

S.V. 107

LEAVE ONE STUMP ONLY

C.V. 207

MAKING INSTRUCTIONS: BATCH UNIT

D.V. 313, 322, 327

CG 36 CODE RT-695-D PKG.

EST. WGT.

NOV 13 80 37770

STD. HRS.

TIME

**CLEAN UP
AS YOU GO ALONG**
THMUNCHE
NOV 13 1980

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

N-740c - Use late 110

Make sure V207 recorder chart is working properly
Cooling temperature, very important

EQUIPMENT	NAME: "BON" RED DARK	USE LBS.	N CODE	ACCT. LBS.
Prep 1	1 If necessary, clean, dress sparkler & pre-coat with 15# 2 Obtain for S 6 3 Obtain for 32B		777-A 740-C 753-C	
313 2	4 Run 25" (370G) water into V-313 5 Weigh & pour in <i>MX12-1992</i> 6 Turn on agitator & steam & dump in from S 2 Lot 100% 110 500 99.04 7 Dump in 8 Dump in 9 Heat to 212-214°F WATCH FOAM 10 Record: BY + (+), if necessary adj to + BY Assume 50% 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/0.30% Total Min 16- Clarity etc.	176 505	7-D 740-C	98 500
207 3	13 Run 1" (125G) water into V-320 14 When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at 190-195°F. Record: Start/0.4% Total Min 50 Sample-From Hose Show to supervisor for OK 15 Weigh on Postal Scale & Add Lot 297	2	584-C	2
322 4	16 Run in 2" (66G) water into V-322 17 Weigh in plastic lined Drums & Pour in & hold for S 28 M 10 31.35%		28-D	202
313 5	18 When S14 complete, close V-313 outlet & stop pump 19 Run in 10" (192G) water & heat to 190-195°F Circulate thru Sparkler until sol'n is clear. - Pump thru Sparkler into V207 20 Run in 5" (80G) water in V313 & heat to 190-195°F - Circulate thru Sparkler until sol'n is clear. - Pump thru Sparkler into V207 21 Pump V 313 thru Sparkler into V-320 (Sample) 22 When MTY-blow out Sparkler into V-320 23 RECORD: VOLUME 1.4" 24 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 25 If S-23 if OK, continue with S-25. If 2-23 is not acceptable re-clarify thru sparkler.			

WINDY
SAFETY
EQUIPMENT

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 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					
	29	Adj to 33" (2277G) at 34-38°F & RECORD: TEMPS OF 30x330				57-A	6600
	30	ADJ TO 34-38°F IF NECESSARY & RECORD TEMP OF				57A	
322	31	Run in 22" (755G) water into V-322				721	
8	32	Weigh & Pour in M 1/2 292%		239		7-D	239
	33	Dump in from S3 Lot				2532-C	425
	34	Weigh on postal scale & add Lot A 1501		✓ 9		180-C	9
	35	Heat to 70-90°F					
	36	Sift in in 1-2 min		✓ 12		567-B	12
	37	Weigh on postal scale & stir to dissolve		✓ 4		479-D	4
100	38	Run in 14" (1391G) water into V-100					
9	39	Turn on agitator & steam and dump in		650		336-B	650
	40	Dump in		200		65-A	200
	41	Heat to 150-160°F & stir to dissolve N-336-B					
	42	Record: pH 5.5 (5.0-5.5)					
	43	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					
	44	Hold for S 49					
10	45	Weigh and pour into V-302 for S 47 M 1/2 3316%		✓ 51		725-A	166
322	46	Adj V-322 to 30" (1031) at 77-80°F & Record: Temp 117°F					
11	47	Slurry with 30 Gal water in drum, pour in & stir 5 min		✓ 73		39-A	73
207	48	Run in N-725-A from S44 AFAP into V-207					
12	49	Stir 30 min at 34-38°F maintaining + Cr, +KI TEMP 34°F				57-A	
		Record: Time Start 2:30 PM CR + KI +					
		NOTE: ADD					
		(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 (+)					
	50	Couple V-322 thru under surface distributor into V-207 in 40-45 min Record: Start 3:20 Total min 55					
	51	When S 49 complete, stir 15 min SAMPLE 1 gal RVD					
		Record: DIAZO - (-); BASE + (+); pH 10.95 (11.0-11.8) TEMP 61°F (60-63°F)					
		NOTE: (1) If pH is 5.0-7.0, weigh & dump in 15# "as is" N-7-D AFAP Assume 50% Record: pH				7-D	
		(2) If necessary, adj to pH 11.2-11.8 Assume 32%				28-D	
	52	Adj to pH 10.8-11.2 Assume 32%				28-D	
		Record: pH 10.95 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					
	53	See attached sheet for PH adjustment Use only diluted N7 or N28 - very important					

Make
Sure
temp
is
not
below
34°F

EQUIPMENT	PAGE 3	CG 36 CODE RT-695-D	EST. WGT.	1350 LBS.	USE LBS.	N CODE	ACCT. LBS.
1070	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 6:20 AM Total min 7 1/2					
	55	When strike complete heat to 210-212°F					
	56	Stir 15 min at 210-212°F					
	57	Flood to 87" (8648G). Record: pH 7.3 (6.5-7.2)					
	58	Stop agitator					
		2 gal. Sample for R & D jar at Vat					
		Start	Fin	Oprr			
		7:00 AM	3:00 PM	237			
		3:00 PM	8:50 PM	340			

FORM A

CODE PT-695

LOT 37770

VATS 313 322
207
100

EQUIP. _____

DATE 11-13 OPER. 237-342

SUPERVISOR She

- ~~1.~~ Used all stumps, leave 1 stump identified.
- ~~2.~~ Clean shovel.
- ~~3.~~ Chute washed & top replaced.
- ~~4.~~ Water hose coiled.
- ~~5.~~ Steam ejector turned off after finished in vat.
- ~~6.~~ Scale left clean.
- ~~7.~~ Added ice to vat only when volume reaches agitator.
- ~~8.~~ Floor cleaned around vats used.
- ~~9.~~ Hoses coiled or on rack on diazo press.
- ~~10.~~ Hoses not crossing walkway after finished.
- ~~11.~~ Pump shut off after removing hose from intake.
- ~~12.~~ Ice blower shut off after using.
- ~~13.~~ All spills in area worked clean.
- ~~14.~~ Door on instruments closed.
- ~~15.~~ All empty drums removed from area & discarded.
- ~~16.~~ Corrosive containers properly covered.
- ~~17.~~ Top of vats cleaned of color, paper cups, strings, etc.
- ~~18.~~ Vat door closed after finished - hatches on abbe's.
- ~~19.~~ All tools cleaned & placed in rack or proper places.
- ~~20.~~ Ice house clean - tools on racks.
- ~~21.~~ Revolver cleaned - platform & pit.

ATTACH TO MAKE CARD

