S.V. C.V. 902, 903 MAKING INSTRUCTIONS: BATCH UNIT

D.V. 904

CG 32 CODE RT-618-D PKG. 1

→ NOV 10 80 37798

EST. WGT. 2902 LBS.

STD. HRS. 10.4 TIME 7A PUNCHED & CHECKED

PROCESSES		APPROVED BY
(0) RT-618-D	(S)	JJG 08-15-78
(1) RT-657-P	(F)	AMJ 09-19-78
( )	( )	
( )	( )	
TYPED BY		
amw092078		

NOV 10 1980

NON-BLEEDING

EQUIPMENT		NAME: WATCHUNG® RED Y	USE LBS.	N CODE	ACCT. LBS.
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 24		253-C	
	4	Install DV & CV Recorder & Controller charts			
921/ 931 2	5	Run 10" (100 G) water into V-921 & adj to 80-100°F			
	6	Add in 1-2 min	63	530-A	63
	7	Stir 2 min & Record: pH 10.0 (9.5-10.5)			
	8	Stir 20 min or longer for S 27			
922 3	9	Run 31" (700 G) water into V-922			
	10	Weigh in V-926 & run in M 12, 49.92 %	201	724-D	201
	11	Turn on agitator & steam & dump in from S 2		740-C	1035
		Lot 100% %			
		109 322 98.97	325		
		110 644 99.04	650		
		111 69 98.82	70		
	12	Dump in	50	113-B	50
	13	Dump in	10	777-A	10
	14	Heat to 212-214°F. Record: HT 214°F; 215 °F WATCH FOAM			
	15	Record: BY 7 (+), if necessary, adj to +BY Assume 50%		724-D	
	16	Stir 30 min at 212-214°F, then shut off steam WATCH FOAM	16A Record:		
	17	Circulate 15 min or longer thru Sparkler until sol'n is clear	Sparkler Pressure		
		Maintain at 190-195°F for S 19 & Record: HT 192 °F	0 PSI		
		& Recorder 194 °F	If not zero, notify		
		Record: Start 9:15A Total Min 50 Clarity OK	Supervisor		
		NOTE: Sample from hose - show to Supervisor for OK OK			
904 4	18	Run 1" (50 G) water into V-904			
	19	When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 10:05A Total Min 25			
Misc 5	20	Weigh in PT for S 35 M 12, 33.16 %	168	725-A	332
	21	Measure 55 units in V-928 for S 33 M 10, 31.35 %	173	28-D	419
CV 6	22	Run 16" (1530 G) water into V-903			
	23	Weigh in V-926 & run in M 12, 49.92 %	507	724-D	507
	24	Dump in from S 3 Lot		253-C	905
		500	900		912
		499	12		
	25	Weigh on postal scale & dump in Lot			
	26	Adjust to 70-90°F & stir to dissolve			
	27	Steam eject V-921/931 into CV			

N37509

EQUIPMENT		PAGE 2 CG 32 CODE RT-618-D (S) EST. WGT. 2902 LBS.	USE LBS.	N CODE	ACCT. LBS.
922 7	28	When S 19 complete, shut off pump & insert V-922 foot plug			
	29	Run in 10" (247 G) water & heat to ~~180-190°F~~ 190-193F CIRCULATE THRU SPARKLER until clear - Pump V922 THRU Sparkler into V904			
904 8	30	~~Pump V-922 thru Sparkler into V-904~~ See attached page for S 30			
	31	When MTY blow out Sparkler into V-904			
	32	Heat to 165-170°F (Sample & show to Supervisor for O K)			
	33	Run in N-28-D from S 21 in 12-15 min & stir 5 min at 165-170°F	45		
	34	Adj to 129" (3409 G) at 28-30°F & Record: Temp 29 °F	42 x 330	57-A	14,850
	35	Run in N-725-A from S 20 AFAP (5-10 min)			
	36	Stir 10 min at 28-35°F maintain +CR, +KI for S 41			
		Record: Time Start 1:10 P.M, CR T (+), KI T (+)			
		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 (+) Temp °F			
CV 9	37	Dump into CV	35 180	65-A	180
	38	Adj to 37" (3496 G) at 28-32°F	~~34~~ x 330	57-A	11,550
		Record: Temp 28 °F Volume 37 "			
	39	Weigh in from drum	239	165-A	239
	40	Stir 2-3 min			
	41	Immediately couple DV thru undersurface distributor into CV in 45-60 min. Maintain CV at 28-32°F		57-A	
		Record: Start 1:35 Total Min 55			
	42	Stir 5 min & Record: Base T (+), Diazo — (-),			
		Final Temp 30 °F, pH 9.5 (9.0-9.8)			
	43	If necessary, adj to pH 9.0-9.8 ~~Assume 60%~~		728-D	
		& Record: pH Assume 32%		28-D	
	44	Heat to ~~180-185~~°F in 65-70 min &			
		Record: HT 182 °F & Recorder 180 °F			
DV 10	45	Run 22 " (600 G) water into DV			
	46	Turn on agitator & steam & dump in	1620	16-B	1620
	47	Heat to 155-160°F & stir to dissolve			
CV 11	48	When S 44 complete, immediately strike DV thru undersurface distributor into CV in 7-10 min. Maintain CV at ~~175-180~~F 180-182F			
		Record: Start 4:50 P.M Total Min 12			
	49	Heat CV to 198-202°F in 10-12 min			
	50	Stir 5 min at 198-202°F			
	51	Flood to 180-190" (±18,000 G)			
	52	Record: pH 8.8 (9.0-9.4) & stop agitator SAMPLE			
		START FIN OPTR			
		7:10 A.M 3:10 P.M 5:25 P.M. 27 381			
		When instructed by Processing Area half way thru pressing, dump in & stir 5 min & stop agitator. Resume pressing	10	588-A	10

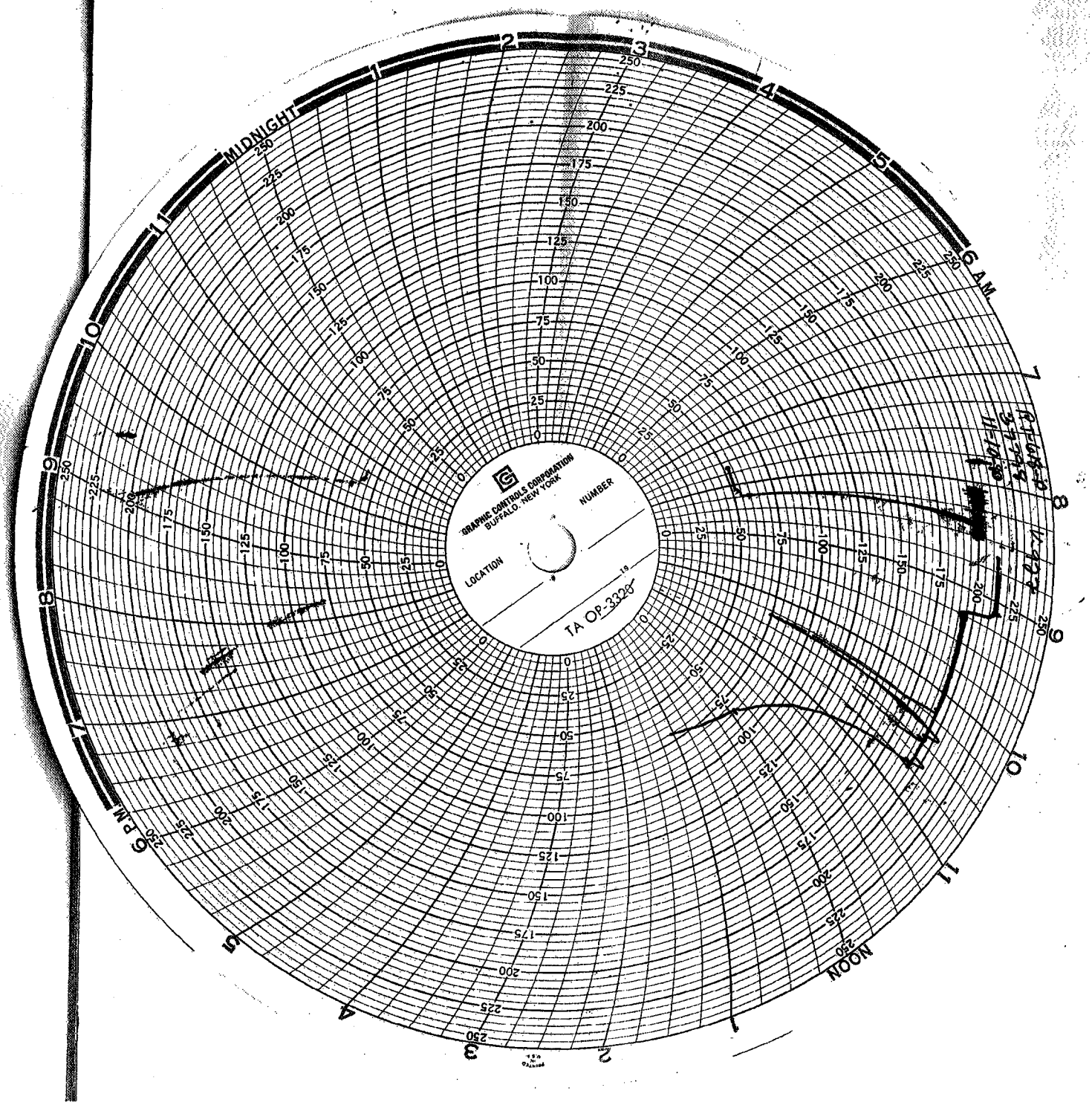
DUP050043832

THRU S-32A

V904 PUMP V-922 THRU SPARGER INTO V-904

CONTINUE WITH S-31

DUP050043833



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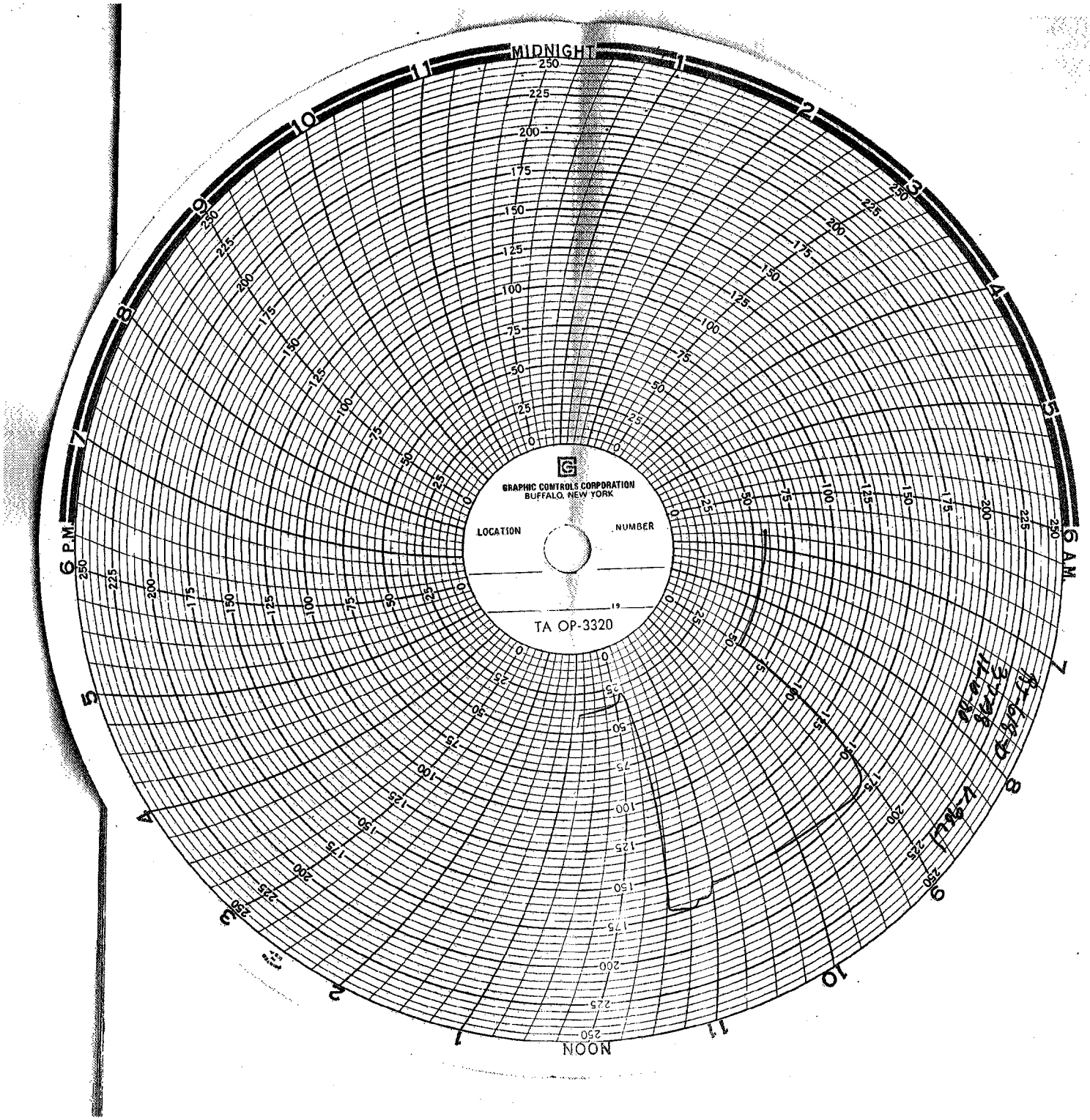

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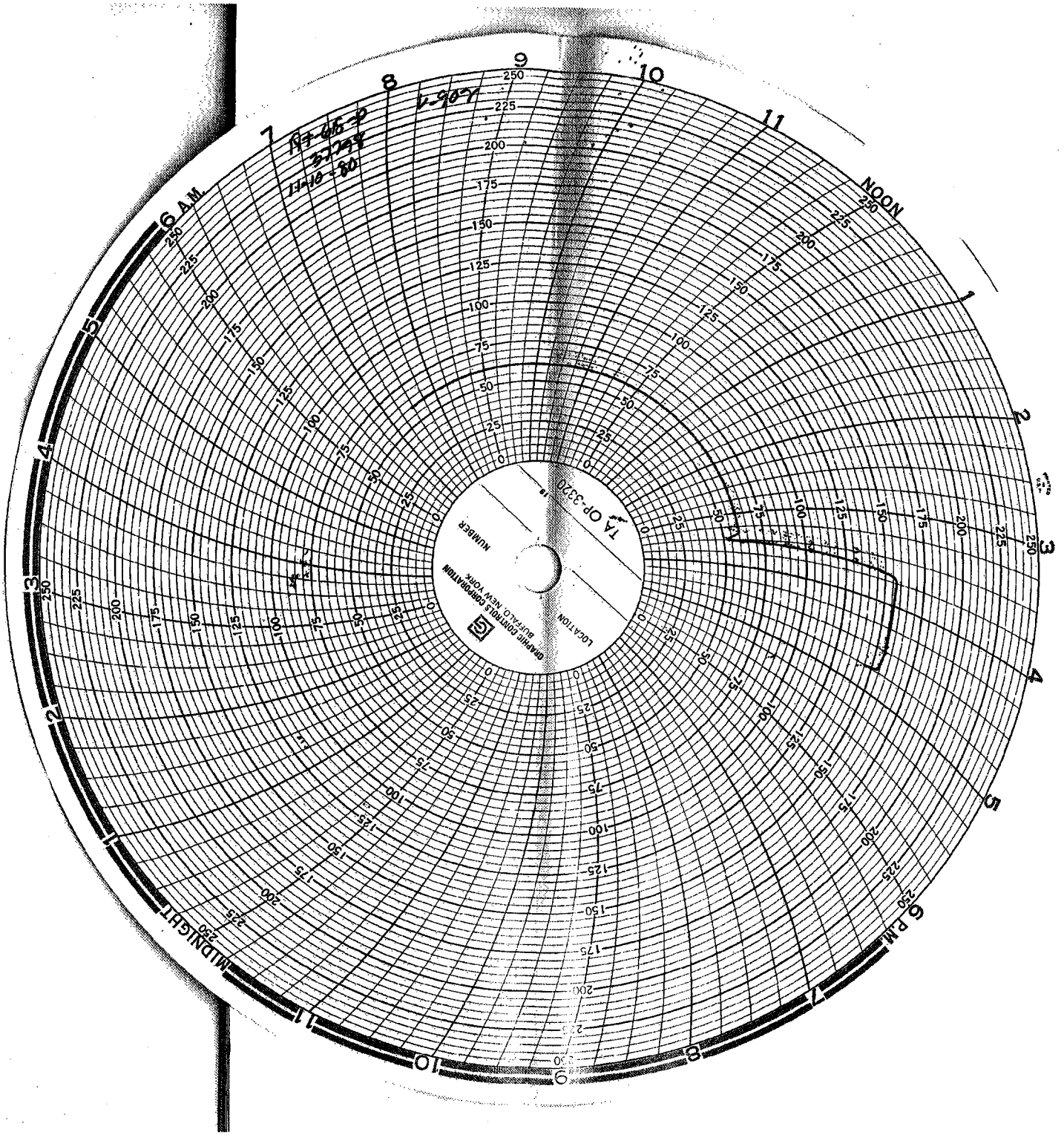

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