

CG 88 CODE SF-88 PKG.

DEC 19 86 88205

EST. WGT. 1714 LBS.

STD. HRS. TIME M

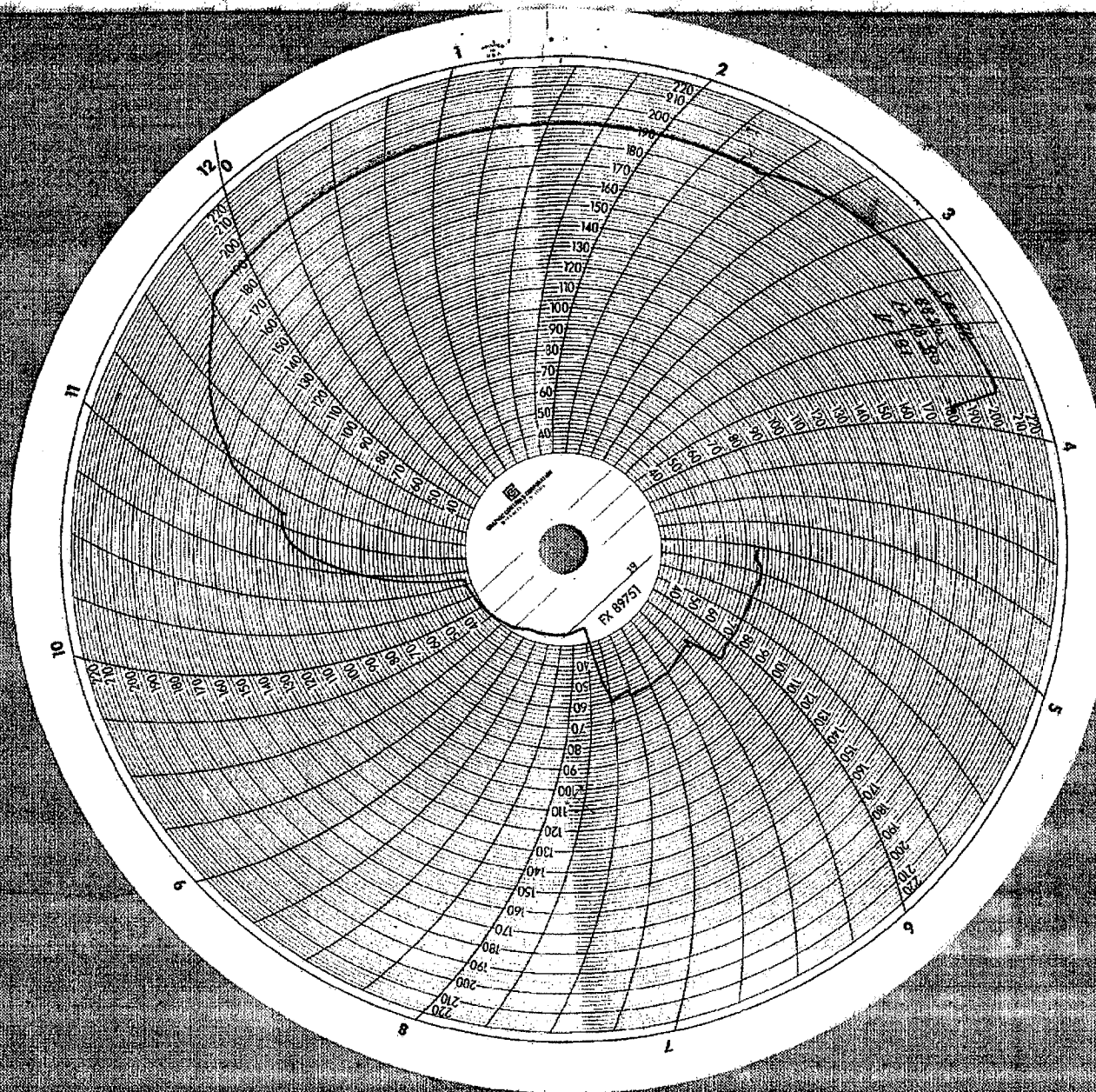
| PROCESSES   |     | APPROVED BY |  |
|-------------|-----|-------------|--|
| (E) SF-88   | ( ) | BBK 9-28-77 |  |
| ( )         | ( ) | DCG 10-3-77 |  |
| ( )         | ( ) | MTW 10-5-77 |  |
| ( )         | ( ) |             |  |
| TYPED BY    |     |             |  |
| NSA 10-6-77 |     |             |  |

## NON-BLEEDING

| EQUIPMENT    | NAME | QAQ                                                                              | USE<br>LBS. | N<br>CODE | ACCT.<br>LBS. |
|--------------|------|----------------------------------------------------------------------------------|-------------|-----------|---------------|
| Prep<br>1    | 1    | Check availability of N-57-A: Need ±60 blocks 9 Bldg.<br>Need ±35 blocks 6 Bldg. |             |           |               |
|              | 2    | Check availability of N-7-D for S 26                                             |             |           |               |
|              | 3    | Obtain 21 drums, weigh & record gross, tare & net wqts for<br>S 16               |             |           |               |
|              |      | Record; Lot                                                                      | ±2100       | 7557-A    |               |
|              |      | GROSS WGT TARE NET WGT                                                           |             |           |               |
|              | 1    |                                                                                  |             |           |               |
|              | 2    |                                                                                  |             |           |               |
|              | 3    |                                                                                  |             |           |               |
|              | 4    |                                                                                  |             |           |               |
|              | 5    |                                                                                  |             |           |               |
|              | 6    |                                                                                  |             |           |               |
|              | 7    |                                                                                  |             |           |               |
|              | 8    |                                                                                  |             |           |               |
|              | 9    |                                                                                  |             |           |               |
|              | 10   |                                                                                  |             |           |               |
|              | 11   |                                                                                  |             |           |               |
|              | 12   |                                                                                  |             |           |               |
|              | 13   |                                                                                  |             |           |               |
|              | 14   |                                                                                  |             |           |               |
|              | 15   |                                                                                  |             |           |               |
|              | 16   |                                                                                  |             |           |               |
|              | 17   |                                                                                  |             |           |               |
|              | 18   |                                                                                  |             |           |               |
|              | 19   |                                                                                  |             |           |               |
|              | 20   |                                                                                  |             |           |               |
|              | 21   |                                                                                  |             |           |               |
|              |      | TOTAL                                                                            |             |           |               |
|              |      | Note: Enter total net wgt under "Acct Lbs"                                       |             |           |               |
|              | 4    | Obtain 7 drums, weigh & record gross, tare & net wqts for<br>S 7 & 22            | ±2600       | 120-D     |               |
|              |      | GROSS WGT TARE NET WGT                                                           |             |           |               |
|              | 1    |                                                                                  |             |           |               |
|              | 2    |                                                                                  |             |           |               |
|              | 3    |                                                                                  |             |           |               |
|              | 4    |                                                                                  |             |           |               |
|              | 5    |                                                                                  |             |           |               |
|              | 6    |                                                                                  |             |           |               |
|              | 7    |                                                                                  |             |           |               |
| 315/317<br>2 | 5    | Run 10" (330 G) water into V-315/317                                             |             |           |               |
|              | 6    | Add                                                                              | 2x330       | 57-A      |               |
|              | 7    | Dump in 5 drums N-120-D from S 4                                                 | 2000        | 120-D     | 2000          |
|              |      | Note: Remaining N-120-D will be added at S 22                                    |             |           |               |
|              |      | Record tare wqts in S 4                                                          |             |           |               |

| EQUIPMENT    | PAGE | CG          | 88                                                                                             | CODE (E)                                        | SE-88 | EST. WGT. | 2255 | LBS. | USE LBS. | N CODE | ACCT LBS. |
|--------------|------|-------------|------------------------------------------------------------------------------------------------|-------------------------------------------------|-------|-----------|------|------|----------|--------|-----------|
| 181<br>3     | 8    | Rinse       | inside                                                                                         | of V-181 top with high pressure water and drain |       |           |      |      |          |        |           |
|              | 9    | Close       | outlet, install temp chart & put up safety chain                                               |                                                 |       |           |      |      |          |        |           |
|              | 10   | Start       | Rotoclone                                                                                      |                                                 |       |           |      |      |          |        |           |
|              | 11   | Set         | agitator at 20 RPM                                                                             |                                                 |       |           |      |      |          |        |           |
|              | 12   | Run         | in from V-386, Record vol                                                                      | " M                                             | %     |           |      |      |          | 27-D   | 19160     |
|              | 13   | Start       | agitator                                                                                       |                                                 |       |           |      |      |          |        |           |
|              | 14   | Add         |                                                                                                |                                                 |       |           |      |      | 46x330   | 57-D   |           |
|              | 15   | Adj         | to 36" (3600 G) at 44°F or below                                                               |                                                 |       |           |      |      |          | 57-D   |           |
|              |      | Note:       | Use ice only to adj - DO NOT ADD ANY WATER                                                     |                                                 |       |           |      |      |          |        |           |
|              |      | Record:     | HT °F, Rec °F, Vol "                                                                           |                                                 |       |           |      |      |          |        |           |
|              |      | Note:       | Volume must not exceed 36"                                                                     |                                                 |       |           |      |      |          |        |           |
|              |      | STOP        | AGITATOR - Take 1 qt samples                                                                   |                                                 |       |           |      |      |          |        |           |
| 181<br>4     | 16   | Start       | agitator, Dump in N-7557 from S 3                                                              |                                                 |       |           |      |      |          |        |           |
|              | 17   | Weigh       | & record tare wgt & calc total net wgt N-7557-A in S 3                                         |                                                 |       |           |      |      |          |        |           |
|              | 18   | Rinse       | vat chute, sides, & agitator post with minimum water                                           |                                                 |       |           |      |      |          |        |           |
|              |      | Note:       | Use "Water Saver" nozzle                                                                       |                                                 |       |           |      |      |          |        |           |
|              | 19   | Stir        | 10 min Record: Temp °F, Vol "                                                                  | (36-38")                                        |       |           |      |      |          |        |           |
| Misc.<br>5   | 20   | Calc        | for S 21                                                                                       |                                                 |       |           |      |      |          |        |           |
|              |      | # Net       | wgt N-7557-A (S 3) x 1.196 = # N-120                                                           |                                                 |       |           |      |      |          |        |           |
|              | 21   | Calc        | for S 22                                                                                       |                                                 |       |           |      |      |          |        |           |
|              |      | # N-120-D   | (S 20) + 2000 = # N-120-D                                                                      |                                                 |       |           |      |      |          |        |           |
| 315/317<br>6 | 22   | Dump        | in & charge out N-120-D calculated in S 21                                                     |                                                 |       |           |      |      |          | 120-D  |           |
|              | 23   | Stir        | 15 min or longer to dissolve                                                                   |                                                 |       |           |      |      |          |        |           |
| 181<br>7     | 24   | When        | S 19 and S 23 stir complete, immediately run in DV AFAP                                        |                                                 |       |           |      |      |          |        |           |
|              |      | (30-60min)  | Maintain V-181 temp below 120°F                                                                |                                                 |       |           |      |      |          |        |           |
|              |      | Note:       | Run in AFAP until temp reaches 110°F then if necessary, reduce addition rate to maintain 120°F |                                                 |       |           |      |      |          |        |           |
|              |      | Record:     | Time Start Total Min                                                                           |                                                 |       |           |      |      |          |        |           |
|              |      | Max         | Temp                                                                                           |                                                 |       |           |      |      |          |        |           |
|              | 25   | When        | DV MTY, rinse sides & wash in                                                                  |                                                 |       |           |      |      |          |        |           |
|              | 26   | Immediately | heat to 190-194°F in 60-65 min. Watch foam                                                     |                                                 |       |           |      |      |          |        |           |
|              |      | Record:     | HT °F, Rec °F                                                                                  |                                                 |       |           |      |      |          |        |           |
|              |      | Note:       | If foaming excessive, shut off agitator & steam, resume when foam stops                        |                                                 |       |           |      |      |          |        |           |
|              | 27   | Stir        | 2-4 hours at 190-194°F. Record Start                                                           |                                                 |       |           |      |      |          |        |           |
| 315/317<br>8 | 28   | During      | S 27, stir, run 8" (265 G) water into V-315/317                                                |                                                 |       |           |      |      |          |        |           |
|              | 29   | Add         | M %                                                                                            |                                                 |       |           |      |      |          | 7-D    | 8000      |
|              | 30   | Adj         | to 67" (2310 G) at 75-80°F & Record °F                                                         |                                                 |       |           |      |      | 31x330   | 57-A   |           |
| 181<br>9     | 31   | When        | S 27 complete, immediately run in DV (S-28) at a rate to minimize splashing (50-70 min )       |                                                 |       |           |      |      |          |        |           |
|              | 32   | Flood       | to 160-170 F at +80" (8000 G)                                                                  |                                                 |       |           |      |      |          |        |           |
|              | 33   | Stop        | agitator & take 1 quart sample                                                                 |                                                 |       |           |      |      |          |        |           |
|              |      | START       | FINISH                                                                                         | OPTR                                            |       |           |      |      |          |        |           |

| EQUIPMENT | PAGE 2 CG 88 CODE (E) SF-88 | EST. WGT. 1714                                                                                            | LBS.            | USE LBS. | N. CODE | ACCT LBS. |
|-----------|-----------------------------|-----------------------------------------------------------------------------------------------------------|-----------------|----------|---------|-----------|
| 181       | 8                           | Rinse inside of V-181 top with high pressure water and drain                                              |                 |          |         |           |
| 3         | 9                           | Close outlet, install temp chart & put up safety chain                                                    |                 |          |         |           |
|           | 10                          | Start Rotocloner <del>CHECK DAMPER SETTING - OPEN WIDE</del>                                              |                 |          |         |           |
|           | 11                          | Set agitator at 20 RPM                                                                                    | 100% 7469 71.32 | 10473    |         |           |
|           | 12                          | Run in from V-386, Record vol 16 " 71.41%                                                                 | 71.41%          | 9930     | 27-D    | 14,561    |
|           | 13                          | Start agitator                                                                                            |                 |          |         |           |
|           | 14                          | Add.                                                                                                      |                 | 35x330   | 57-A    | 11550     |
|           | 15                          | Adj to 27" (2700 G) at 44°F or below                                                                      |                 |          | 57-A    |           |
|           |                             | Note: Use ice only to adj - DO NOT ADD ANY WATER                                                          |                 |          |         |           |
|           |                             | Record: HT °F, Rec - 32 °F 28 " Vol                                                                       |                 |          |         |           |
|           |                             | Note: Volume must not exceed 28"                                                                          |                 |          |         |           |
|           |                             | STOP AGITATOR - <del>10 MINUTES</del>                                                                     |                 |          |         |           |
|           |                             | ONE DRUM EVERY 2 MINUTES (MINIMUM TIME)                                                                   |                 |          |         |           |
| 181       | 16                          | Start agitator, Dump in N-7557 from S 3 <del>GROUND ALL DRUMS Before DUMPING</del>                        |                 |          |         |           |
| 4         | 17                          | Weigh & record tare wgt & calc total net wgt N-7557-A in S 3                                              |                 |          |         |           |
|           | 18                          | Rinse vat chute, sides, & agitator post with minimum water                                                |                 |          |         |           |
|           |                             | Note: Use "Water Saver" nozzle                                                                            |                 |          |         |           |
|           | 19                          | Stir 10 min Record: Temp 30 °F, Vol 31 " (27-29")                                                         |                 |          |         |           |
| Misc.     | 20                          | Calc for S 21                                                                                             |                 |          |         |           |
| 5         |                             | 1621 # Net wgt N-7557-A (S 3) x 1.196 = 1939 # N-120                                                      |                 |          |         |           |
|           | 21                          | Calc for S 22                                                                                             |                 |          |         |           |
|           |                             | 1939 # N-120-D (S 20) - 1600 = 339 # N-120-D                                                              |                 |          |         |           |
| 315/322   | 22                          | Dump in & charge out N-120-D calculated in S 21                                                           |                 | 339      | 120-D   | 339       |
| 6 ONLY    | 23                          | Stir 15 min or longer to dissolve                                                                         |                 |          |         |           |
| 181       | 24                          | When S 19 and S 23 stir complete, immediately run in DV AFAP (30-60 min). Maintain V-181 temp below 120°F |                 |          |         |           |
| 7         |                             | Note: Run in AFAP until temp reaches 110°F then if necessary, reduce addition rate to maintain 120°F      |                 |          |         |           |
|           |                             | Record: Time Start 10:55 P Total Min 30                                                                   |                 |          |         |           |
|           |                             | Max Temp 118                                                                                              |                 |          |         |           |
|           | 25                          | When DV MTY, rinse sides & wash in USE MINIMUM WATER                                                      |                 |          |         |           |
|           | 26                          | Immediately heat to 190-194°F in 60-65 min. Watch foam                                                    |                 |          |         |           |
|           |                             | Record: HT 192 °F, Rec. 192 °F                                                                            |                 |          |         |           |
|           |                             | Note: (1) If foaming excessive, shut off agitator & steam,                                                |                 |          |         |           |
|           |                             | TURN ON WATER SPRAYS FOR MIN AMOUNT OF TIME,                                                              |                 |          |         |           |
|           |                             | WHEN FOAM STOPS TURN OFF WATER SPRAYS, TURN ON AGITATOR & RESUME HEATING                                  |                 |          |         |           |
|           |                             | (2) REPEAT NOTE 1 AS REQUIRED (SPRAYS ON FOR MINIMUM TIME.)                                               |                 |          |         |           |
|           | 27                          | Stir 2-1/2 hours at 190-194°F. Record Start 11:55 P                                                       |                 |          |         |           |
| 315/322   | 28                          | During S 27, stir, run 2" (51 G) water into V-315/322 ONLY                                                |                 |          |         |           |
| 8         | 29                          | Add M 50.33 % 12080                                                                                       |                 | 7-D      | 6088    |           |
|           | 30                          | Adj to 59" (3026 G) at 75-80°F & Record 78 °F, 59 " 23x330                                                |                 | 57-A     | 7590    |           |
| 181       | 31                          | When S 27 complete, immediately run in DV (S-28) at a rate to minimize splashing (50-70 min)              |                 |          |         |           |
| 9         | 32                          | Cool to 160-170°F WITH ICE                                                                                |                 | 15x330   | 57-A    | 2250      |
|           | 33                          | Stop agitator                                                                                             |                 |          |         |           |
|           | 34                          | HOSE OFF AGITATOR COUPLING                                                                                |                 |          |         |           |
|           | 35                          | RECORD VAT FREE BOARD: 24                                                                                 |                 |          |         |           |
|           |                             | START 300 P FINISH 700 A OPTR 259                                                                         |                 |          |         |           |



DUP050292117

N 31800.01

S.V. 181

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V. 315 ONLY

CG 88 CODE SF-88

PKG.

EST. WGT. ~~51714~~ LBS.

STD. HRS. TIME M

| PROCESSES   |     | APPROVED BY |  |
|-------------|-----|-------------|--|
| (E) SF-88   | ( ) | BBK 9-28-77 |  |
| ( )         | ( ) | DCG 10-3-77 |  |
| ( )         | ( ) | MTW 10-5-77 |  |
| ( )         | ( ) |             |  |
| TYPED BY    |     |             |  |
| NSA 10-6-77 |     |             |  |

$$\frac{1600^*}{2100^*} = 0.76$$

## NON-BLEEDING

| EQUIPMENT | NAME                                       | QAQ                                                                 | USE LBS. | N CODE  | ACCT. LBS. |
|-----------|--------------------------------------------|---------------------------------------------------------------------|----------|---------|------------|
| Prep 1    | 1                                          | Check availability of N-57-A: Need 45 blocks 9 Bldg (2)             |          |         |            |
|           |                                            | Need 26 blocks 6 Bldg.                                              |          |         |            |
|           | 2                                          | Check availability of N-7-D for S 26                                |          |         |            |
|           | 3                                          | Obtain 16 drums, weigh & record gross, tare & net wghts for S 16    |          |         |            |
|           | Record:                                    | Lot                                                                 | 1600     | 7557-A  | 1614       |
|           |                                            | GROSS WGT                                                           | TARE     | NET WGT |            |
|           | 1                                          | 126                                                                 | 24       | 102     |            |
|           | 2                                          | 123                                                                 | 23       | 100     |            |
|           | 3                                          | 122                                                                 | 26       | 101     |            |
|           | 4                                          | 128                                                                 | 26       | 102     |            |
|           | 5                                          | 125                                                                 | 32       | 101     |            |
|           | 6                                          | 126                                                                 | 24       | 102     |            |
|           | 7                                          | 123                                                                 | 33       | 100     |            |
|           | 8                                          | 126                                                                 | 25       | 101     |            |
|           | 9                                          | 132                                                                 | 31       | 101     |            |
|           | 10                                         | 126                                                                 | 25       | 101     |            |
|           | 11                                         | 124                                                                 | 26       | 102     |            |
|           | 12                                         | 125                                                                 | 24       | 101     |            |
|           | 13                                         | 125                                                                 | 26       | 99      |            |
|           | 14                                         | 123                                                                 | 28       | 100     |            |
|           | 15                                         | 131                                                                 | 30       | 101     |            |
|           | 16                                         | 123                                                                 | 23       | 100     |            |
|           | TOTAL                                      | 1614                                                                |          |         |            |
|           | Note: Enter total net wgt under "Acct Lbs" |                                                                     |          |         |            |
|           | 4                                          | Obtain 5 drums, weigh & record gross, tare & net wghts for S 7 & 22 | 1976     | 120-D   |            |
|           |                                            | GROSS WGT                                                           | TARE     | NET WGT |            |
|           | 1                                          | 417                                                                 | 17       | 400     |            |
|           | 2                                          | 412                                                                 | 17       | 400     |            |
|           | 3                                          | 417                                                                 | 17       | 400     |            |
|           | 4                                          | 417                                                                 | 17       | 400     |            |
|           | 5                                          | 393                                                                 | 17       | 376     |            |
|           | 6                                          |                                                                     |          |         |            |
|           | 7                                          |                                                                     |          |         |            |
|           | 5                                          | Run 7" (2256) water into V-335                                      |          |         |            |
|           | 6                                          | Add                                                                 |          |         |            |
|           | 7                                          | Dump in 4 drums N-120-D from S 4                                    | 2x330    | 57-A    | 660        |
|           |                                            | Note: Remaining N-120-D will be added at S 22                       | 1600     | 120-D   | 1600       |
|           |                                            | Record tare wghts in S 4                                            |          |         |            |

DUP050292118