

C.V. 901, 903

D.V. 902, 904

G 32 CODE RT-867-D

PKG.

EST. WGT.

2470

LBS.

STD. HRS.

9.5

TIME

M

PROCESSES		APPROVED BY	
() RT-867-D	()	JJG 6/18/75	
()	()	DCG 6/25/75	
()	()	MW 6/26/75	
()	()		
TYPED BY			
emw 072275			

NON-BLEEDING

SHIPMENT	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 PR Supv Start Making M Making Supv			
REP 1	1 If necessary, clean, dress Sparkler & precoat with 15#		777-A	
	2 Obtain for S 7		740-C	
	3 Obtain for S 24		82-C	
	4 Install DV & CV Recorder & Controller charts			
27	5 Run 35" (722 G) water into V-922			
	6 Weigh in V-926 & run in M 8, 49.83% 11.51		7-D	226
	7 Turn on agitator & steam & pump in from S 2		740-C	1157
	Lot 100% 199 1157 99.2 11.66			
	8 Dump in	25	113-A	25
	9 Dump in	10	777-A	10
	10 Heat to 212-214°F Watch Foam			
	11 Record: BY +, must be + Assume 50% 7-D			
	12 Stir 30 min at 212-214°F, then shut off steam Watch Foam			
	13 Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 18			
	Record: Start 7:00 AM Total Min 70 Clarity Out			
	14 Record: HT 195°F & Rec 195°F			
V 3	15 Run 6" (569 G) water into V-903			
	16 Measure 9.42 units in V-928 & run in + 8.5# 10 Pumping M 2, 32.00% 17.44		28-D	558
04 4	17 Run 2" (58 G) into V-904			
	18 When S 13 complete, pump in V-922 thru Sparkler			
	Maintain V-922 at 190-195°F			
	Record: Start 8:12 AM Total min 30			
JSC	19 Weigh in PT for S 33 M 7, 32.93% 11.37		725-A	375
	20 Weigh in drum for S 38 M 7, 32.93% 10.0		725-A	33
	21 Weigh in drum for S 39 M 7, 32.93% 10.0		725-A	33

JM

DATE PRINTED: 5/07/81

S.V.

MAY 06 1981

C.V. 901, 903

D.V. 902, 904

CG 32 CODE RT-867-D PKG ---

PROCESSES

APPROVED BY

MAY -0-81-21386

() RT-867-D ()

JJG 4/1/81

(DATE) (LOT NUMBER)

() ALTERNATE ()

() ()

TYPED BY: JMH

ESTIMATED WGT 2470 LBS.

STANDARD HRS. ---

TIME --- M

PREPARATION NOTES:

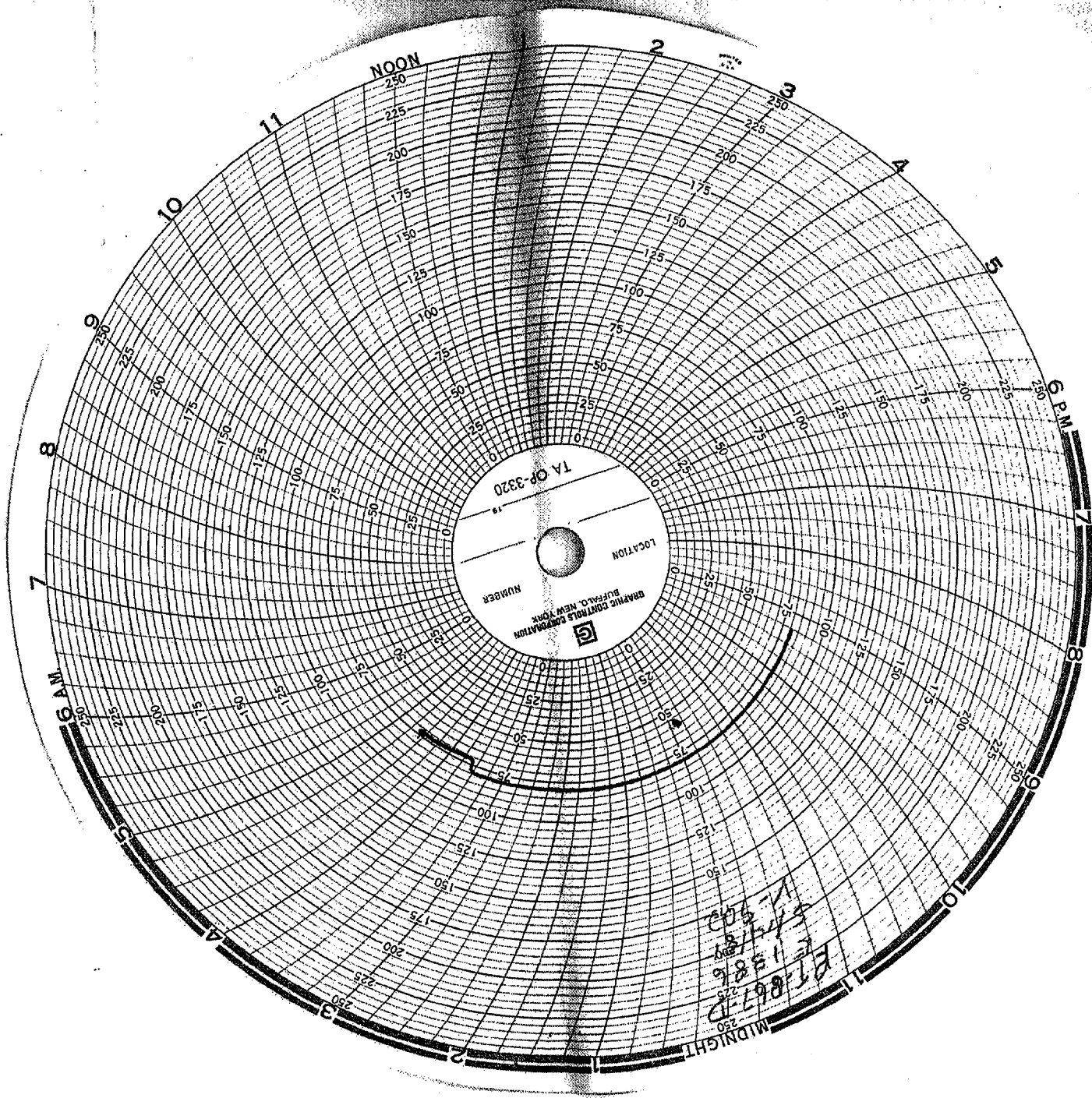
EQUIP MENT		NAME: WATCHUNG RED B	USE LBS	N-CODE	ACCT LBS
		NOTE: DO NOT START IF PRESS WILL NOT BE AVAILABLE WITHIN 3 HRS AFTER MAKING. MAKING SUPVR TO REVIEW WITH P.R. SUPV & RECORD: PRESS WILL BE READY --- M --- PR SUPVR START MAKING --- M --- MAKING SUPV ---			
		NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V-922			
PREP 1	1	IF NECESSARY, CLEAN, DRESS SPARKLER & PRE- COAT WITH 15#		777-A	
	2	OBTAIN FOR S7		740-C	
	3	OBTAIN FOR S24		82-C	
	4	INSTALL DV & CV RECORDER & CONTROLLER CHART			
922 2	5	RUN 35: (722G) WATER INTO V-922			
	6	WEIGH IN V-926 & RUN IN M --- %		7-D	206
	7	TURN ON AGITATOR & STEAM & PUMP IN FROM S2 LOT 100% %		740-C	1054

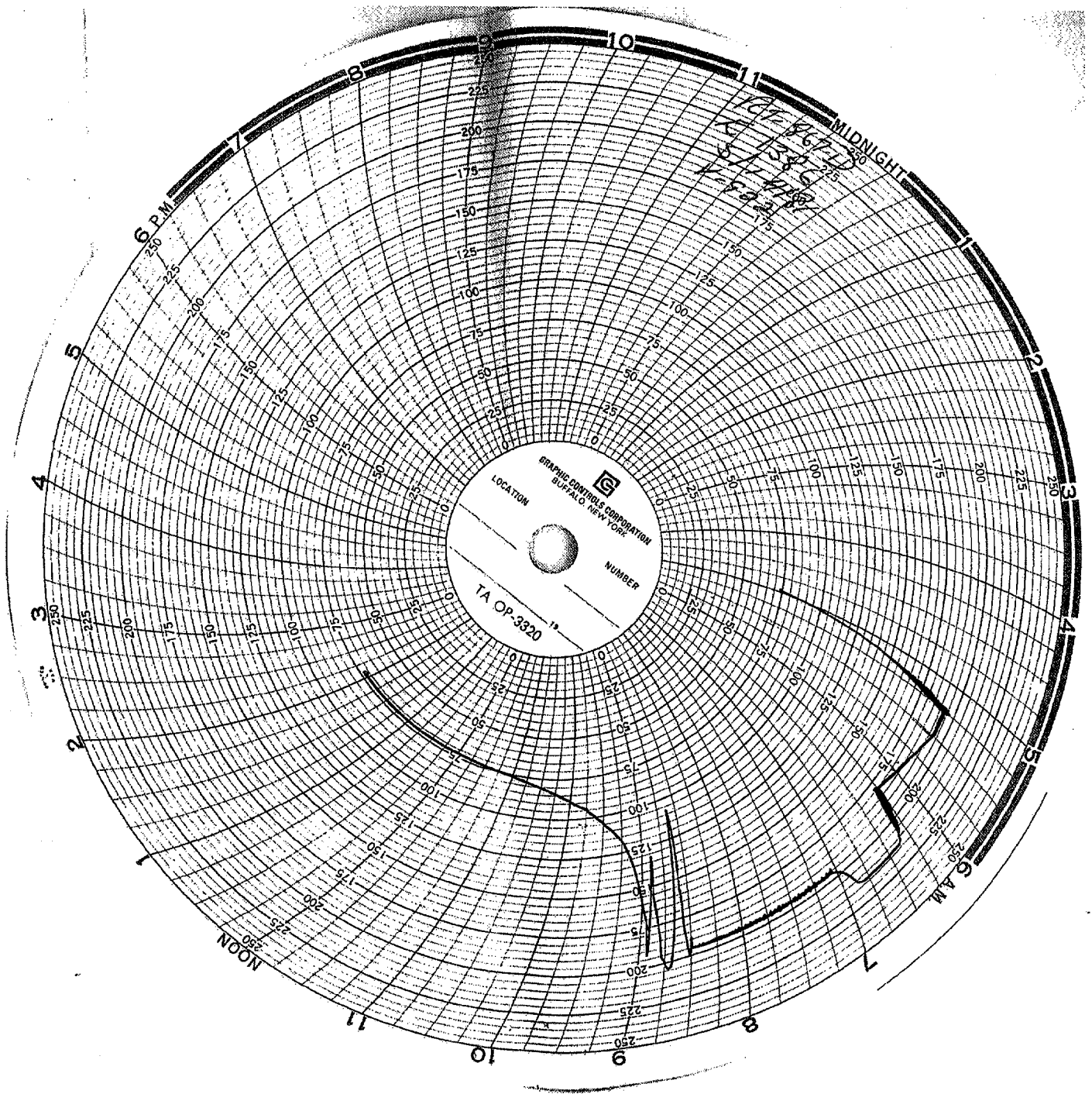
	8	DUMP IN	25	113-A	25
	9	DUMP IN	10	777-A	10
	10	HEAT TO 212-214 DEG F WATCH FOAM			
	11	RECORD: BY ---, MUST BE + ASSUME 50%		7-D	
	12	STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM			
		RECORD: SPARKLER PRESSURE --- PSI. IF NOT ZERO, NOTIFY SUPERVISOR			
	13	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 F			
		FOR S18 RECORD: START ---			
		TOTAL MIN --- CLARITY ---			
	14	RECORD: HT --- DEG F & REC --- DEG F			

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 2 OF 3 CG 32 CODE RT-867-D (D)	USE LBS	N-CODE	ACCT LBS
CV 3	15 16	RUN 6" (569G) WATER INTO V- MEASURE _____ UNITS IN V-928 & RUN IN M _____ %		28-D	508
904 4	17 18	RUN 2" (58G) INTO V-904 WHEN S13 COMPLETE, PUMP IN V-922 THRU SPARKLER MAINTAIN V-922 AT 190-195 DEG F RECORD: START _____ TOTAL MIN _____			
MISC 5	19 20 21	WEIGH IN PT FOR S33 M _____ % WEIGH IN DRUM FOR S38 M _____ % WEIGH IN DRUM FOR S39 M _____ %		725-A 725-A 725-A	342 30 30
DV 6	22 23 24	RUN 56" (1566G) WATER INTO V- WEIGH IN V-926 & RUN IN M _____ % DUMP IN FROM S3 LOT _____		7-D 82-C	495 964
	25	ADJ TO 70-90 DEG F & STIR 10 MIN OR LONGER TO DISSOLVE FOR S39			
922 7	26 27A	WHEN S18 COMPLETE, STOP PUMP & INSERT V-922 FOOT PLUG RUN IN 10" (209G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904 8	27B	PUMP THRU SPARKLER INTO V-904			
922 9	28A	RUN IN 5" (104G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904 10	28B 29 30	PUMP V-922 THRU SPARKLER INTO V-904 WHEN MT BLOW OUT SPARKLER INTO V-904 HEAT TO 165-170 DEG F			
CV 11	31 32 33 34 35 36 37 38	WHEN S30 COMPLETE, PUMP V-904 AT 165-170 F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (12-15 MIN) RECORD: START _____ TOTAL MIN _____ ADJ TO 43" (4080G) AT 32-38 DEG F RUN IN N-725-A FROM S19 AFAP (5-10 MIN) & STIR 20 MIN AT 32-38 F MAINTAINING +KI M _____ % RECORD: KI _____ (+) DUMP IN DUMP IN ADJ TO 90" (8532G) & ADD TO MAINTAIN CV AT 32-38 DEG F POUR IN N-725-A FROM S20	46X330 714 50 30X330	57-A 57-A 725-A 20-A 65-A 57-A	 714 50

INSTRUMENT	PAGE 2 CG 32 CODE RT-867-D (D) EST. WGT. 2250 LBS.	USE LBS.	N CODE	ACCT. LBS.
	22 Run 56" (1566 G) water into V-902			
	23 Weigh in V-926 & run in	M 8 47.83 %	1070	7-D 543
	24 Dump in from S 3	Lot	82-C	1058
		6191	505	
		6199	505	
		6174	98	
	25 Adj to 70-90°F & stir 10 min or longer to dissolve for S 39			
2	26 When S 18 complete, stop pump & insert V-922 foot plug			
7	27 Run in 15" (309 G) water & heat to 190-195°F. CIRCULATE 15 MIN THRU SPARKLER			
14	28 Run in 10" (205 G) WATER IN V-922 & HEAT TO 190-195°F. Pump V-922 THRU SPARKLER			
8	29 Pump V-922 thru Sparkler into V-904			
	30 Heat to 165-170°F			
9	31 When S 30 complete, pump V-904 at 165-170°F thru under-surface distributor into CV AFAP (12-15 min)			
	Record: Start 9:10 Total Min 15	72	57-A	23762
	32 Adj to 43" (4080 G) at 32-38°F	10 X 330	57-A	
	33 Run in N-725-A from S 19 AFAP (5-10 min) and		57-A	
	Stir 30 min at 32-38°F maintaining +K M	%	725-A	
	34 Record: KI + (+)			
	35 Pump in	784	20-A	784
	36 Pump in	55	65-A	55
	37 Adj to 90" (8532 G) & add to maintain CV at 32-38°F	33 X 330	57-A	10,890
	38 Pump in N-725-A from S 20			
	39 Pour N-725-A from S 21 into DV			
	40 Weigh in from drum	261	122-D	261
V	41 Immediately couple DV thru undersurface distributor into			
11	CV in 18-22 min. Maintain CV - 32-38°F		57-A	
	Record: Start 12:00 Total min 25			
	42 Stir 30 min			
	43 Record: Base + (+), Diazo - (-), pH 9.2 (9.0-9.8)			
	44 Adj to pH 9.0-9.2 Record: pH	Assume 50%	7-D	
		M	28-D	
T	45 Run 170 G water into PT			
12	46 Dump in	200	16-B	200
	47 Heat to 155-160°F & stir to dissolve for S 48			
V	48 When S 47 complete, run PT into CV			
13	49 Measure in calibrated container & pour in	35	588-A	35
	50 Heat to 193-195°F in 75-80 min			
	51 Record: HT 190 °F & Rec 192 °F			
	52 Stir 60 min at 193-195°F			
	53 After 20 min S 52 stir Record: pH 8.4 (8.2-8.6)			
	54 When S 52 complete, flood to 180-190" (±18,000 G) & stop agitator			
	START 4:45 AM	FIN 7:00 AM	OPTR 174	
	3:00 PM	3:00 PM	342	
		5:30 PM	409	





DUP050098237

MAKING INSTRUCTIONS: BATCH UNIT

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EST. WGT. 2470 LBS.STD. HRS. 9.5 TIME _____ M

PROCESSES		APPROVED BY
() RT-867-D	()	JJG 6/18/75
()	()	DCG 6/25/75
()	()	MW 6/26/75
()	()	
TYPED BY		
emw 072275		

NON-BLEEDING

SHIPMENT	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 _____ PR Supv Start Making _____ M _____ Making Supv			
REP 1	1 If necessary, clean, dress Sparkler & precoat with 15#		777-A	
	2 Obtain for S 7		740-C	
	3 Obtain for S 24		82-C	
	4 Install DV & CV Recorder & Controller charts			
922	NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V922			
	5 Run 35" (722 G) water into V-922			
	6 Weigh in V-926 & run in _____ M <u>8</u> , <u>49.83</u> %		7-D	226
	7 Turn on agitator & steam & pump in from S 2		740-C	1157
	Lot <u>199</u> 100% % <u>99.2</u>			
	8 Dump in	25	113-A	25
	9 Dump in	10	777-A	10
	10 Heat to 212-214°F			
	11 Record: BY <u>+</u> , must be + Watch Foam Assume 50%		7-D	
	12 Stir <u>30</u> min at 212-214°F, then shut off steam Watch Foam			
	13 Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 18			
	Record: Start <u>5:15 AM</u> Total Min <u>15</u> Clarity <u>ok</u>			
	14 Record: HT <u>190</u> OF & Rec <u>195</u> OF			
3	15 Run 6" (569 G) water into V- <u>903</u>			
CV	16 Measure _____ units in V-928 & run in		28-D	558
	<u>160</u> UNITS MEASURED _____ M <u>2</u> , <u>32.00</u> %			
4	17 Run 2" (58 G) into V- <u>903</u>			
903	18 When S 13 complete, pump in V-922 thru Sparkler			
	Maintain V-922 at 190-195°F			
	Record: Start <u>5:30 AM</u> Total min <u>40</u>			
1152	19 Weigh in PT for S 33 _____ M <u>7</u> , <u>32.93</u> %		725-A	375
5	20 Weigh in drum for S 38 _____ M <u>7</u> , <u>32.93</u> %		725-A	33
	21 Weigh in drum for S 39 _____ M <u>7</u> , <u>32.93</u> %		725-A	33

DUP050098238