

Date: 23/07/2022

Sr No	Stages	Parameters	Specifications	Checking Frequency	Observation Time			
					Time am	Reading after addition	Time pm	Reading after addition
1	Degreasing	Pressure	2.0 - 3.0 Kg/cm <sup>2</sup>	Twice / Shift	2.8		2.8	
		Temperature	40-45 °C		44.6		44.9	
		Free Alkali	9 - 12 ml	Twice / Shift	10.0		10.0	
		Total Alkali	18 - 24 ml		19.8		19.9	
		Oil content	< 4.0 gm/litre	Once / 6 month	0.167		0.167	
	Chemical Addition	Bonderite 1523R	For 1 Pointage	8 ltr	8		8	
		Bonderite 1523S	For 1 Pointage	0.8 ltr	0.8		0.8	
2	Water Rinse-I	Pressure	1.0 - 2.0 Kg/cm <sup>2</sup>	Twice / Shift	1.3		1.3	
		Total Alkali	< 5 ml	Twice / Shift	0.6		2.0	
		pH	7.00 - 9.00	Once / Shift	7.5		8.0	
3	Water Rinse-II	Pressure	1.0 - 2.0 Kg/cm <sup>2</sup>	Twice / Shift	1.0		1.0	
		Total Alkali	< 2 ml	Twice / Shift	0.5		0.5	
		pH	7.00 - 9.00	Once / Shift	7.2		7.9	
4	DM Water Rinse - 1	Pressure	1.0 - 2.0 Kg/cm <sup>2</sup>	Twice / Shift	1.5		1.5	
		pH	6.0 - 7.5	Once / Shift	6.0		6.1	
		Conductivity	< 300 µ/cm	Twice / Shift	13.1		19.0	
5	NANO	Pressure	3.0-4.0 Kg/cm <sup>2</sup>	Twice / Shift	3.0		3.0	
		pH	4.5 - 5.5	Twice / Shift	5.0		4.9	
		Zr point	13 - 18ml.	Twice / Shift	14.5		14.3	
	Chemical Addition	Bonderite M-NT2011		0.83 KG/1000 LTR/1 point	-		0.5	
		Bonderite M-AD 700	INCREASE PH	100ML/1000 LTR	350		350	
		Bonderite C-IC 2520	DECREASE PH	100ML/1000 LTR	-		-	
		M-AD 338	FRESH BATH	30ML/1000 LTR	0.6 ml		0.6 ml.	
6	DM Water Rinse -2	Pressure	1.0 - 2.0 Kg/cm <sup>2</sup>	Twice / Shift	1.5		1.5	
		pH	6.0 - 7.5	Once / Shift	6.0		6.1	
		Total Acid	< 5 ml	Twice / Shift	0.2		0.2	
7	DM Water Rinse -3	Pressure	1.0 - 2.0 Kg/cm <sup>2</sup>	Twice / Shift	1.4		1.4	
		pH	6.0 - 7.5	Once / Shift	6.0		6.1	
		Conductivity	<100 µ/cm	Twice / Shift	80		90.8	
9	Water Dry off	Temperature	105°C - 115 °C	Twice / Shift	111.2		113.0	

m.R. Pooj

SIGNATURE OF SUPERVISOR