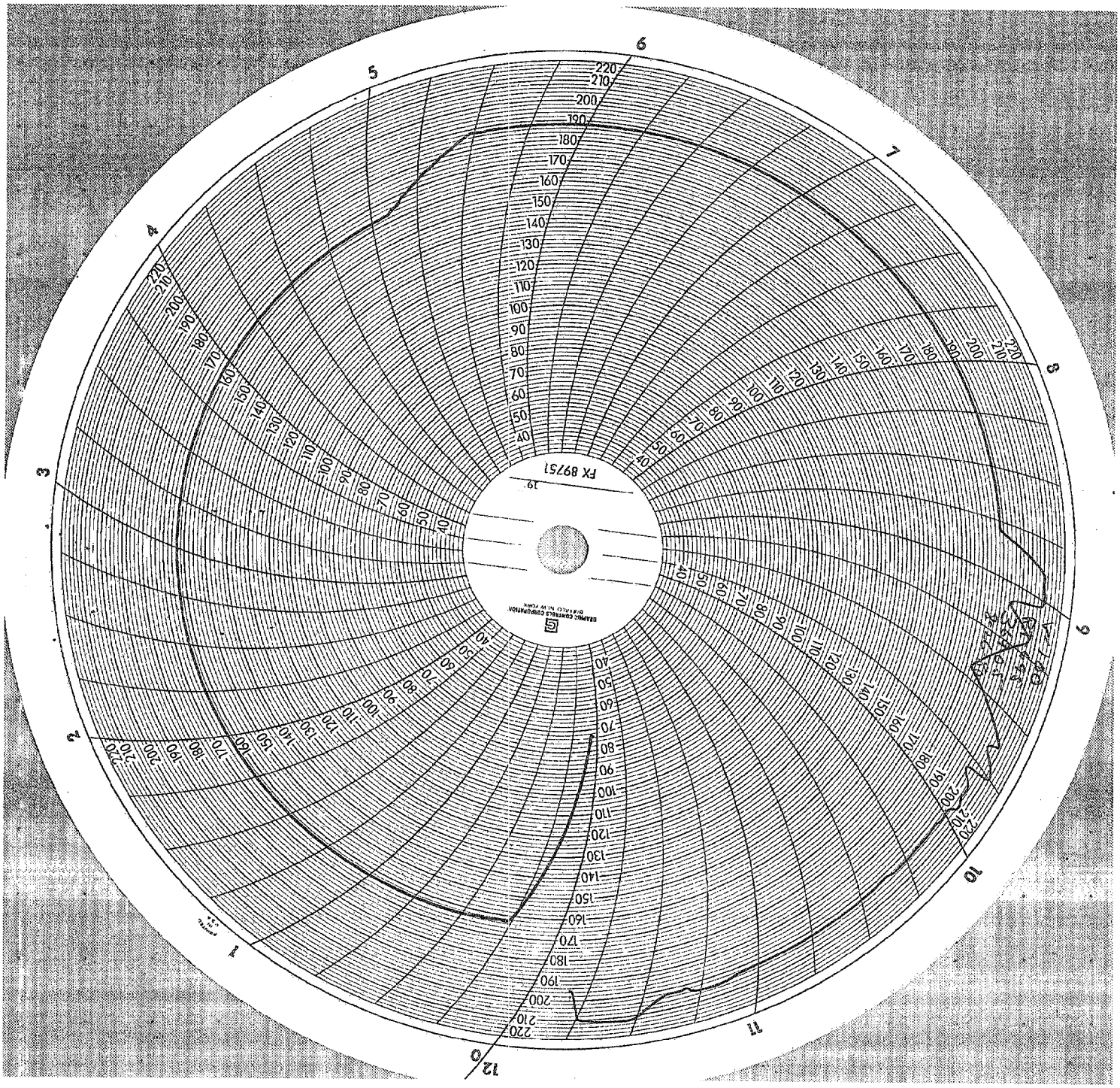
DUP050107031

| EQUIPMENT | | PAGE 3 CG 36 CODE RT-695-D EST. WGT. 1350 LBS. | USE LBS. | N CODE | ACCT. LBS. |
|---|---|---|---|---|---|
| V-100 - 12 | 53 | During S 49, heat to 210-212°F & shut off steam | | | |
| | | 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 6:50 A Total min 8.0 | | | |
| | 55 | When strike complete heat to 210-212°F | | | |
| | 56 | Stir 15 min at 210-212°F | | | |
| | 57 | Flood to 87" (8648G). Record: pH 6.8 (6.5-7.2) | | | |
| | 58 | Stop agitator | | | |

| Start | Fin | Optr |
|---|---|---|
| 3:00 PM | 11:00 PM | 287 |
| 11:00 PM | 7:20 | 392 |
| 7:A.M. | 9:AM. | 54 |

DELAYED Waiting For Coe

K 13830 REV.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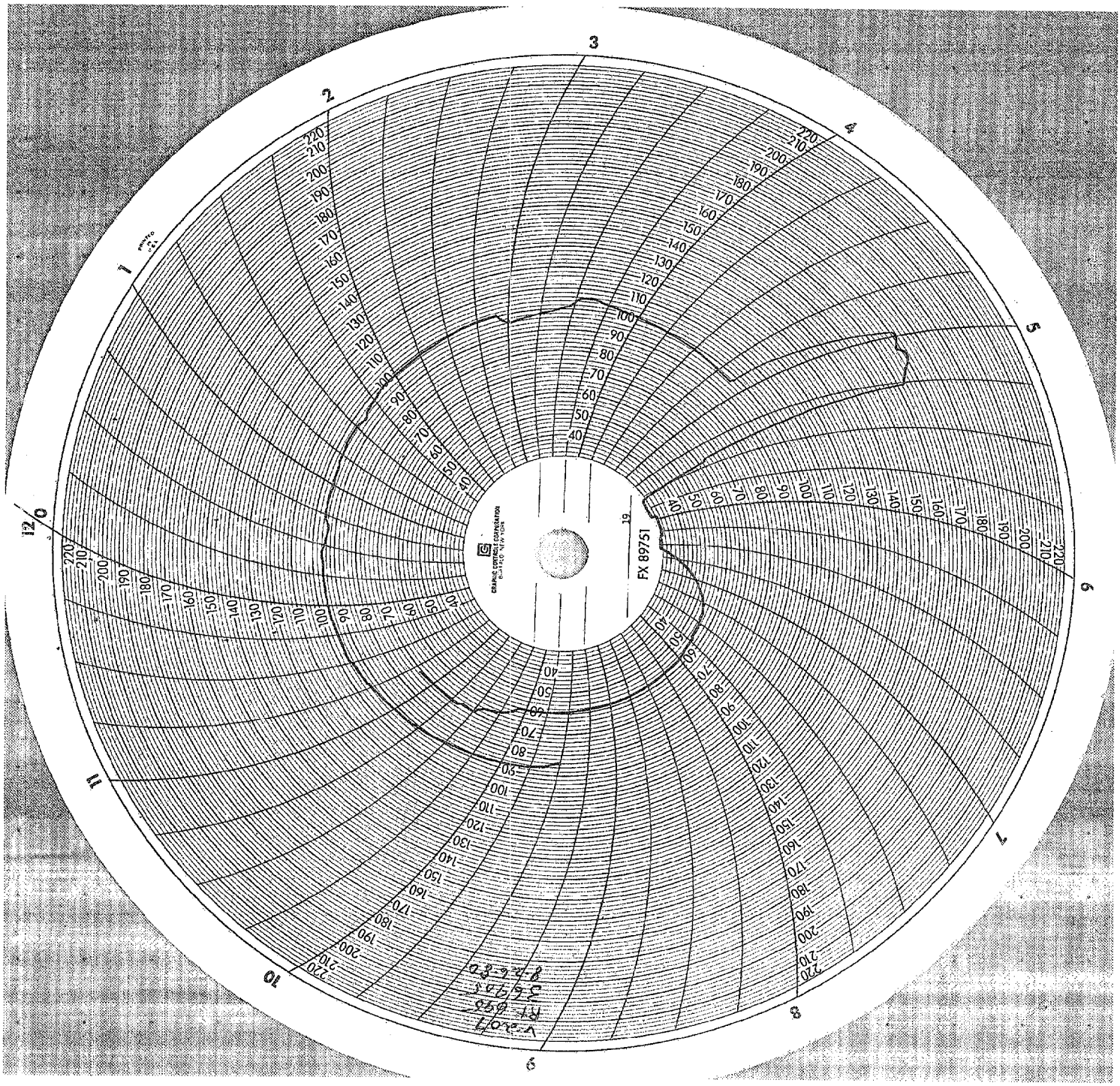


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