CG. 32 CODE RT-761-D PKG. _____

→ MAY -0-81-E1027

EST. WGT. ~~2800~~ 2674 LBS.

STD. HRS. _____ TIME _____ M

PROCESSES		APPROVED BY
( ) RT-761-D	(J)	JJG 4-4-78
( ) RT-838-D	(1)	DCG 4-5-78
( )	( )	MTW 4-13-78
( )	( )	
TYPED BY		
NSA 4-19-78		

NON-BLEEDING

IIPMENT		NAME: WATCHUNG® RED B	USE LBS.	N CODE	ACCT. LBS.
		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: ____ Batches since Sparkler last cleaned.			
		After 5 batches, clean, dress Sparkler & pre-coat with 15#		777-A	
	2	Obtain for S 12		740-C	
	3	Obtain for S 27		82-C	
	4	Install DV & CV Recorder & Controller charts			
921/ 931	5	Run 16" (160 G) water into V-____ & adj to 80-100°F			
	6	Add in 2-3 min	110	99-A	110
	7	Add in 1-2 min	50	530-A	50
	8	Stir 5 min & Record: pH ____ (9.5-10.5)			
	9	Stir 20 min or longer to dissolve for S 30			
922 3	10	Run 35" (722 G) water into V-922			
	11	Weigh in V-926 & run in ____ M ____ %		7-D	216
	12	Turn on agitator & steam & dump in from S 2		740-C	1105
		Lot ____ #100% ____ %			
	13	Dump in	25	113-A	25
	14	Dump in	10	777-A	10
	15	Heat to 212-214°F Watch Foam			
	16	Record: BY ____ must be +. Adj if needed Assume 50%		7-D	
	17	Stir 15 min at 212-214°F, then shut off steam. Watch Foam			
	18	Record: HT ____ F & Rec ____ F			
	19	Circulate 15 min or longer thru Sparkler until sol'n is			
		clear. Maintain at 190-195°F for S 24			
Misc. 1	20	Measure ____ units in V-928 for S 39 ; M ____ , ____ %		28-D	533
	21	Weigh in PT for S 42 M ____ , ____ %		725-A	401
	22	Weigh in drum for S 48		725-A	40
904/CV 5	23	Run 1" (____ G) water into V-____			
		Note: Use CV if MTY. If CV is not MTY, use V-904			
	24	When S 19 complete, pump in V-922 thru Sparkler. Maintain			
		V-922 at 190-195°F. Record: Start ____ Total Min ____			

EQUIPMENT		PAGE 2 CG 32 CODE RT-761-D (J) LBS.	USE LBS.	N CODE	ACCT. LBS.
902 6	25	Run 56" (1566 G) water into V-902			
	26	Weigh in V-926 & run in M %		7-D	682
	27	Dump in from S 3 Lot		82-C	1012
	28	Adj to 70-90°F & stir 10 min to dissolve			
	29	Slurry in 30 Gal water & pour into V-902	100	39-A	100
	30	Steam eject in V-921-931 from S 9			
922 & 904/CV 7	31	When S 24 complete, stop pump & insert V-922 foot plug			
	32	Run in 12" (247 G) water & heat to 180-190°F			
	33	Pump V-922 thru sparkler into V-904/CV			
	34	When V-922 MIY blow out sparkler into V-904/CV			
	35	Weigh & add to V- Lot	18 oz	749-C	1
	36	Heat V-904/CV to 165-170°F for S 39			
		NOTE: If N-740-C solution was pumped directly from sparkler to CV at S's 23 & 24 omit S's 37 & 38			
CV 8	37	Run in 1" (95 G) water into V-			
	38	If V-904 is used, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min) maintain CV at 165-170°F			
	39	Run in N-28-D from S 21 in 12-15 min			
	40	Stir 5 min			
	41	Adj to 43" (4080 G) at 32-38°F	45 x 330	57-A	
	42	Run in N-725-A from S 21 AFAP (5-10 min)			
	43	Stir 10 min at 32-38°F maintaining + CR, + KI			
		Record: Time Start CR (+) KI (+)			
		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 (+)			
	44	Dump in	1116	20-A	1116
	45	Dump in	244	246-B	244
	46	Dump in	130	65-A	130
	47	Add for maintaining 32-38°F during coupling	36x330	57-A	
902 9	48	Pour N-725-A from S 22 into V-902			
	49	Dump in	189	165-A	189
CV 10	50	Immediately couple V-902 thru undersurface distributor into CV in 18-22 min. Maintain CV at 32-38°F			
		Record: Start Total Min			
	51	Stir 5 min & Record: Base (+), Diazo (-)			
		pH (9.0-9.8)			
	52	If necessary, adj to pH 9.0-9.8 Record: pH Assume 50%		7-D	
		Assume 32%		28-D	
	53	Weigh in drum & pour in	45	588-A	45
	54	Heat to 184-186°F in 70-75 min			
	55	Record: HT °F & Rec °F			
	56	Stir 30 min at 184-186°F			
	57	After 10 min S 56 stir, record: pH (8.8-9.3)			
	58	If necessary, adj to pH 8.8-9.3 Assume 50%		7-D	
		Record: pH If pH above 9.3 do not adjust			
	59	When S 56 complete, flood to 180-190" (± 18000 G) & stop agitator			

DUP050098303

EQUIPMENT		PAGE 2 CG 32 CODE RT-880-D (D) EST. WGT. 2516 LBS.	USE LBS.	N CODE	ACCT. LBS.
902	25	Run 60" (1566 G) water into V-902			
6	26	Weigh in V-926 & run in M 7 , 48.79 %	969	7-D	473
	27	Dump in from S 3 Lot		82-C	~~1058~~
		6114	1000		1018
		6122	18		
	27A	Weigh ON Postal Scale & Dump in	40	180C	40
	28	Adj to 70-90°F & stir to dissolve			
922	29	When S 24 complete, shut off pump & insert V-922 foot-plug			
7	30	Run in 18" (209 G) water & heat to 180-190°F - CIRCULATE 15 MIN THRU SPARKLER			
	31A	RUN IN 5" (50 G) WATER INTO V922 - HEAT TO 180-185°F / PUMP V922 THRU SPARKLER			
904/CV	31	Pump V-922 thru Sparkler into V-904/CV CIRCULATE 15 MIN THRU SPARKLER INTO V904/CV			
8	32	When MT blow out Sparkler into V-904/CV			
	33	Dissolve in 20 G water at 150-160°F in drum & pour in	32	133-B	32
	34	Heat V-904/CV to 165-170°F for S 40			
902	35	When S 28 complete, measure in calibrated container,	105	39-A	105
9		slurry with 46 G water in drum & pour into V-902			
	36	Steam eject in V-921/931 from S 8			
PT-2	37	Run into PT-2 M 7 , 48.79%	271	7-D	132
10	38	Adj to 19" (68 G)			
	39	Stir 5 min or longer for S 57			
		NOTE: If N-740-C solution was pumped directly from Sparkler to CV at S's 23 & 24, omit S's 40 & 41			
CV	40	Run 1" (95 G) water into V-			
11	41	If V-904 is used, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min) Maintain 165-170°F			
		Record: Start Total Min			
	42	Run in N-28-D from S 22 in 12-15 min			
	43	Stir 5 min			
	44	Adj to 43" (4080 G) at 32-38°F 55 ~~50~~ x 330		57-A	18150
		Record: Temp 32 °F Stick 45"			
	45	Run in N-725-A from S 19 AFAP (5-10 min)			
	46	Stir 30 min at 32-38°F maintaining +CR, +KI for S 54		57-A	
		Record: Time Start 4:15A CR + (+) KI + (+)			
		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 (+)			
	47	Dump in	1166	20-A	1166
	48	Dump in	255	246-E	255
	49	Dump in	100	65-A	100
	50	Add for maintaining at 32-38°F during coupling	36 x 330	57-A	118 80
	51	Pour in N-725-A from S 20			
902	52	Pour N-725-A from S 21 into V-902			
12	53	Dump in & stir 2-3 min	228	165-A	228
CV	54	Immediately couple 902 thru undersurface distributor into CV			
13		in 18-22 min. Maintain CV at 32-38°F			
		Record: Start 5:30A Total Min 22			
	55	Install 5/16" orifice in undersurface addition line			
	56	When S 54 complete, stir 30 min &			
		Record: Base + (+), Diazo + (+), pH 4.6 (5.0-6.0)			

K13830 REV.

V 901

EQUIPMENT		PAGE 3 CG 32 CODE RT-~~880~~ 261-D (D) EST. WGT. 2516 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV -13 cont'd	57	Run in N-7-D from S 39 thru 5/16" orifice			
		Record: 40 Min (40-50 min)			
	58	Stir 20 min & Record: pH 6.5 (7.0-8.5)			
	59	If pH below 7.0 adj to pH 7.0-8.5 with N-7-D only Assume 50%	30	7-D	13
		Record: pH 7.0			
	60	Weigh in V-926 & run in Assume 50%	110	7-D	55
	61	Stir 15 min & Record: Base + (+), Diazo — (-),			
START 6:39A		pH 9.5 (9.0-9.8)			
	62	If pH below 9.0, adj to pH 9.0-9.8 with N-7-D only Assume 50%	—	7-D	—
		& Record: pH —			
	63	Measure in calibrated container & pour in	35	588-A	35
	64	Heat to 193-195°F in 75-80 min Start 7:45 AM			
	65	Record: HT 193 °F & Rec 195 °F			
	66	Stir 60 min at 193-195°F Record: Start 8:50 AM			
	67	After 20 min S 66 stir Record: pH 8.4 (8.8-9.3)			
	68	If pH 8.8, adj to pH 8.8-9.3 with N-7-D only Assume 50%	30	7-D	15
		Record: pH 8.8			
	69	When S 66 complete, flood to 180-190" (±18,000 G)			
	70	Stop agitator			
		When instructed by Processing Area halfway thru Pressing			
		1. Dump in	10	588-A	10
		2. Stir 5 min			
		3. Advise Processing to resume Pressing			

START	FINISH	OPTR
11:P.M.	7:A.M	54
7:00 AM	10:00 AM	237

K 13830 REV.

DUP050098305

MAKING INSTRUCTIONS: BATCH UNIT

S.V. C.V. 901,903 D.V. 902,904

CG 32 CODE RT-761-D PKG.

→

EST. WGT. 2014 LBS.

STD. HRS. 7.9 TIME M

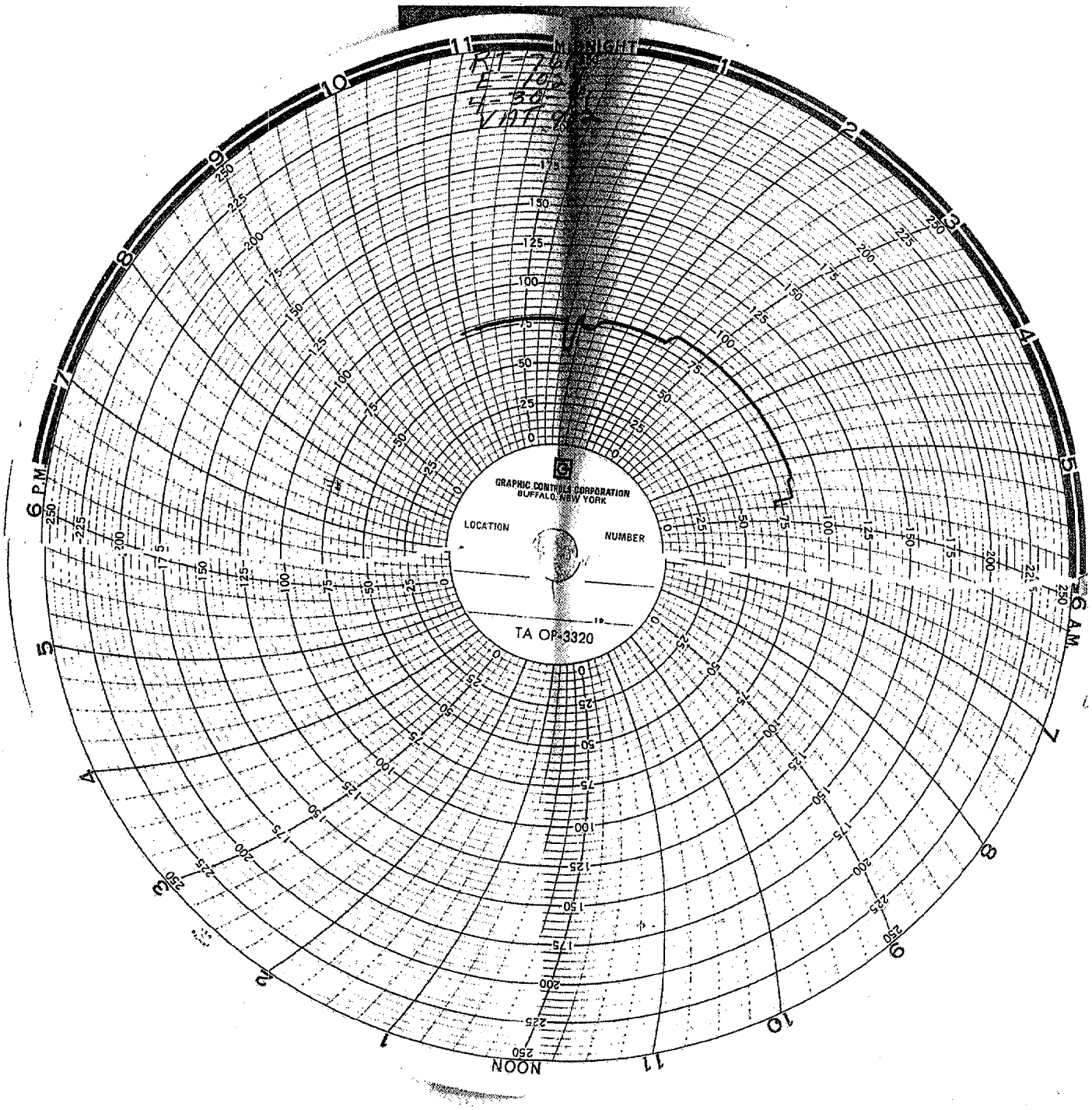
PROCESSES		APPROVED BY
( ) RT-761-D	(I)	JJG 3-3-75
( ) RT-838-D	(H)	DCG 3-3-75
( )	( )	MTW 3-4-75
( )	( )	
TYPED BY		
NSA 3-19-75		

NON-BLEEDING

EQUIPMENT		NAME: "WATCHUNG" RED B	USE LBS.	N CODE	ACCT. LBS.
		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	If necessary, clean, dress Sparkler & pre-coat with 15#		777-A	
	2	Obtain for S 12		740-C	
	3	Obtain for S 28		82-C	
	4	Install DV & CV Recorder & Controller charts			
921/ 931 2	5	Run 8" (80 G) water into V- & Adj to 80-100°F			
	6	Add in 1-2 Min	80	99-A	80
	7	Add in 1-2 Min	40	530-A	40
	8	Stir 5 Min & Record: pH (9.5-10.5)			
	9	Stir 20 Min or longer to dissolve for S 31			
922 3	10	Run 28" (527 G) water into V-922			
	11	Weigh in V-926 & run in M , %		7-D	165
	12	Turn on agitator & steam & dump in from S 2 Lot #100% %		740-C	845
	13	Dump in	25	113-A	25
	14	Dump in	10	777-A	10
	15	Heat to 212-214F Watch Foam			
	16	Record: BV , must be + Assume 50%		7-D	
	17	Stir 15 min at 212-214F, then shut off steam. Watch Foam			
	18	Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195F for S 23 Record: Start Total Min Clarity			
	19	Record: HT F & Rec F			
CV 4	20	Run 5" (455 G) water into V-			
	21	Measure units in V-928 & run in M , %		28-D	407
904	22	Run 2" (58 G) water into V-904			
	23	When S 18 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195F. Record: Start Total Min			

K 13829 REV.

DUP050098306



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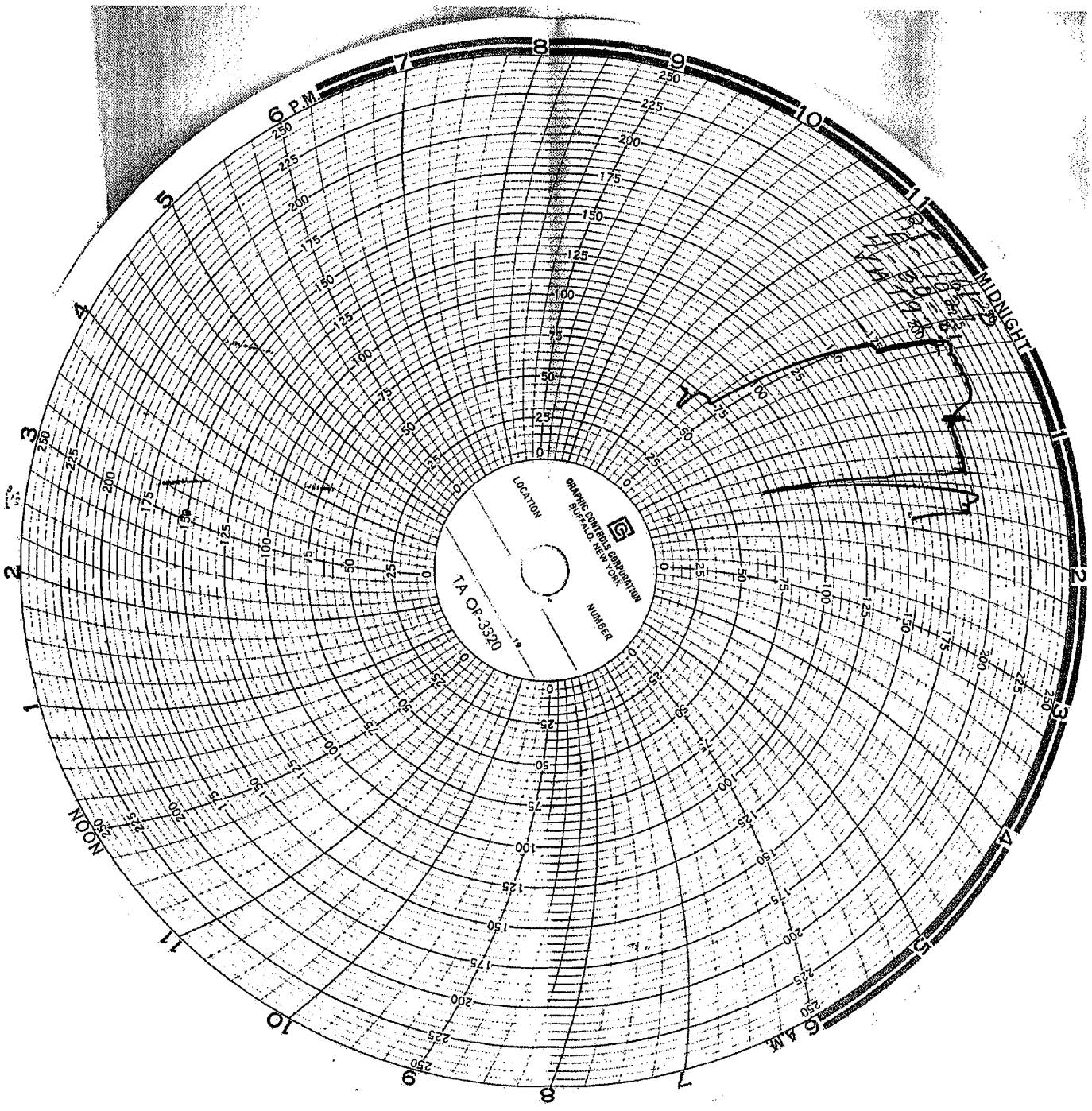

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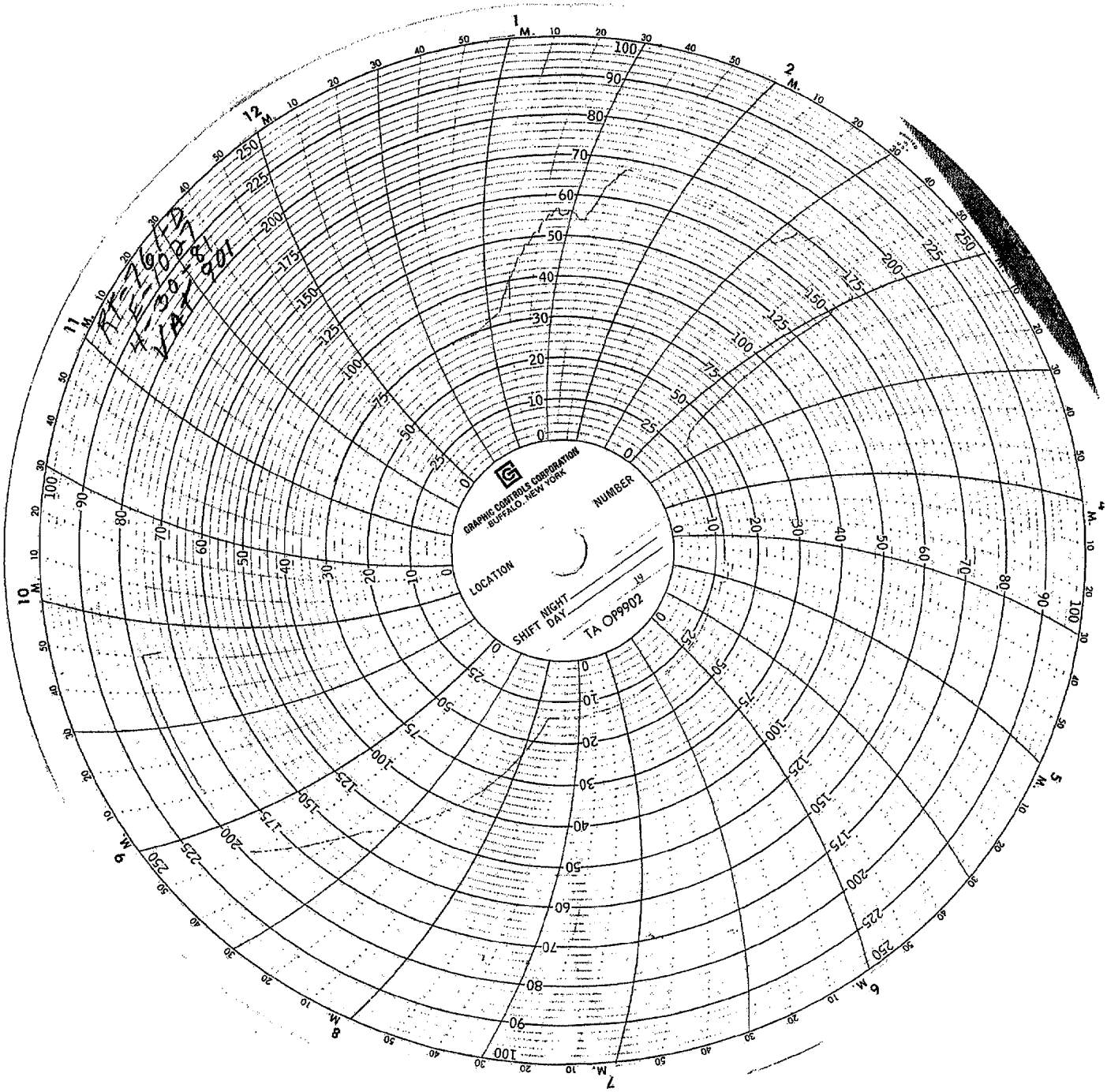

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