

V. (107) C.V. 100

D.V. (330)	(322)	(207)
PROCESSES	APPROVED BY	
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TYPED BY		

SG 36 CODE RT-695-D PKG.

-12/1 NOV 88 33024

EST. WGT. 2781 LBS.

STD. HRS. TIME 7 AM 2 g

NOTE
STRIKE TIME

NON-BLEEDING

UMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
REP 1	"BON" RED DARK			
1	If necessary, clean, dress Sparkler & pre-coat with 15#	15	777-A	15
2	Obtain for 56		740-C	
3	Obtain for 526		82-C	
330 2	Run 28" (948G) water into V-330			
4	Weigh & POUR IN	M 11, 49.29%	43%	7-D 215
5	Turn on agitator & steam & dump in from S 2		740-C	1102
	Lot 100% %			
	952 961 98.53 975			
	956 141 98.46 143			
7	Dump in	50	113-B	50
8	Dump in	10	777-A	10
9	Heat to 212-214°F			
10	Record: BY F (+), if necessary adj to + BY		7-D	
11	Stir 30 min at 212-214°F, then shut off steam			
12	Circulate 15 min or longer thru Sparkler until sol'n is clear			
	Maintain at 190-195°F for S 14 & Record: HT 193 OF			
	& Recorder 195 OF			
	Record: Start 4:15 PM Total Min 30 Clarity CLEAR			
207 3	Run 1" (99G) water into V-207			
14	When S 12 complete, pump in V-330 thru Sparkler. Maintain V-330 at 190-195°F. Record: Start 4:50 PM Total Min 25			
15	WEIGH ON POSTAL SCALE & ADD LOT	2	584-C	2
330 4	WHEN S-14 COMPLETE, CLOSE V-330 OUTLET & STOP PUMP			
17	RUN IN 1" (431 G) WATER & HEAT TO 180-190°F			
18	Circulate 15 min or longer thru Sparkler until sol'n is clear			
	Maintain at 180-190°F for S 19 & Record: HT 190 OF			
	& Recorder 190 OF			
	Record: Start 5:35 PM Total Min 10 Clarity CLEAR			
207 5	WHEN S-18 IS COMPLETE			
19	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)			
22	TEST FOR CLARITY OF SOLUTION			
	SHOW 1 QT SAMPLE TO SHIFT SUPERVISOR			
	FOR APPROVAL (EXAMPLE OF ACCEPTABLE CLARIFICATION OF N740-C IS AVAILABLE IN OFFICE TO COMPARE TO)			
23	IF S-21 IS OK CONTINUE WITH S-23			
	IF S-21 IS NOT ACCEPTABLE, RECLARIFY THRU SPARKLER			
24	IF S-21 IS OK, RE-HEAT V-207 to 165-170°F FOR S-25			

V-107

EQUIPMENT

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CG 36

CODE

AT-695-D

EST. WGT.

2781

LHS.

USE

LBS.

N

CODE

AC

LI

107

12

DURING 553 HEAT V-107 TO 210-212°F &

SHUT OFF STEAM

NOTE: IF NECESSARY, REHEAT V-107 TO 210-212°F

PRIOR TO START OF STRIKE

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 1:15 AM TOTAL MIN 135

WHEN STRIKE COMPLETE HEAT TO 210-212°F

STIR 15 MIN AT 210-212°F

COOL TO 180-190°F (18240 G) RECORD: PH 7.0 (65-72)

STOP AGITATOR

SAMPLE

START

FIN

OP/LR

1:50 PM

3:00 PM

350

9:00 PM

11:00 PM

409

11:00 PM

4:00 AM

381

DO NOT HAVE TO PRECOAT SPARKER START OF

STRIKE

AT-100
START 844

STRIKE

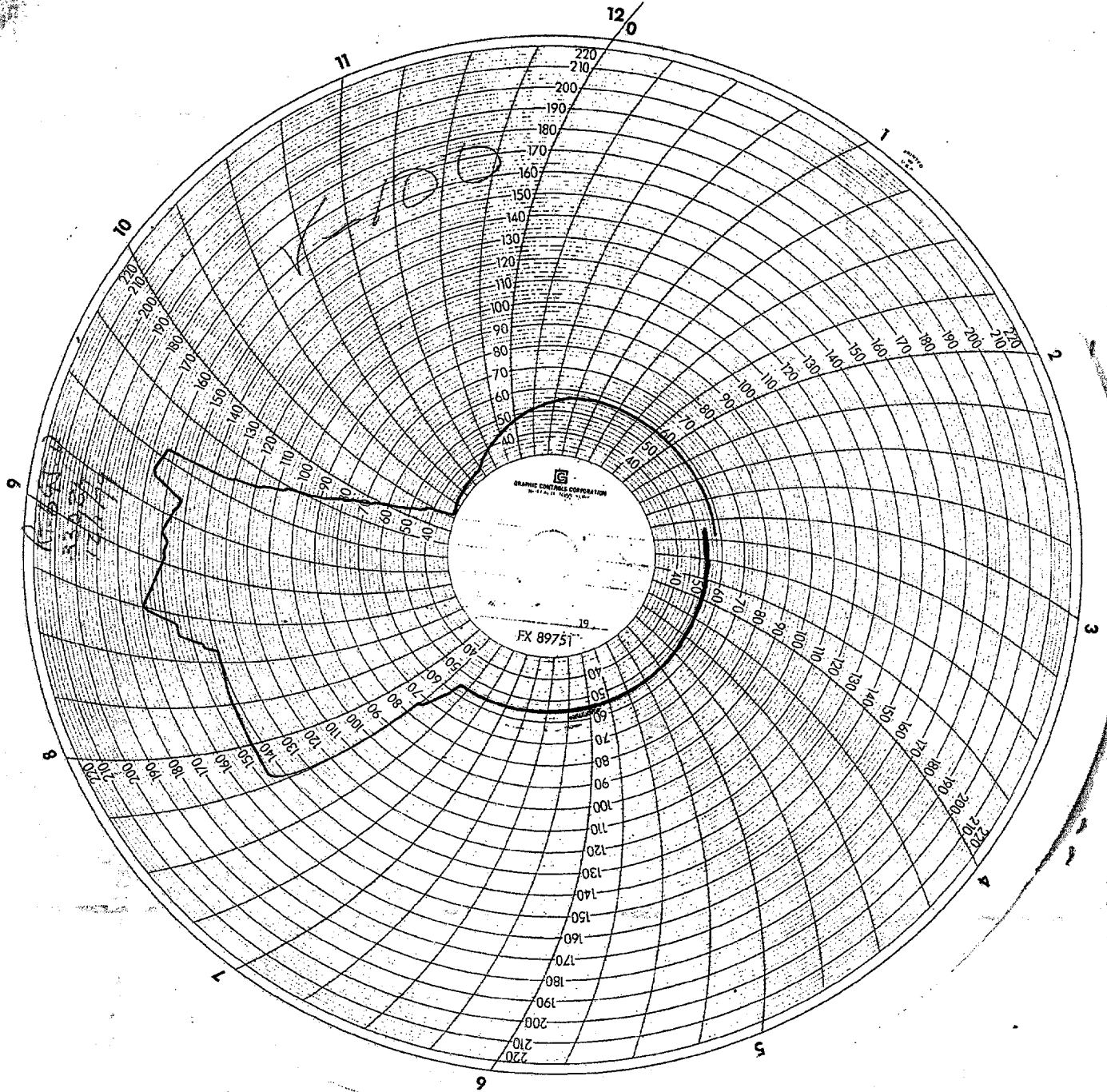
14 15 HR

14 - 2 HR

65% OUT AFTER

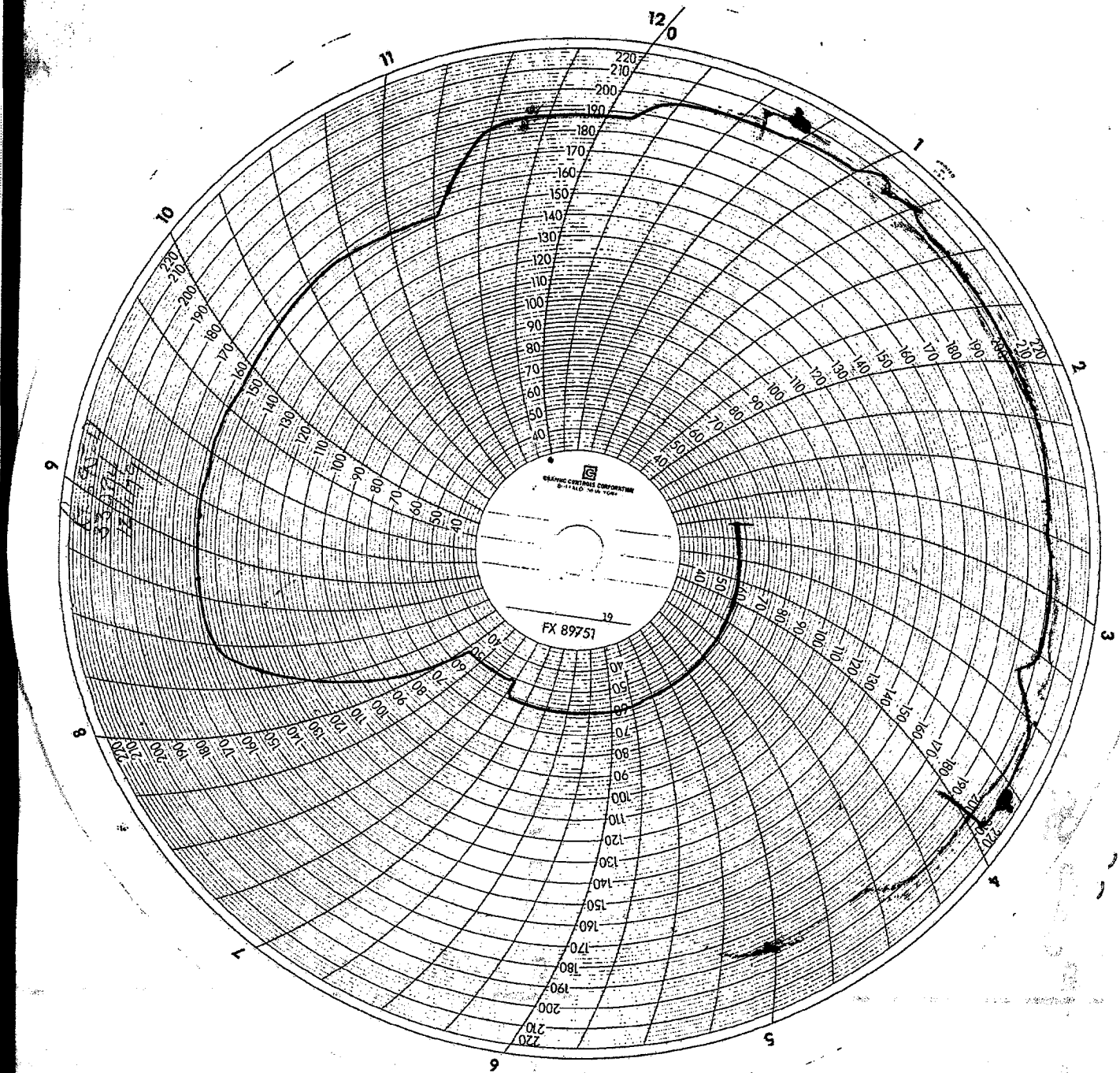
2 HR

89
27
68



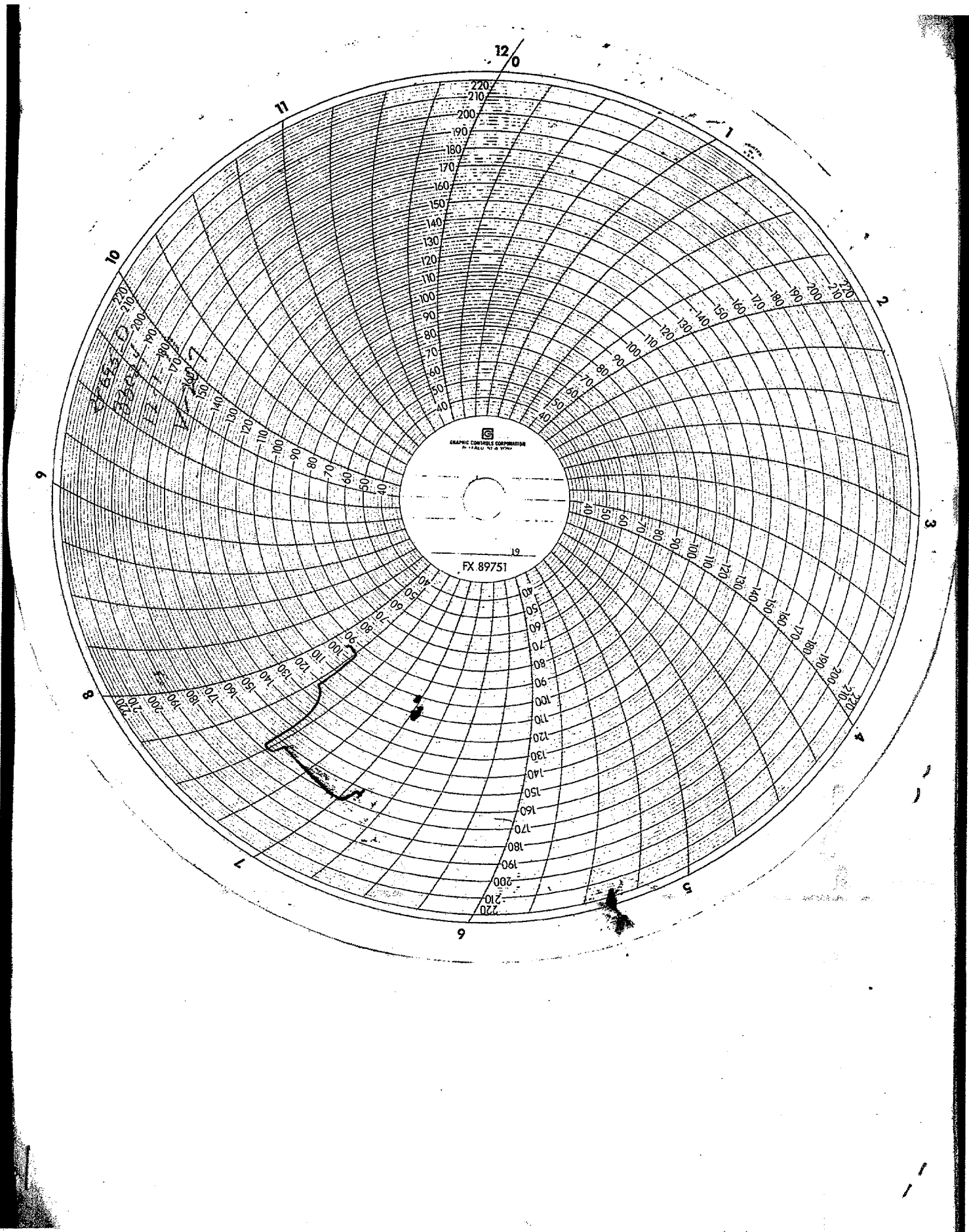
DUP050292310

N 31817.01



DUP050292311

N 31817.02



DUP050292312

N 31817.03