

S.V.

C.V. 901, 903

D.V. 904

CG 32 CODE RT-618-D PKG

PROCESSES

APPROVED BY

MAY -0.81-21561
(DATE) (LOT NUMBER)() RT-618-D (S)
() ALTERNATE ()
() ()

JJG 3-18-81

TYPED BY: JMH

ESTIMATED WGT 2902 LBS. STANDARD HRS. TIME M

PREPARATION NOTES:

Presort Sparkler

EQUIP MENT	NAME: WATCHUNG RED Y	USE LBS	N-CODE	ACCT LBS
PREP 1	1 RECORD: 0 BATCHES SINCE SPARKLER LAST CLEANED. AFTER 5 BATCHES, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15#	15	777-A	15
	2 OBTAIN FOR S11		740-C	
	3 OBTAIN FOR S24		253-C	
	4 INSTALL DV & CV RECORDER & CONTROLLER CHART NOTE: NOTIFY PRESS ROOM AND ROPE OFF AREA UNDER V-922			
931 2	5 RUN 10" (100G) WATER INTO V-921 & ADJ TO 80-100 DEG F			
	6 ADD IN 1-2 MIN	63	530-A	63
	7 STIR 2 MIN & RECORD: PH. 9.95 (9.5-10.5)			
	8 STIR 20 MIN OR LONGER FOR S27			
922 3	9 RUN 31" (700G) WATER INTO V-922			
	10 WEIGH IN V-926 & RUN IN M. 9, 50.28 %	400	7-D	201
	11 TURN ON AGITATOR & STEAM & DUMP IN FROM S2	1042	740-C	1035
	LOT 100% 197 99.3			
	12 DUMP IN	50	113-B	50
	13 DUMP IN	10	777-A	10
	14 HEAT TO 212-214 DEG F, RECORD HT. 214 F,			
	214 DEG F WATCH FOAM			
	15 RECORD BY (+), IF NECESSARY ADJ TO +BY ASSUME 50%		7-D	
900	16 STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM			
	NOTE: RECORD: SPARKLER PRESSURE 1000 PSI IF NOT ZERO, NOTIFY SUPERVISOR			
	17 CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 F FOR S19 & RECORD: HT. 197 DEG F AND RECORDER 197 DEG F			
	RECORD: START 8:50, TOTAL MIN. 15 CLARITY OK NOTE: SAMPLE FROM HOSE - SHOW TO SUPERVISOR FOR O.K.			

MAY 26 1981

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MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 2 OF 3 CG 32 CODE RT-618-D (S)	USE LBS	N-CODE	ACCT LBS
904 4	18 19	RUN 1" (50G) WATER INTO V-904 WHEN S17 COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F RECORD: START <u>905</u> , TOTAL MIN <u>30</u>			
MISC 5	20 21	WEIGH IN PT FOR S35 M <u>7</u> <u>32.93</u> % MEASURE <u>84.1</u> UNITS IN V-928 FOR S33 M <u>2</u> <u>32.00</u> %	<u>1008</u> <u>1329</u>	725-A 28-D	332 419
CV 6	22 23 24 25 26 27	RUN 16" (1530G) WATER INTO V- WEIGH IN V-926 & RUN IN M <u>9</u> <u>50.28</u> % DUMP IN FROM S3 LOT <u>557</u> <u>524</u> WEIGH ON POSTAL SCALE & DUMP IN LOT ADJ TO 70-90 DEG F & STIR TO DISSOLVE STEAM EJECT V-921/931 INTO CV	<u>1008</u> <u>900</u> <u>12</u>	7-D 253-C 150-C	507 888 <u>912</u>
922 7	28 29A	WHEN S19 COMPLETE, SHUT OFF PUMP & INSERT V-922 FOOT PLUG RUN IN 10" (207G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER.			
904 8	29B	PUMP V-922 THRU SPARKLER INTO V-904			
922 9	30A	RUN IN 5" (103G) WATER INTO V-922 & HEAT TO 190-195 F. CIRCULATE 15 MIN THRU SPARKLER			
904 10	30B 31 32 33 34 35 36	PUMP V-922 THRU SPARKLER INTO V-904 WHEN MTY BLOW OUT SPARKLER INTO V-904 HEAT TO 165-170 F (SMPL TO SUPVR FOR O.K.) RUN IN N-28-D FROM S21 IN 12-15 MIN & STIR 5 MIN AT 165-170 DEG F ADJ TO 129" (3409G) AT 28-30 DEG F AND RECORD: TEMP <u>28</u> DEG F, <u>128</u> " RUN IN N-725-A FROM S20 AFAP (5-10 MIN) STIR 30 MIN AT 28-35 DEG F MAINTAINING +CR, +KI FOR S41 AND RECORD: TIME START <u>12:10</u> , CR <u>+</u> (+), KI <u>+</u> (+) NOTE (1) IF CR-, KI-, ADD 20# AS IS IN- CREMENTS ASSUME 32% RECORD: CR <u>+</u> (+), KI <u>+</u> (+) (2) IF CR+, KI-, ADD 20# AS IS INCREMENTS RECORD: CR <u>+</u> (+), KI <u>+</u> (+) ASSUME 33%	<u>162</u> <u>140X330</u>	57-A <u>20460</u> 28-A 725-A	

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 3 OF 3 CG 32 CODE RT-618-D (S)	USE LBS	N-CODE	ACCT LBS
CV 11	37	DUMP INTO CV	180	65-A	180
	38	ADJ TO 37" (3494G) AT 28-32 DEG F	30X330	57-A	9900
	39	RECORD: TEMP <u>30</u> DEG F & VOLUME <u>40</u>			
	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 DEG F. RECORD: START <u>1:10 PM</u>		57-A	
	42	TOTAL MIN <u>65</u>			
	42	STIR 30 MIN & RECORD: BASE <u>+</u> (+), DIAZO <u>-</u> (-), PH <u>9.35</u> (9.0-9.8)			
	43	FINAL TEMP _____ DEG F			
	43	IF NECESSARY, ADJ TO PH 9.0-9.8 ASSUME 50% & RECORD: PH _____ ASSUME 32%		7-D 28-D	
	44	HEAT TO <u>184-186</u> DEG F IN 65-70 MIN AND RECORD: HT _____ DEG F & RECORDER _____ DEG F			
DV 12	45	RUN <u>1</u> ✓ " (600G) WATER INTO DV	1620	16-B	1620
	46	TURN ON AGITATOR & STEAM & DUMP IN			
	47	HEAT TO 155-160 DEG F & STIR TO DISSOLVE			
CV 13	48	WHEN S44 COMPLETE, IMMEDIATELY STRIKE DV THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 7-10 MIN. MAINTAIN CV AT 184-186 DEG F. RECORD: START <u>4:23 PM</u> TOTAL MIN <u>11</u>			
	49	HEAT CV TO 198-202 DEG F IN 10-12 MIN			
	50	STIR 5 MIN AT 198-202 DEG F			
	51	FLOOD TO 180-190" (+/-18,000G)			
	52	RECORD: PH <u>8.2</u> (9.0-9.4) & STOP AGITATOR			
		START <u>5:07 PM</u> FIN <u>5:45 PM</u> OPTR <u>179</u>			
		WHEN INSTRUCTED BY PROCESSING AREA HALF WAY THRU PRESSING, DUMP IN, STIR 5 MIN. AND STOP AGITATOR. RESUME PRESSING.	10	588-A	10





