

S.V.

C.V.

(901, 903)

D.V. 904

CG 32 CODE RT-618-D PKG.

→ DEC 10 80 38227

EST. WGT. 2902 LBS.

STD. HRS. 10.4 TIME M

PROCESSES		APPROVED BY
() RT-618-D (S)		JJG 08-15-78
() RT-657-P (F)		AMJ 09-19-78
()	()	
()	()	
TYPED BY		
emw092078		

*Not too much water on V904 - split to V902
 Too much ice added to design - plugging
 lines, added warm water to design to relieve.*

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	5	Run 10" (100 G) water into V-921 & adj to 80-100°F			
2	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 34" (700 G) water into V-922			
	10	Weigh in V-926 & run in M 14, 49.19 % 407		7-D	201
	11	Turn on agitator & steam & dump in from S 2		740-C	1035
		Lot 100% %			
		118 1035 98.87			
	12	Dump in	50	113-B	50
	13	Dump in	10	777-A	10
	14	Heat to 212-214°F. Record: HT OF; OF 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 19 & Record: HT 195 OF			
		& Recorder 195 OF			
		Record: Start 600 Total Min 30 Clarity Clear			
		NOTE: Sample from hose - show to Supervisor for 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 730 Total Min 20			
Misc 5	20	Weigh in PT for S 35 M 13, 33.49 % 971		725-A	332
	21	Measure 87 units in V-928 for S 33 M 12, 30.56 % 1211		28-D	419
CV 6	22	Run 16" (1530 G) water into V-903			
	23	Weigh in V-926 & run in M 14, 49.19 % 1021		7-D	507
	24	Dump in from S 3		253-C	908
		Lot 500 900 12			912
	25	Weigh on postal scale & dump in Lot		7	100-C
	26	Adjust to 70-90°F & stir to dissolve			
	27	Steam eject V-921/931 into CV			

EQUIPMENT		PAGE <u>2</u> CG <u>32</u> CODE <u>RT-618-D (S)</u> EST. WGT. <u>2902</u> LBS.	USE LBS.	N CODE	ACCT LBS.
922	28	When S 19 complete, shut off pump & insert V-922 foot plug			
7	29	Run in 18" (247 G) water & heat to 165-170°F 190-195°F - Circulate 15 min thru Sparkler - Pump V922 thru Sparkler into V904			
904	30	Pump V 922 thru Sparkler into V 904			
8	31	When MTY blow out Sparkler into V-904			
	32	Heat to 165-170°F (Sample & show to Supervisor for OK)			
	33	Run in N-28-D from S 21 in 12-15 min & stir 5 min at 165-170°F			
	34	Adj to 129" (3409 G) at 28-30°F & Record: Temp °F	45 x 330	57-A	1480
	35	Run in N-725-A from S 20 AFAP (5-10 min)			
	36	Stir 20 min at 28-35°F maintain +CR, +KI for S 41			
		Record: Time Start <u>12:00</u> , CR <u>+</u> (+), KI <u>+</u> (+)			
		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	37	Dump into CV	180	65-A	180
9	38	Adj to 37" (3496 G) at 28-32°F	34 x 330	57-A	11,220
		Record: Temp <u>30</u> °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°F		57-A	
		Record: Start <u>9:50 AM</u> Total Min <u>ALL IN 8:15 AM</u>			
	42	Stir 30 min & Record: Base <u>+</u> (+), Diazo <u>-</u> (-), Final Temp <u>25</u> °F, pH <u>9.0</u> (9.0-9.8)			
	43	If necessary, adj to pH 9.0-9.8	Assume 50%	7-D	
		& Record: pH	Assume 32%	28-D	
	44	Heat to 178-180°F 180°F in 65-70 min &			
		Record: HT <u>180</u> °F & Recorder <u>180</u> °F			
PUMP DV	45	Run <u>24</u> " (600 G) water into DV			
FROM 10	46	Turn on agitator & steam & dump in	1620	16-B	1620
901	47	Heat to 155-160°F & stir to dissolve			
CV	48	When S 44 complete, immediately strike DV thru undersurface distributor into CV in 7-10 min. Maintain CV at 178-180°F 180°F			
11		Record: Start <u>10:20</u> Total Min <u>14</u>			
	49	Heat CV to 198-202°F in 10-12 min <u>195</u>			
	50	Stir 5 min at 198-202°F			
	51	Flood to 180-190" (±18,000 G)			
	52	Record: pH <u>9.0</u> (9.0-9.4) & stop agitator <u>SAMPLE</u>			
		START <u>4:45 AM</u> FIN <u>7:00 AM</u> OPTR <u>223</u>			
		<u>7:00 PM</u> <u>3:00 PM</u> <u>126</u>			
		<u>3:00 PM</u> <u>11:00 PM</u> <u>322</u>			
		<u>7 AM</u> <u>10:50</u> <u>262</u>			
		When instructed by Processing Area half way thru pressing, dump in & stir 5 min & stop agitator. Resume pressing	10	588-A	10

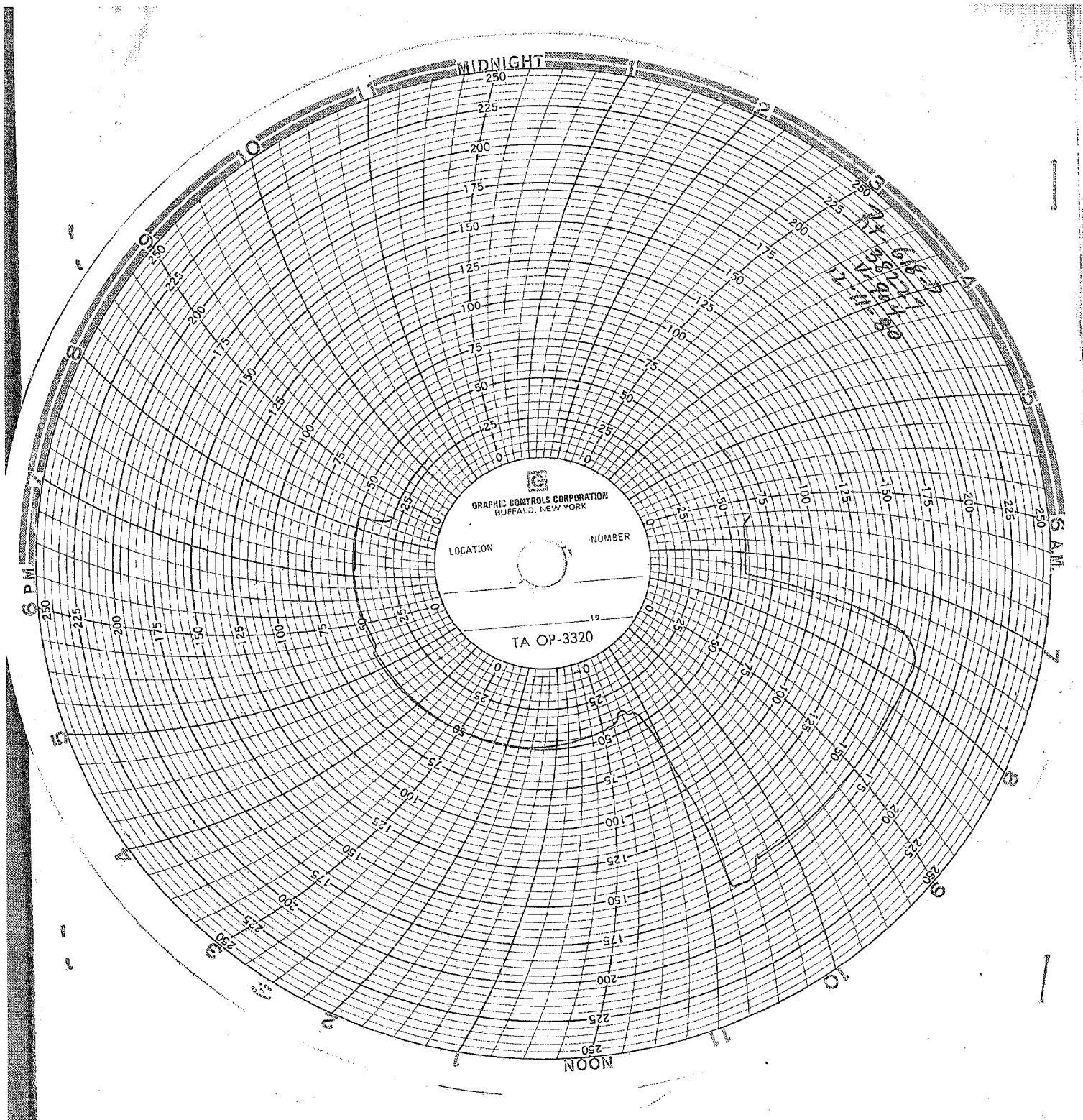
V922

300 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-30

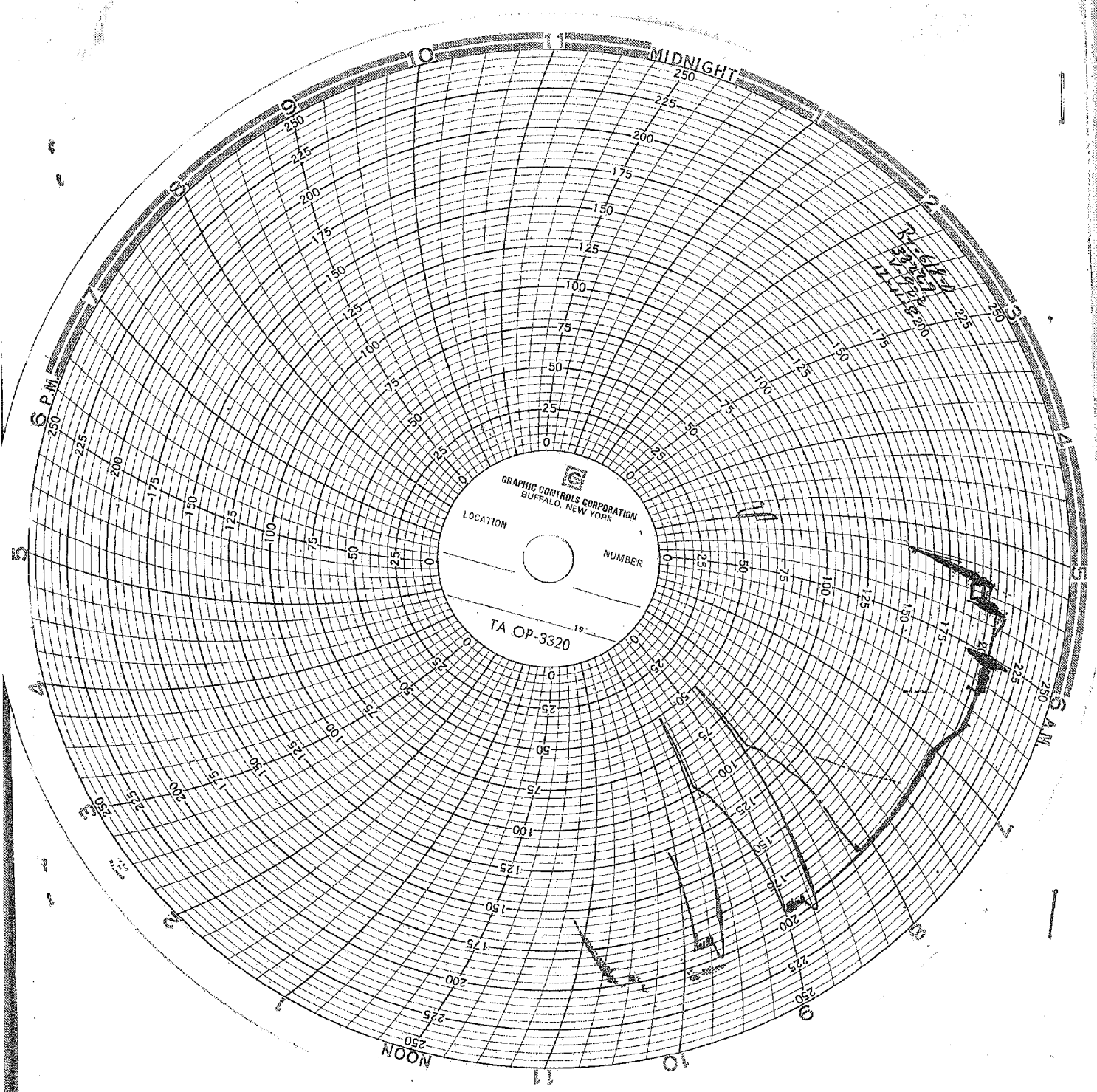
V904

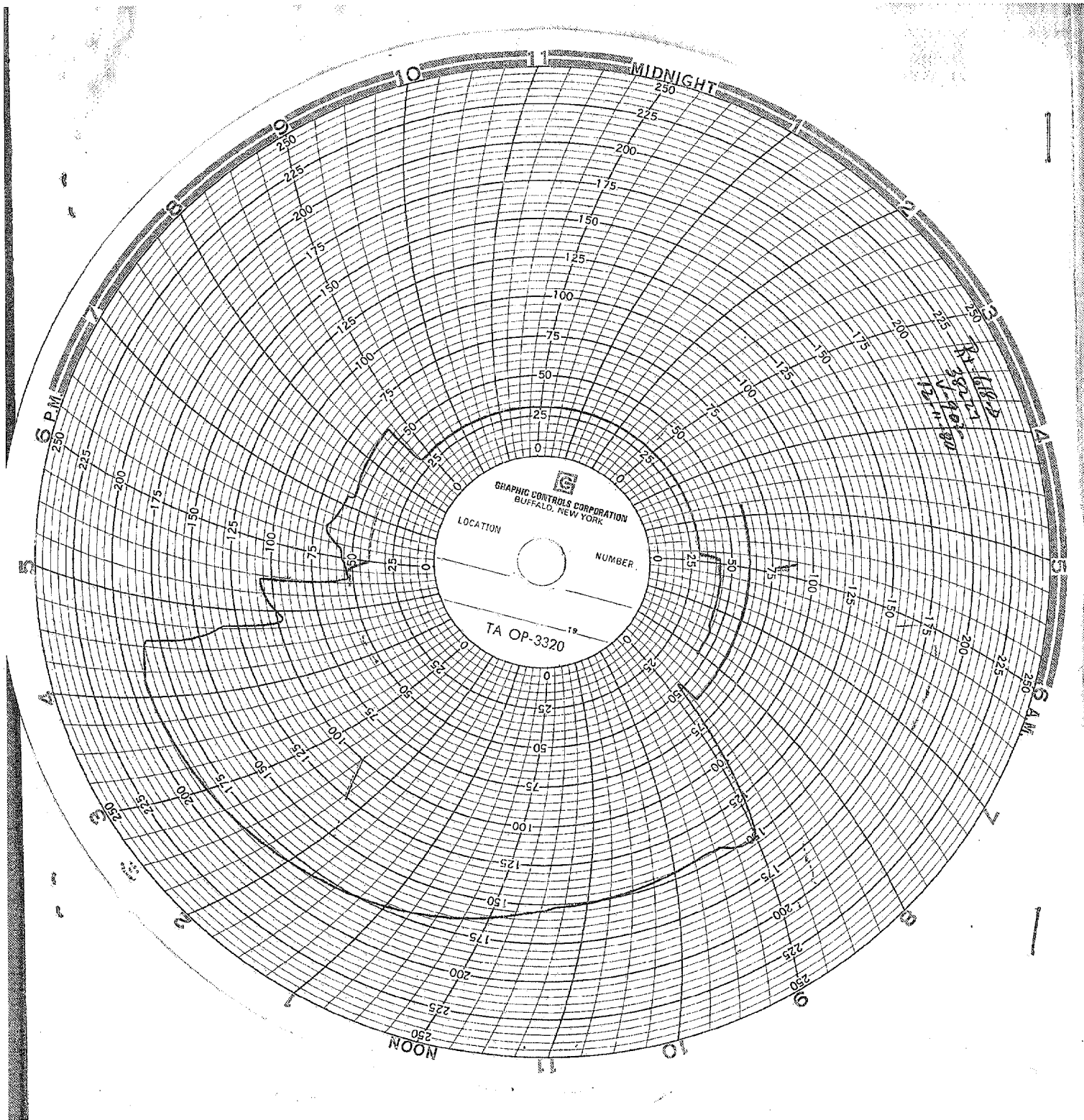
300 PUMP V-922 THRU SPARKLER
INTO V-904

CONTINUE WITH S-30



DUP050106487





DUP050106489

