

I.V. 107

C.V. 207

MAKING INSTRUCTIONS: BATCH UNIT

D.V. 313, 322, 330

CG 36 CODE RT-695-D PKG.

EST. WGT. 1350 LBS. 37397

STD. HRS. TIME 3PM 285

PROCESSES	APPROVED BY
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TYPED BY	

N740C- Use lots 102 & 103 only

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		82-C	
313 2	4 Run 25" (370G) water into V-313			
	5 Weigh & pour in 49.92 196		7-D 98	
	6 Turn on agitator & steam & dump in from S 2		740-C	
	Lot 100% 5			502
	102 502 98.73 508			
	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 °F			
	& Recorder			
	Record: Start/0.05 Total Min 20 Clarity CLEAR			
307 3	13 Run 1" (125G) water into V-307			
	14 When S-12 complete, pump V 313 thru Sparkler. Maintain V-313 at 190-195°F. Record: Start/0.05 Total Min 40 Sample-From Hose			
	Show to supervisor for OK			
	15 Weigh on Postal Scale & Add Lot			
322 4	16 Run in 2" (66G) water into V-322			
	17 Weigh in plastic lined Drums & Pour in & hold for S 28			
	M 8 32.31 625		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 Sparkler until sol'n is clear.			
307 6	20 Pump V 313 thru Sparkler into V-307 (Sample)			
	21 When MTY-blow out Sparkler into V-307			
	22 RECORD: VOLUME 10 "			
	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 S-23 is not acceptable re-clarify thru sparkler.			

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					
	29	Adj to 33" (2277G) at 32-38°F		27x330	57-A		
322	30	Run in 22" (755G) water into V-322					
8	31	Weigh & Pour in	M 12, 4902%	479	7-D	239	
	32	Dump in from S3	Lot		82-C		
			4912	422		932	
	33	Weigh on postal scale & add	Lot 00316	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	
1020	37	Run in 14" (1391G) water into V-1020					
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 6.3 (5.0-5.5)					
	42	If pH above 5.5, adj to pH 5.5 or lower Assume 78%		1	27-D	1	
		Record: pH 4.3					
		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 12 3316%		501	725-A	166	
10							
322	45	Adj V-322 to 30" (1031) at 30-30°F a RECORD: TEMP 80°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 2:35/P 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 Assume 33%			725-A		
		RECORD: CR (+), KI (+)					
	49	Couple V-322 thru under surface distributor into V-207 in					
		40-45 min Record: Start 3:15 P Total min 46					
	50	When S 49 complete, stir 15 min					
		Record: DIAZO - (-); BASE + (+); pH 11.7 (11.0-11.8) TEMP 52°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		
	51	If necessary, adj to pH 11.4-11.8 Assume 50%			7-D		
		Record: pH Assume 32%			28-D		
	52	Adj to pH 9.0-9.5 8.2-8.6 Assume 32%		66	28-D	22	
		Record: pH 8.3 TAKE 1 GAL SAMPLE 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 dilutes N 7 & N 28 for pH adj.					



