

C.V. 901, 903.

D.V. 902, 904

CG 32 CODE RT-428-D PKG. _____

EST. WGT. 2332 LBS.

STD. HRS. _____ TIME _____ M

PROCESSES		APPROVED BY	
() RT-428-D	(W)	JJG	07-10-78
() RC-14-A	()	DCG	08-10-78
() RT-139-P	(P)	MW	08-11-78
()	()		
TYPED BY			
emm082178			

NON-BLEEDING

JIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	WATCHUNG® RED B			
	NOTE: Do not start if press will not be available within 3 hrs after Making. Making Supv to review with P.R. Supv & Record: Press will be ready M / P.R. Supv Start Making M / Making Supv			
Prep 1	1 Record: 4 batches since Sparkler last cleaned			
	2 After 5 batches clean, dress Sparkler & pre-coat with 15#		777-A	
	3 Obtain for S 11		740-C	
	4 Obtain for S 40		82-C	
	5 Install DV & CV Recorder & Controller charts			
921/922 2	6 Run 10" (100 G) water into V- 921 & heat to 80-100°F			
	7 Add in 2-3 min		530-A	
	8 Stir 5 min & Record: pH 10.0 (9.5-10.5)	125		125
	9 Stir 20 min or longer to dissolve for S 43			
922 3	10 Run 35" (722 G) water into V-922			
	11 Weigh in V-926 & run in M 2, 50.01 %	432	7-D	216
	12 Turn on agitator & steam & dump in from S 2		740-C	
	Lot #100% %			1107
	129 1107 48.46	1124		
	13 Dump in	25	113-B	25
	14 Dump in	10	777-A	10
	15 Heat to 212-214°F			
	16 Record: BY + (+) If necessary adj to +RY Assume 50%		7-D	
	17 Stir 30 min at 212-214°F then shut off steam			
	18 Circulate 15 min or longer thru Sparkler until 30 min is clear. Maintain at 190-195°F for S 21			
	Record: Start 6:45 P, Total Min 50, Clarity OK			
	HT 195 OF & Rec 196 OF			
Misc 4	19 Measure 98% units in V-928 for S 33 M 1, 31.61 %	1686	28-D	1653
	20 Weigh in PT for S 36 M 1, 32.33 %	1084	725-A	2335
904/905 5	21 Run 1" (G) water into V- 904			
	NOTE: Use CV if MTY. If CV is not available, use V-904			
	22 When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 7:35 P Total Min 25			

JAN 15 1981

S.V.

C.V.

001, 003

MAKING INSTRUCTIONS: BATCH UNIT

D.V. 902, 904

CG 32 CODE RT-428-D PKG.

EST. WGT.

JAN 21 1981

38741

LBS.

STD. HRS.

TIME

7 AM

288

PROCESSES		APPROVED BY
() RT-428-D	(V)	JJG 07-10-78
() RC-14-A	()	DCG 08-10-78
() RT-139-P	(O)	MW 08-11-78
()	()	
TYPED BY		
emw081878		

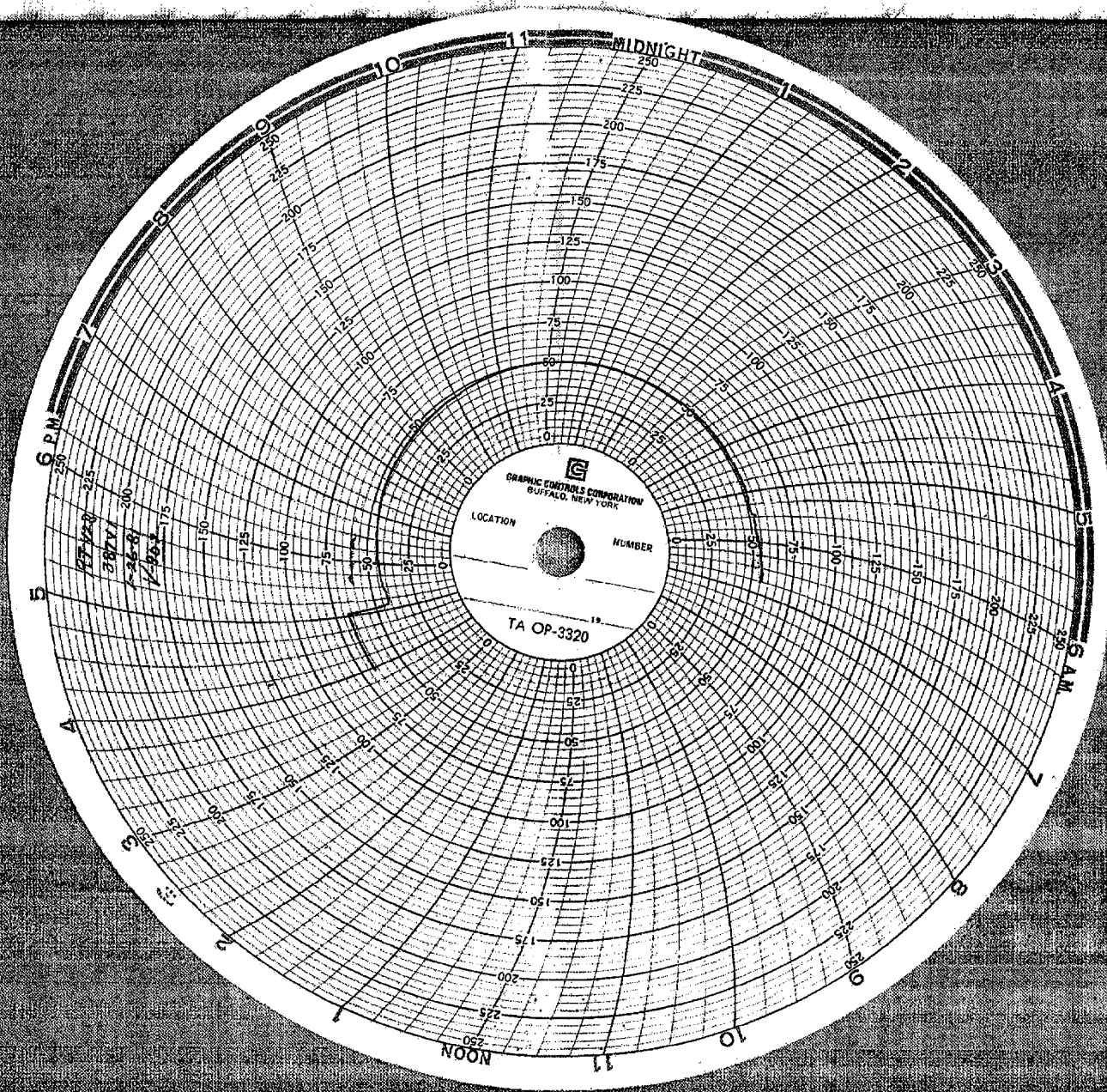
NON-BLEEDING

EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	WATCHUNG® RED B			
	Note: Do not start if press will not be available within 3 hours after making. Making Supv to review with P.R. Supv & Record:			
	Press will be ready M / P.R. Supv			
	Start Making M / Making Supv			
Prep 1	1 Record: batches since Sparkler last cleaned.			
	After 5 batches, clean, dress Sparkler & pre-coat with 15#		777-A	
	2 Obtain for S 11		740-C	
	3 Obtain for S 40		82-C	
	4 Install DV & CV Recorder & Controller Charts			
921/931 2	5 Run 10" (100 G) water into V- & heat to 80-100°F			
	6 Add in 2-3 min	125	530-A	125
	7 Stir 5 min & Record: pH (9.5-10.5)			
	8 Stir 20 min or longer to dissolve for S 43			
922 3	9 Run 35" (722 G) water into V-922			
	10 Weigh in V-926 & run in M , %		7-D	216
	11 Turn on agitator & steam & dump in from S 2		740-C	1107
	Lot #100% %			
	12 Dump in	25	113-B	25
	13 Dump in	10	777-A	10
	14 Heat to 212-214°F Watch Foam			
	15 Record: BY (+) If necessary adj to +BY Assume 50%		7-D	
	16 Stir 30 min at 212-214°F. then shut off steam Watch Foam			
	17 Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 21			
	Record: Start Total Min Clarity			
	HT °F & Rec °F			
Misc 4	18 Measure units in V-928 for S 33 M , %		28-D	533
	19 Weigh in PT for S 36 M , %		725-A	352
904/CV 5	20 Run 1" (G) water into V-			
	Note: Use CV if MTY. If CV is not available use V-904			
	21 When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start Total Min			

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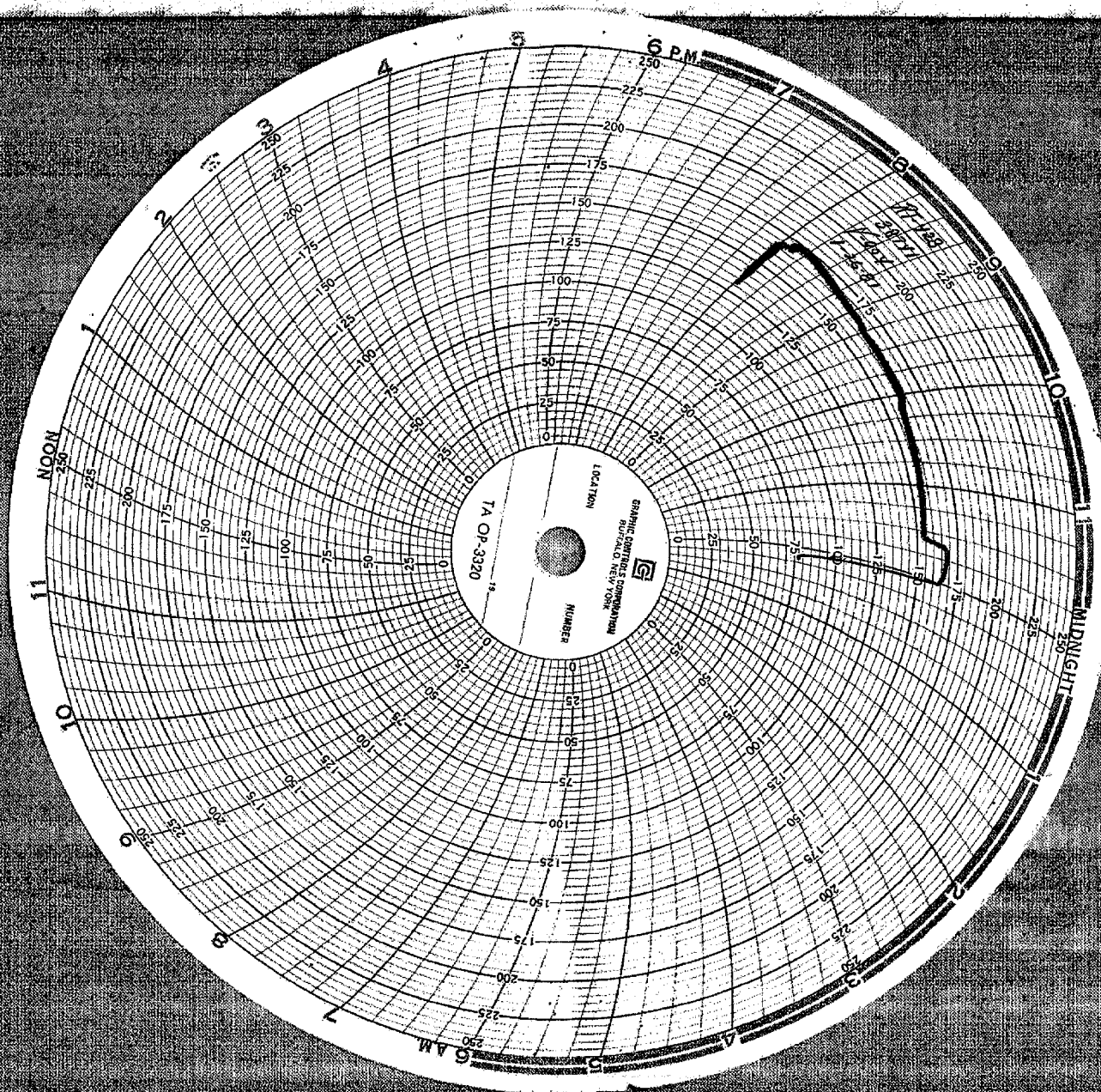
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EQUIPMENT	PAGE	2	CG	CODE	EST. WGT.	LBS.	USE LBS.	N CODE	ACCT LBS.
902 6	22	Run 45" (1300 G) water into V-902					525		525
	24	Dump in & stir to smooth slurry for S 41						542-A	
922 7	25	When S 21 complete, stop pump & insert V-922 foot plug							
	26	Run in 12" (247 G) water & heat to 180-190°F <i>See attached sheet for S 26 & 27</i>							
904/CV 8	27	Pump V-922 thru Sparkler into V-904/CV							
	28	When Mty blow out Sparkler into V-904/CV							
	29	Pour in					60	979-D	60
	30	Heat to 165-170°F							
CV 9		NOTE: If N-740-C sol'n (S's 20 & 21) was pumped directly from Sparkler to CV, omit (S's 31 & 32)							
	31	Run in 1" (95 G) water into V- 901							
	32	Pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min) Maintain 165-170°F in CV							
	33	Run in N-28-D from S 18 in 12-15 min							
	34	Stir 15 min at 165-170°F							
	35	Adj to 34" (3223 G) at 32-38°F					50x330	57-A	1650
	36	Run in N-725-D from S 19 AFAP (5-10 min)							
	37	Stir 20 min at 32-38°F maintaining +CR +KI							
		Record: Time Start <u>4:00 AM</u> , CR <u>+</u> (+), KI <u>+</u> +							
		NOTE:							
		1. If CR-, KI-, add 20# "as is" increments Assume 32%						28-d	
		Record: CR <u>+</u> (+), KI <u>+</u> (+)							
		2. If CR+, KI-, add 20# "as is" increments Assume 33%						725-A	
		Record: CR <u>+</u> (+), KI <u>+</u> (+)							
	38	Dump in					244	246-E	244
	39	Dump in					250	65-A	250
	40	Dump in from S 3 & stir 10 min						82-C	
	43-A	Weigh on Postal scale & dump in					20	36-C	20
902 10	41	Dump into V-902 & stir 203 min					220	165-A	220
CV 11	42	Immediately after S 41 complete, run V-902 thru undersurface distributor into CV in 18-22 min. Let CV temp rise freely							
		Record: Start <u>5:00 AM</u> TOTAL Min <u>2.5</u>							
	43	Immediately after S 42 complete, steam eject V-921/931 into CV							
	44	Stir 30 min & Record: Diazo (-), Base <u>+</u> (+) pH <u>5.4</u> (5.0-6.0) Temp <u>60</u> (50-60°F)							
	45	Weigh in PT and dilute to maximum volume M <u>50.01</u> %					330	7-D	165
		with water							
		Run in PT thru undersurface line							
		If necessary, adj to pH 9.0-9.8							
		As sume 50%						7-D	
		Assume 32%						28-D	
	46	Heat to 173-175°F in 55-65°F min & min & Record: HT <u>173</u>°F							
		Rec <u>172</u>°F							
	49	Stir 60 min at 173-175°F							
		Record: Start <u>6:30 AM</u>							
	50	-Record: pH <u>9.0</u> (8.8-9.3)							
	51	Flood to 180-190" ($\pm$ 18,000 G) & Stop agitator							
	52	When instructed by Processing Area halfway thru pressing dump in & stir 5 min. Stop agitator & resume pressing					10	588-A	10
		11:00 PM							
		START							
		FIN							
		237							
		OPER							



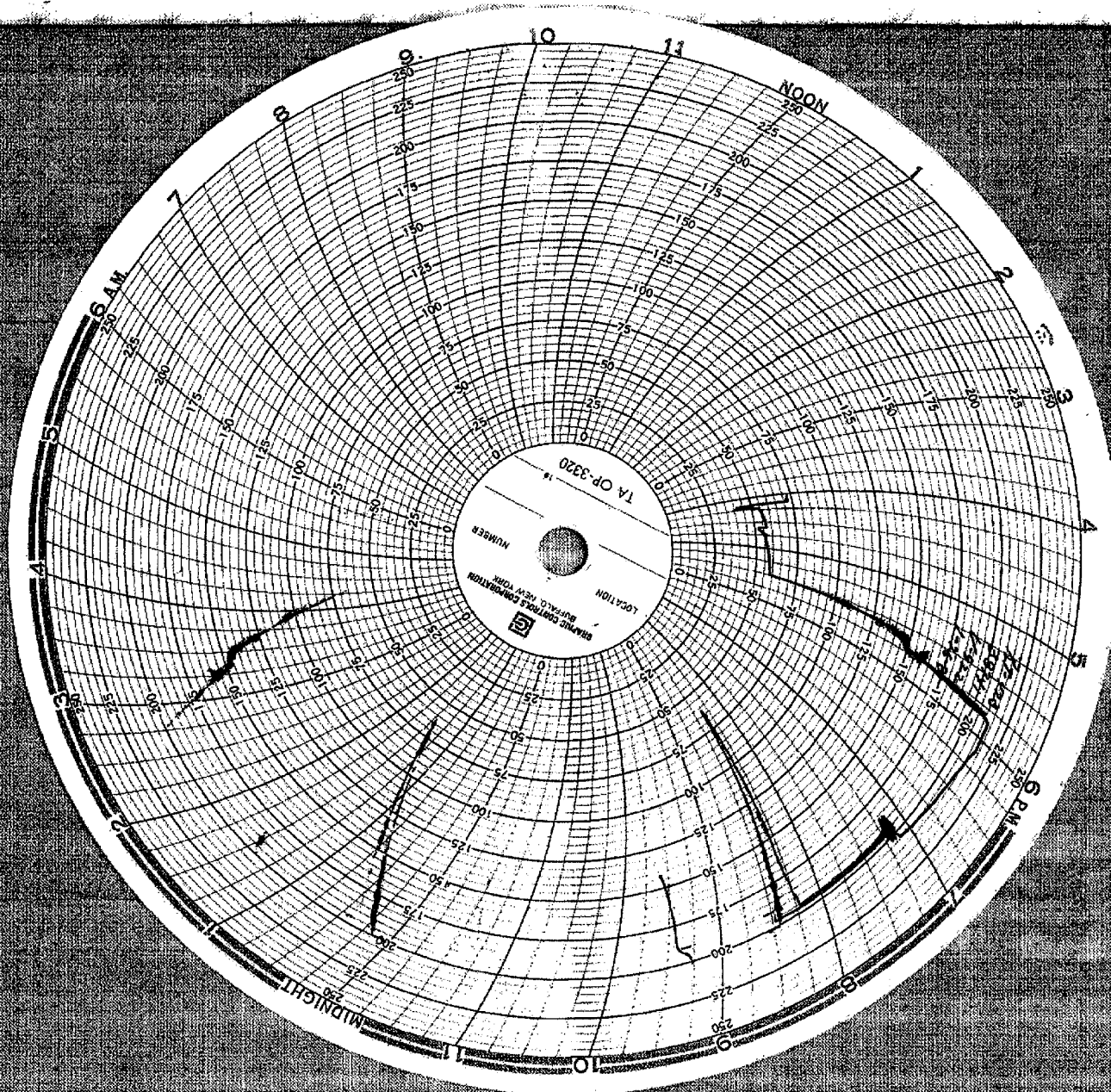
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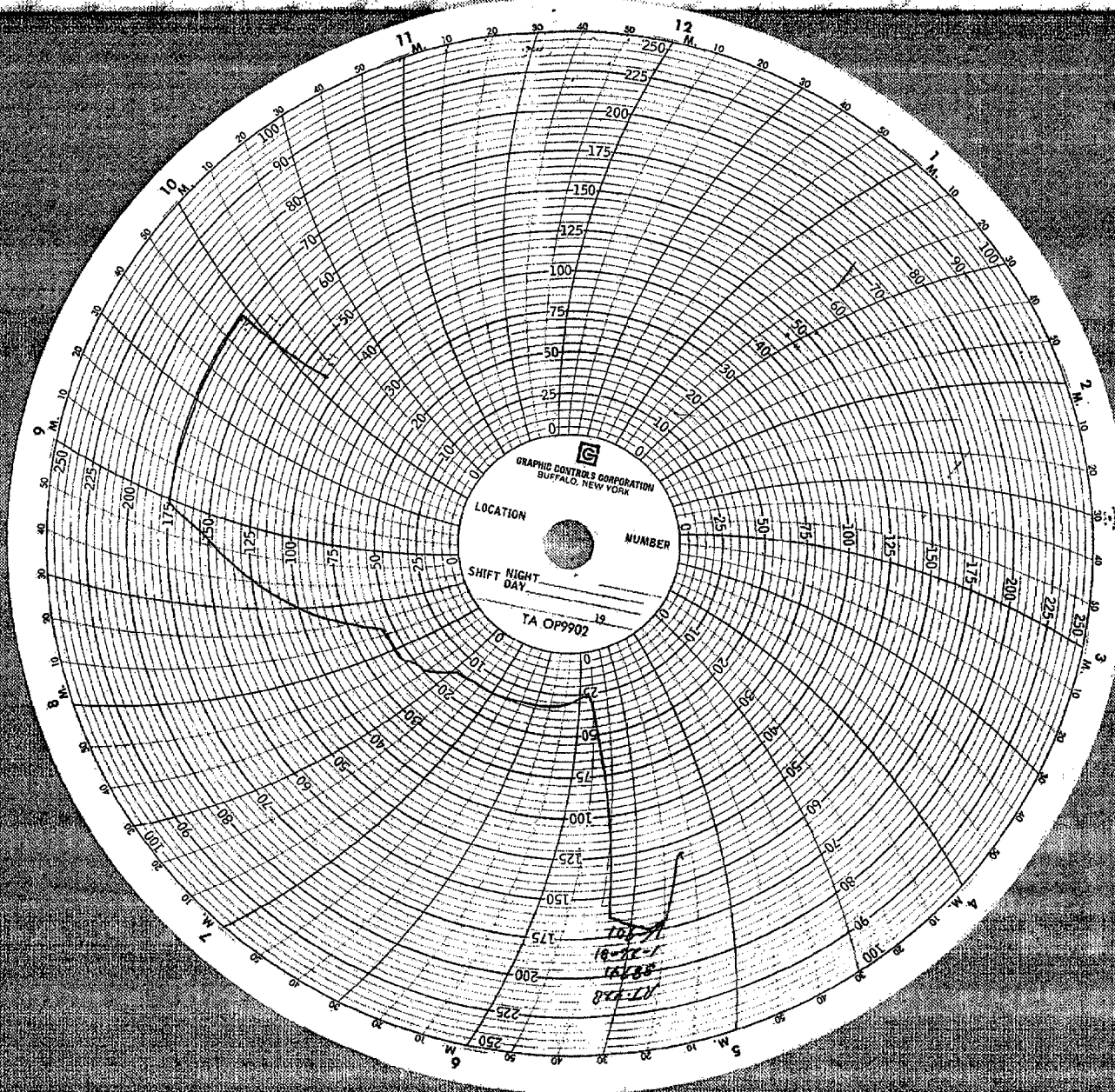
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DUP050292144

N 31804.03



DUP050292145

N 31804.04

EQUIPMENT	PAGE	CG	CODE	EST. WGT.	LBS.	USE LBS.	N CODE	ACCT LBS.
V922	26 A							
RUN IN 10" (206 G) WATER INTO V922 & HEAT TO 190-195°F. CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR. MAINTAIN 190-195°F DURING S-36								
V904	26 B							
PUMP V922 THRU SPARKLER INTO V-904								
V922	27 27A							
RUN 8" (165 GAL) WATER INTO V922 & HEAT TO 190-195°F CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR. MAINTAIN 190-195°F THRU S- 36 27								
V904	27 27B							
PUMP V-922 THRU SPARKLER INTO V-904								
CONTINUE WITH S- 36 28								