

S.V. 107

C.V. (107)

D.V. 313/322/317

99K

CG 36 CODE RT-565-D PKG ---

PROCESSES

APPROVED BY

OCT 28 1982

L2H74

() RT-565-D (M)

EWK 12-8-81

(DATE) (LOT NUMBER)

EST. WT. ~~1523~~ LBS.TYPED BY: KIW
STANDARD HRS. 8.5

TIME 3 P. M.

PREPARATION NOTES:

NON-BLEEDING

EQUIP MENT		NAME: BON RED LIGHT	USE LBS	N-CODE	ACCT LBS
PREP 1	1	IF NECESSARY, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15% DICALITE, FILTER AID		777-A	
	2	OBTAIN 2-CHLORO-4-AMINO TOLUENE-5-SULFONIC ACID FOR S7		740-C	
	3	OBTAIN 3-HYDROXY-2-NAPHTHOIC ACID FOR S19		82-C	
	4	INSTALL DV & CV RECORDER & CONTROLLER CHART			
317 2	5	RUN 15" (474G) WATER INTO V-317			
	6	WEIGH SODIUM HYDROXIDE IN DRUM & POUR IN M. 12, 50.16 %	255	7-D	128
	7	TURN ON AGITATOR & STEAM & DUMP IN FROM S2		740-C	681
		2-CHLORO LOT #100%			
		4-AMINOTOLUENE 322 642 98.52 652			
		5-SULFONIC 282 39 98.62 40			
		ACID			
	8	PUMP IN ACTIVATED CARBON	25	113-B	25
	9	PUMP IN DICALITE FILTER AID	5	777-A	5
	10	HEAT TO 212-214 DEG F WATCH FOAM			
	11	RECORD: BY (+)			
	12	STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM. WATCH FOAM			
		RECORD: SPARKLER PRESSURE PSI			
		IF NOT ZERO, NOTIFY SUPERVISOR			
	13	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 F FOR S15 & RECORD: HT 195 DEG F AND RECORDER 195 DEG F. RECORD: START 245P TOTAL MIN 15 CLARITY OK			
322 3	14	RUN 1-2" (70G) WATER INTO V-322			
	15	WHEN S13 COMPLETE, PUMP IN V-317 THRU SPARKLER. MAINTAIN V-317 AT 190-195 DEG F. RECORD: START 10 PM TOTAL MIN 20			
330 43/3	16	WEIGH SODIUM HYDROXIDE INTO V-330 FOR S18 M. 12, 50.16 %	678	7-D	1340

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HBB

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 2 OF 3 CG 36 CODE RT-565-D (M)	USE LBS	N-CODE	ACCT LBS
107 5	17	RUN 21" (1989G) WATER INTO V-107			
	18	RUN IN V-330 FROM S16			
	19	DUMP IN FROM S3		82-C	596
		LOT 3-HYDROXY- 2-NAPHTHOIC ACID 8293	500 96		
	20	ADJ TO 70-80 DEG F, STIR TO SOL'N AND RECORD: HT _____ & RECORDER _____ DEG F			
	21	DUMP IN SODIUM CARBONATE	100	3-A	500
	22	DUMP IN SODIUM CARBONATE & STIR 5 MIN OR LONGER TO DISSOLVE	500	3-A	500
317 6	23	WHEN S15 COMPLETE, CLOSE V-317 OUTLET & STOP PUMP			
	24A	RUN IN 12" (378G) WATER INTO V-922 AND HEAT TO 190-195 DEG F. CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN 190-195 DEG F DURING S26			
322 7	24B	PUMP V-317 THRU SPARKLER INTO V-322			
317 8	25A	RUN 6" (183G) WATER INTO V-317 & HEAT TO 190-195 DEG F. CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR MAINTAIN 190-195 DEG F THRU S25			
322 9	25B	PUMP V-317 THRU SPARKLER INTO V-322			
	26	WHEN MT BLOW OUT SPARKLER INTO V-322			
MISC 10	27	WEIGH SODIUM NITRITE INTO DRUMS FOR S31 M. 10, 32.26% 672	672	725-A	220
322 11	28	WHEN S26 COMPLETE, HEAT V-322 TO 165-170 F			
	29	RUN HYDROCHLORIC ACID FROM V-324 & STIR 5 MIN M. 2, 31.01%	1029	28-D	319
	30	ADJ TO 62" (2170G) AT 32-38 DEG F	24X330	57-A	13407
	31	DUMP IN SODIUM NITRITE N-725-A FROM S27	32		
	32	STIR 30 MIN AT 32-38 F & RECORD: KI _____ MUST BE (+) M. _____ %		725-A	
107 12	33	PUMP V-322 AT 32-38 F THRU UNDERSURFACE DISTRIBUTOR INTO V-107 IN 25-30 MIN. MAINTAIN V-107 AT 70-80 DEG F DURING DIAZO ADDITION. RECORD: START 2:50 TOTAL MIN 3:20			
	34	STIR 15 MIN & RECORD: BASE _____ (+), DIAZO _____ (-), PH 10.4 (10.6-11.6)			
	35	HEAT TO 190-194 DEG F IN 70-75 MIN AND RECORD: HT 194 DEG F & RECORDER 194 DEG F			

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 3 OF 3 CG 36 CODE RT-565-D (M)	USE LBS	N-CODE	ACCT LBS
322 13	36	DURING S35, RUN 44" (1540G) WATER INTO V-322			
	37	TURN ON AGITATOR AND STEAM AND DUMP IN MANGANESE SULPHATE.	1036	336-A	1036
	38	HEAT TO 140-160 DEG F & STIR 5 MIN OR LONGER TO DISSOLVE. RECORD PH <u>6.1</u> IF PH IS ABOVE 5.5 ADJ WITH SULFURIC ACID TO PH 5.0-5.5. RECORD PH <u>4.8</u> ASSUME 78%	<u>2</u>	27-D	<u>1</u>
107 14	39	HEAT TO 210-212 DEG F IN 5-10 MIN			
	40	WHEN S39 COMPLETE, PUMP V-322 THRU UNDER-SURFACE DISTRIBUTOR INTO V-107 IN 20-30 MIN. MAINTAIN V-107 AT 210-212 DEG F DURING STRIKE. RECORD: START <u>4:05A</u> TOTAL MIN <u>40</u>			
	41	STIR 30 MIN AT 210-212 F RECORD START <u>5:45A</u>			
	42	FLOOD TO 180-190" (18240G) & RECORD: PH <u>7.5</u> (7.5-8.5)			
START <u>9 PM</u> <u>11:00 PM</u> FIN <u>11 PM</u> <u>6:30 AM</u> OPTR <u>438</u> <u>342</u>					

N= 740 - C CHECK-WEIGH & CALCULATE

NEWARK CHECK-WEIGH

DUP050061065

