

CG 36 CODE RT-695-D PKG. 35069
 EST. WGT. 2781 LBS.
 STD. HRS. TIME 8A

PROCESSES	APPROVED BY
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TYPED BY	

PUNCHED & CHECKED

R & D will follow MAR 27 1960

NON-BLEEDING

EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	"BON" RED DARK			
Prep 1	1 If necessary, clean, dress Sparkler & pre-coat with 15#		777-A	
	2 Obtain for S 6		740-C	
	3 Obtain for S 26		82-C	
330 2	4 Run 38" (748G) water into V-330			
	5 Weigh & pour in M 3 .48.04%	44.8	7-D	215
	6 Turn on agitator & steam & dump in from S 2		740-C	1104
	Lot 100%			
	36 321 98.62			
	998 635 97.7	650		
	7 Weigh on postal scale & add	150	584-C	
	8 Dump in 774 148 98.63	50	113-B	50
	9 Dump in	10	777-A	10
	10 Heat to 214-216°F WATCH FOAM			
	11 Record: BY T (+), if necessary adj to +BY Assume 50%		7-D	
	12 Stir 30 min at 214-216°F, then shut off steam WATCH FOAM			
	13 Circulate 15 min or longer thru Sparkler until sol'n is clear			
	Maintain at 190-195°F for S 15 & Record: HT 195°F			
	and Recorder			
	Record: Start 9:15 Total Min 15 Clarity clear			
207 3	14 Run 1" (99G) water into V-207			
	15 When S 13 complete, pump in V-330 thru Sparkler. Maintain V-330 at 190-195°F. Record: Start 9:35 Total Min 80			
330 4	16 When S 13 complete, close V-330 outlet & stop pump			
	17 Run in 22" (431G) water & heat to 180-190°F			
	18 Circulate thru Sparkler until sol'n is clear			
	Maintain at 180-190°F for S 19 & Record: HT 180°F 190			
	& Recorder			
	Record: Start 11:45 Total Min 40 Clarity clear			
207 5	19 When S-18 is complete pump V-330 thru Sparkler into V-207			
	20 When MT, blow out Sparkler into V-207			
	21 Heat to 165-170°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 to)			
	22 IF S-21 is OK, continue with S-23. If S-21 is not acceptable reclarify thru Sparkler			
	23 If S-21 is OK, re-heat V-207 to 165-170°F for S-25			
	Boil out 4206 V260			
			7-D 300	
			152-G 75	

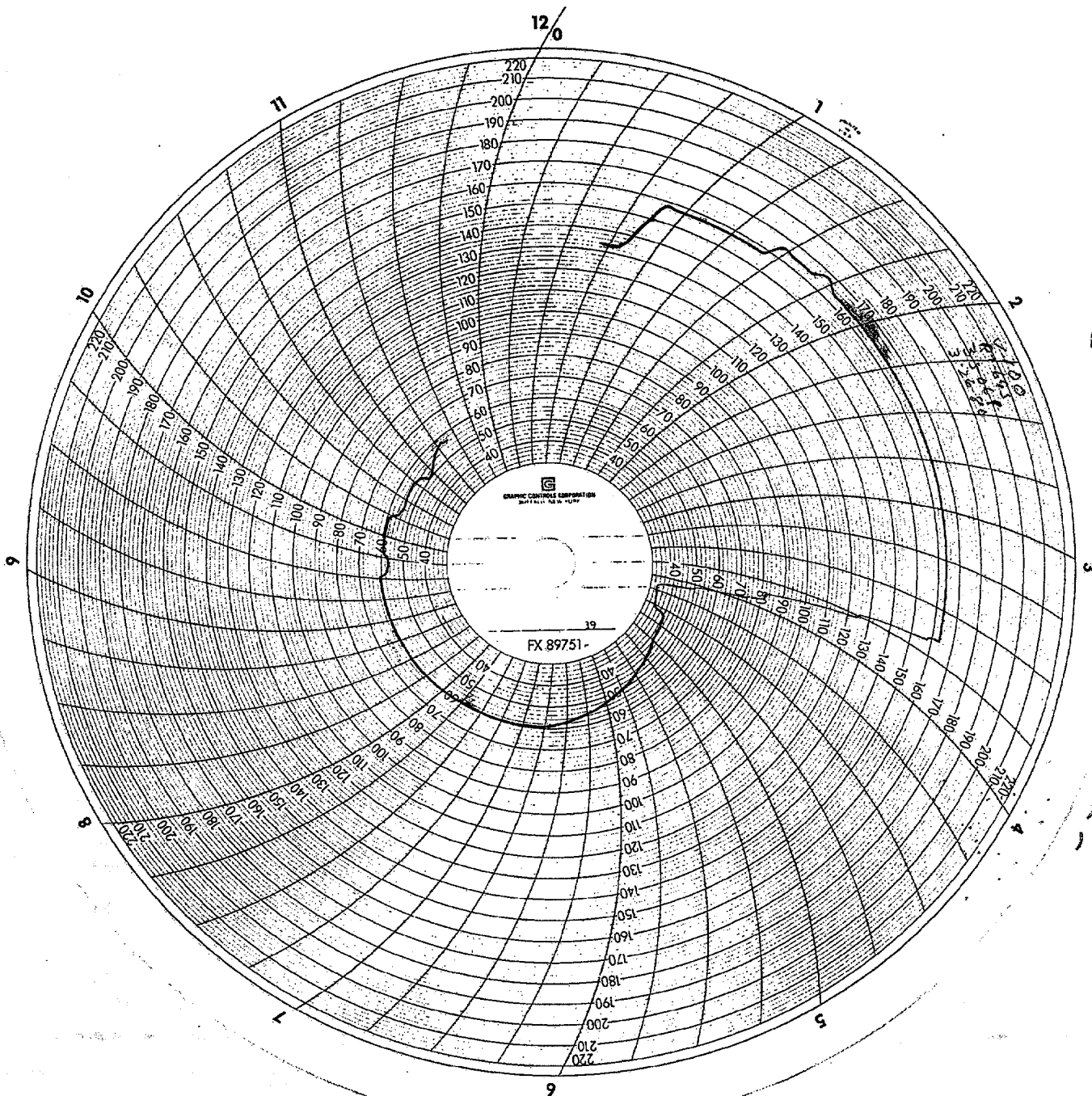
EQUIPMENT	PAGE 2 CG 36 CODE RT-695-D	EST. WGT. 2781	LBS.	USE LBS.	N CODE	ACE1 LBS.
100	Run 1" (99G) water into V-100					
6	When S-23 is complete, pump in V-207					
	Adj to 16" (1590G)					
	Heat to 165-170°F					
	Run in from V-324 thru direct M 4, 31.05%		1428		28-D	443
	line and rinse in.					
	Stir 15 min at 165-170°F					
	Adj to 50" (4970G) at 34-38°F Record: Temp 33 °F	77	X 330		57-A	2540
	(Vol. 24" from top of V100)					
107	Run 45" (2400G) water into V-107 & DUMP IN		100		165-A	100
7	Turn on agitator & steam & dump in		1400		336-B	1400
	Dump in		250		65-A	250
	Heat to 150-160°F & stir					
	Record: pH 6.5 (5.0-5.5)					
	If pH above 5.5, adj to pH 5.5 or lower Assume 78%		2		27-D	1
	Record: pH 5.3					
	NOTE: If pH below 5.0, do not adj upward					
	Hold for S 58 RECORD: VOLUME 47.0					
322	Run in 47" (1610G) water into V-322					
8	Weigh and pour in M 3, 48.04%		978		7-D	470
	Dump in from S 3 Lot 39.56		920		82-C	970
	Weigh on postal balance and add Lot 90807		26		180-C	26
	Heat to 70-90°F					
	Sift in in one to two min.		27		567-B	27
	Dump in & stir 5 min or longer to dissolve		8		479-D	8
313/302	Weigh & pour into V-330 for S 50 M 3, 33.46%		1091		725-A	365
9						
322	Adj V-322 to 65" (2240G) at 77-80°F & record: Temp 70 °F					
10	Slurry with 30 gals water in drum. Pour in and stir 5 min		160		39-A	160
100	Run in N-725-A from S 47 AFAP into V-100					
11	Stir 30 min at 36-38°F maintaining + CR + KI				57-A	
	Record: Time start 4:00, CR +, KI + Temp 41 °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 33%				725-A	
	Record: CR (+), KI (+), Temp °F					
	Couple V 322 thru undersurface distributor into V-100 in 90-110 min (use 9/16" orifice)					
	Record: Start 6:00 PM Total min 100					
	When S 53 complete stir 15 min					
	Record: Diazo - (-); Base + (+) pH 7.0 (7.0-8.0) Temp 60 °F					
	NOTE: If pH is 5.0-6.0 weigh and dump in 30# "as is" N-7-D diluted to 30 gal AFAP Assume 50%				7-D	
	Record: pH 9.1 (diluted to 30 Gal)		25		7-D	13
	2. If necessary, adj to pH 9.0-9.5 Assume 50%					
	Record: pH Assume 32%				28-D	
	3. For pH adjustments use only diluted N-28-D and N-7-D					
	Adj to pH 9.0-9.5 Assume 32%				28-D	
	Record: pH 9.1 Assume 50%				7-D	
	NOTE: Add N-28-D in 5# "as is" increments to approach pH 9.0-9.5 then use less N-28-D					

K43830 REV.

Note - some color loss - V100 overflowed - too much volume in diazo - (note) - 77 blocks we do...

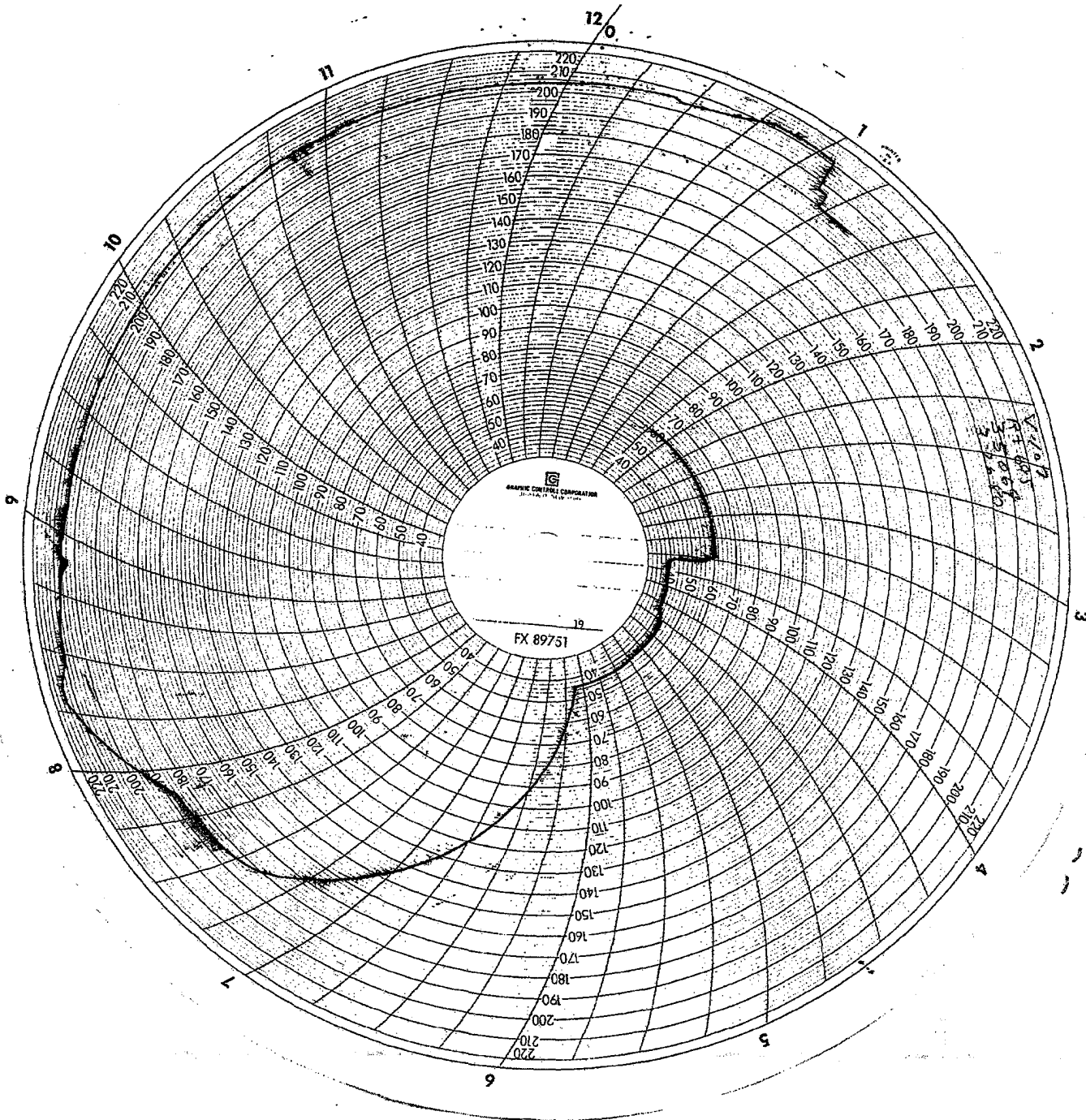
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EQUIPMENT	PAGE 3 CG 36 CODERT-695-D	EST. WGT. 2781	LBS.	USE LBS.	N CODE	ACCT. LBS.
107	58 During S 53 Heat V-107 to 210-212°F & shut off steam					
12	NOTE: If necessary reheat V-107 to 210-212°F prior to start of strike					
	59 Pump V-100 into V-107 in 70-75 min/Let V-107 temp drop to 200-205°F during strike then maintain at 200-205°F for balance of strike					
	Record: Start 805/PM 1 min 250					
	60 When strike complete, heat to 210-212°F					
	61 Stir 15 min at 210-212°F					
	62 Flood to 180-190" (18240G) and stop agitator	Record: pH 7.1 (6.5-7.2)				
		SAMPLE - 5 gal				
	Start	Fin	Optr			
	7:00 AM	3:00 PM	237			
	3:00 PM	11:00 PM	323			
	11:00 PM	1:20 AM	101			



DUP050292289

N 31812.01



DUP050292290

N 31812.02