

MD-3-A

PACKAGE TICKET

CODE

RT880

LOT

F2K37

PQ

NET WT/PKG.

NO. PKG.

PACK WT.

LOCATION

10

1945

24

STUMP

TOTAL NET WT.

1945

LUMP WT.

1946

PKG. N-CODE

PROD. SUPV.

DATE

OPERATOR

C 28

282

N38101

PRODUCT NAME = WATCHUNG RED B

CG 32 CODE RT-880-D PKG

LOT

F2K37

10

JUN 16 1982

EST. WT. 2026* LBS.

NON-BLEEDING

PROCESSES

APPROVED BY

RT-880-D (F) EWK 12-28-81

ALTERNATE

TYPED BY JMH

MAKING NOTES

JOB NAME: 32RT880DPF

===== INSTRUCTIONS = PRESSING = RECORD =====

					1ST	2ND	3RD	4TH	5TH
VAT	901								
DATE	6-22-82								
TIME	8:15 PM								
RELEASED BY									
PRESS	M-1 ONLY								
NO. OF CAKES	64								
PRESS WITHOUT AGITATION									
WASH TO 333 M MHOS - 35-75 F. WATER									
TEST AFTER 6 HOURS									
LOAD ON 6 CARS									
PRESS IMMEDIATELY CODE									
INSTURCT MAKING AREA TO ADD 10#									
N-588-A HALF-WAY THRU PRESSING.									
CLEAN MAGNETIC SEPARATOR AFTER									
PRESSING. CLEANED BY:									
TIME CLEANED:									
MEMBRANCE PRESS-SLURRY TEMP MUST NOT									
EXCEED 160°F OR 15PSI BACK PRESS. AT									
THE INLET FEED GAUGE. WATER TEST,									
FILL, WASH & COMPRESS PER OP #P.0081									
SAMPLES JAR									
DELIVER TO									

=====

===== DRYING =

DRY 20 HOURS AT 220 F

HOLD ON TRACK 30 MIN BEFORE DUMPING PANS.

=====

SAMPLES

DELIVER TO

=====

LUMP: - OK - WET - SALTS - CONTAMINATD

=====

ADDITIONAL DRYING HOURS REQUIRED

=====

NO CARS PULLED

SAMPLED BY

RELEASED BY

=====

NO DRUMS 10

LUMP WGT 1946

=====

===== GRINDING =

MILL 2 LSP 1/8" RP SCREEN 1800 RPM

MAX. TEMP. 140 F

INERT WITH CO2 WHEN GRINDING PER

O.P. #O.F. 0043.

=====

SCREEN

MAX. TEMP.

=====

EXPLAIN LOSSES

=====

SAMPLE WITHOUT MIXING

SAMPLES 2 ENV & 1 PT CAN

DELIVER TO CTL

=====

DATE MIXED 6-28-82

SAMPLED BY

RELEASED BY

=====

37
51
17

0.00 *

2.06 +
0.14 -
2.11 +
0.14 -
2.11 +
0.14 -
2.12 +
0.14 -
2.21 +
0.14 -
2.21 +
0.14 -
2.15 +
0.14 -
2.17 +
0.14 -
2.04 +
0.14 -
1.68 +
0.14 -
19.46 *

DATE PRINTED: 6/02/82 16

S.V.

C.V. 901-903

D.V. 902,904

CG 32 CODE RT-880-D PKG

PROCESSES () RT-880-D (F) APPROVED BY EWK 12-28-81

JUN 16 1982

F2K37

(DATE)

(LOT NUMBER)

TYPED BY: JMH

EST. WT. 2026* LBS.

STANDARD HRS. 9.3

TIME M

PREPARATION NOTES:

NON-BLEEDING

EQUIP MENT	NAME: WATCHUNG RED B	USE LBS	N-CODE	ACCT LBS
	NOTE: BATCH MUST BE PRESSED PROMPTLY TO CONTROL COLOR. DO NOT START IF PRESS WILL NOT BE AVAILABLE WITHIN 3 HRS AFTER MAKING. RECORD: PRESS WILL BE READY M PR SUPV START MAKING M / MAKING SUPV			
	NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V-922			
	NOTE: RUN 15" WATER INTO V-904. PUMP WATER FROM V-904 THRU DISTRIBUTOR. IF WATER DOES NOT COME OUT OF ALL DISTRIBUTOR HOLES WITH FULL FORCE, NOTIFY SUPERVISOR			
PREP 1	1 RECORD: 1 BATCHES SINCE SPARKLER LAST CLEANED. AFTER 4 BATCHES, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15# DICALITE, FILTER AID		777-A	
	2 OBTAIN FOR S11 2-CHLORO-4-AMINOTOLUENE-5-SULFONIC ACID		740-C	
	3 OBTAIN FOR S27 3-HYDROXY-2-NAPHTHOIC ACID		82-C	
	4 INSTALL DV & CV RECORDER & CONTROLLER CHART			
921/ 931 2	5 RUN 9" (90G) WATER INTO V-921 & ADJ TO 80-100 DEG F			
	6 ADD IN 2-3 MIN DRESINATE XX	88	99-A	88
	7 STIR 5 MIN & RECORD PH 9.9 (9.5-10.5)			
	8 STIR 20 MIN OR LONGER TO DISSOLVE FOR S36			
922 3	9 RUN 31" (639G) WATER INTO V-922			
	10 WEIGH IN SODIUM HYDROXIDE IN V-926 & RUN IN M 10 49.55 %	367	7-D	182
	11 TURN ON AGITATOR & STEAM & DUMP IN FROM S2		740-C	927
	LOT #100% %			
	2-CHLORO 284 350 98.57 355			
	4-AMINO 281 577 99.30 581			
	TOLUENE			
	5-SULFONIC ACID			

N38101.02

DUP050047253

DATE PRINTED: 6/02/82

EQUIP MENT		PAGE 2 OF 4 CG 32 CODE RT-880-D (F)	USE LBS	N-CODE	ACCT LBS
922	12	DUMP IN ACTIVATED CARBON	25	113-B	25
3	13	DUMP IN FILTER AID	10	777-A	10
CONT.	14	HEAT TO 212-214 DEG F WATCH FOAM!!			
	15	RECORD: BY <u>+</u> MUST BE +, ADJ IF NECESSARY SODIUM HYDROXIDE ASSUME 50%		7-D	
	16	STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM! NOTE: RECORD SPARKLER PRESSURE <u>0</u> PSI. IF NOT ZERO NOTIFY SUPERVISOR.			
	17	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 DEG F FOR S24. RECORD: START <u>8:45 A.M.</u> TOTAL MIN <u>15</u> CLARITY <u>CLEAR</u>			
	18	RECORD: HT <u>195</u> F & REC <u>195</u> F			
MISC	19	WEIGH SODIUM NITRITE IN PT-1 FOR S45			
4		M <u>9</u> <u>33.36%</u>	<u>90</u>	725-A	301
	20	WEIGH SODIUM NITRITE IN DRUM FOR S51			
		M <u>9</u> <u>33.36%</u>	<u>105</u>	725-A	35
	21	WEIGH SODUM NITRITE IN DRUM FOR S52			
		M <u>9</u> <u>33.36%</u>	<u>105</u>	725-A	35
	22	MEASURE <u>9 1/2</u> UNITS IN V-928 FOR S42			
		HYDROCHLORIC ACID M <u>1</u> <u>29.89%</u>	<u>1495</u>	28-D	447
904/ CV	23	RUN 1" (<u> </u> G) WATER INTO V- <u>904</u>			
5	24	NOTE USE CV IF MTY, IF CV NOT MTY USE V-904 WHEN S18 IS COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F. RECORD: START <u>9:02/A</u> TOTAL MIN <u>30</u>			
902	25	RUN 53" (1383G) WATER INTO V-902			
6	26	WEIGH SODUM HYDROXIDE IN V-926 & RUN IN			
		M <u>10</u> <u>49.55%</u>	<u>767</u>	7-D	380
	27	DUMP IN FROM S3 LOT <u>7673</u>	<u>13</u>	82-C	848
		3-HYDROXY <u>7664</u>	<u>285</u>		
		2-NAPHTHOIC ACID <u>7491</u>	<u>250</u>		
		<u>7668</u>	<u>250</u>		
	28	ADJ TO 70-90 DEG F & STIR TO DISSOLVE	<u>50</u>		
		<u>7488</u>			
922	29	WHEN S24 COMPLETE, SHUT OFF PUMP & INSERT V-922 FOOT-PLUG			
7	30A	RUN IN 10" (209G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER. CIRCULATE 15 MIN THRU SPARKLER.			
904/CV	30B	PUMP V-922 THRU SPARKLER INTO V-904/CV			
8					
922	30C	RUN IN 5" (104G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER.			
9					
904/CV	31	PUMP V-922 THRU SPARKLER INTO V-904/CV			
10	32	WHEN MTY BLOW OUT SPARKLER INTO V-904/CV			

DUP050047254

DATE PRINTED: 6/02/82

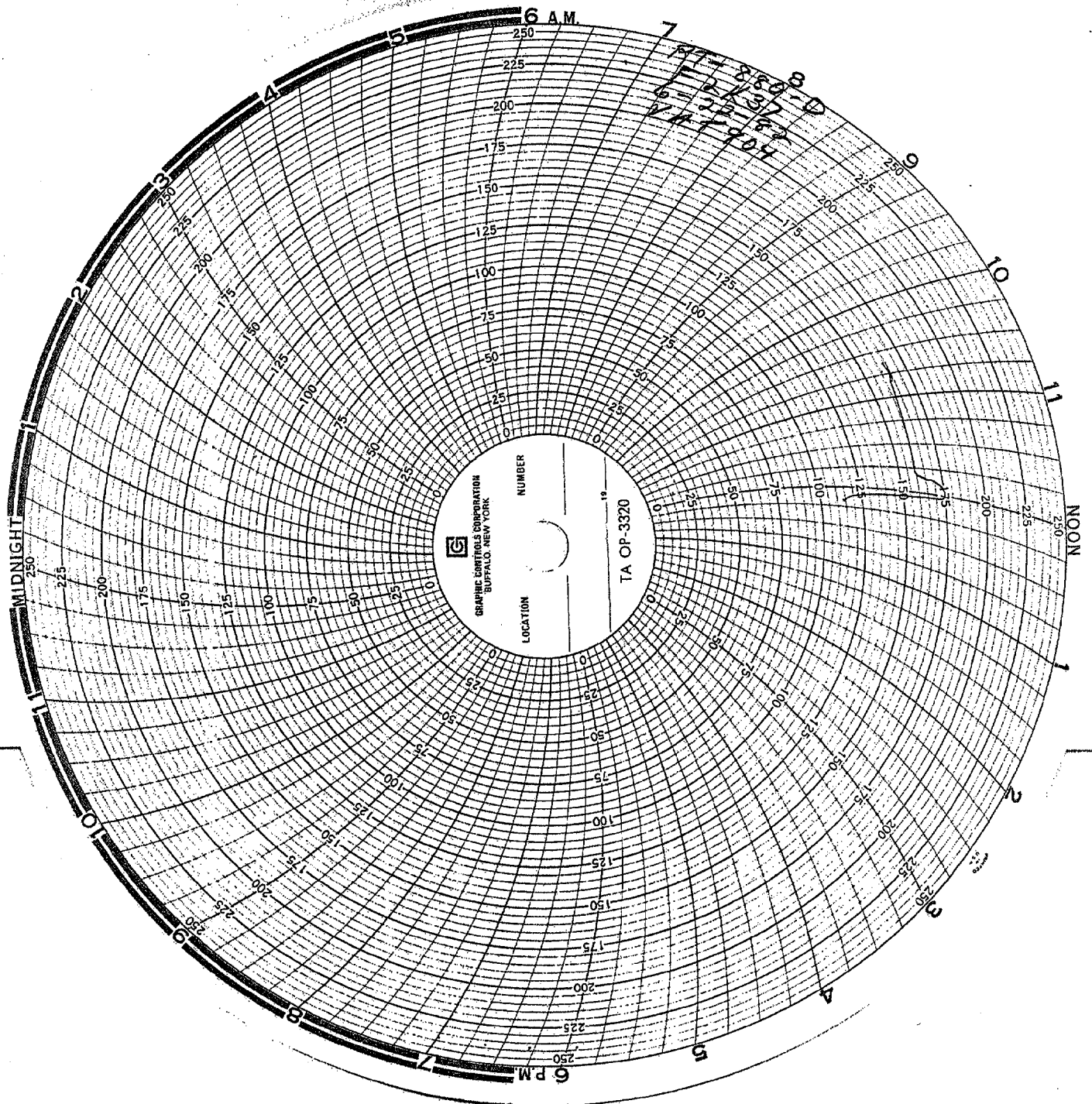
EQUIP MENT		PAGE 3 OF 4 CG 32 CODE RT-880-D (F)	USE LBS	N-CODE	ACCT LBS
904/CV 10 CONT	33	DISSOLVE ALKANOL XC IN 20G WATER AT 135-145 E WATER FROM HOT WATER MIXER IN DRUM & POUR IN	26	133-B	26
	34	HEAT V-904/CV TO 165-170 F FOR S41			
902 11	35	WHEN S28 COMPLETE, MEASURE TRISULPHOIL SOAP D IN CALIBRATED CONTAINER, SLURRY WITH 46G WATER IN DRUM & POUR INTO V-902	84	39-A	84
	36	STEAM EJECT IN V-921/931 FROM S8			
PT-2 12	37	RUN SODIUM HYDROXIDE INTO PT M <u>10</u> <u>49.55</u>	<u>214</u>	7-D	106
	38	ADJ TO 17" (59G)			
	39	STIR 5 MIN OR LONGER FOR S57			
NOTE: IF N-740-C SOLUTION WAS PUMPED DIRECTLY FROM SPARKLER TO CV AT S'S 23 & 24, OMIT S'S 40 & 41					
CV 13	40	RUN 1" (95G) WATER INTO V- <u>901</u>			
	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 DEG F RECORD: START <u>12:00N</u> TOTAL MIN <u>14</u>			
	42	RUN IN N-28-D HYDROCHLORIC ACID FROM S22 IN 12-15 MIN.			
	43	STIR 5 MIN			
	44	ADJ TO 37" (3496G) AT 32-38 DEG F <u>60</u> X330		57-A	<u>19800</u>
		RECORD: TEMP <u>32</u> F, STICK <u>40</u>			
	45	RUN IN N-725-A SODIUM NITRITE FROM S19 AFAP (5-10 MIN) & RINSE IN			
	46	STIR 20 MIN AT 32-38 F MAINTAINING +CR +KI FOR S54 RECORD: TIME START <u>1:15/PM</u> CR <u>+</u> (+) KI <u>+</u> (+) NOTE:		57-A	
		1) IF CR-, KI-, ADD 20# "AS IS" INCREMENTS RECORD: CR <u>+</u> (+) KI <u>+</u> (+)			
		HYDROCHLORIC ACID ASSUME 32%		28-D	
		2) IF CR+, KI-, ADD 20# "AS IS" INCREMENTS RECORD: CR <u>+</u> (+) KI <u>+</u> (+)			
		SODIUM NITRITE ASSUME 33%		725-A	
	47	DUMP IN CALCIUM CHLORIDE	935	20-A	935
	48	DUMP IN STRONTIUM NITRATE	205	246-B,E	205
	49	DUMP IN BARIUM SULFATE	44	65-A	44
	50	ADD FOR MAINTAINING AT 32-38 DEG F DURING <u>34</u> X330		57-A	<u>11220</u>
		COUPLING			
	51	POUR IN N-725-A SODIUM NITRITE FROM S20			
902	52	POUR N-725-A SODIUM NITRITE FROM S21 INTO V-902			
14	53	DUMP IN AMMONIUM CHLORIDE & STIR 2-3 MIN	172	165-A	172
CV 15	54	IMMEDIATELY COUPLE 902 THRU UNDERSUFACE DISTRIBUTOR INTO CV IN 18-22 MIN. MAINTAIN CV AT 32-38 DEG F. RECORD: START <u>2:28/PM</u> TOATL MIN. <u>20</u>			
	55	INSTALL 5/16" ORIFICE IN UNDERSURFACE			
		ADDITION LINE			
	56	WHEN S54 COMPLETE. STIR 30 MIN & RECORD:			

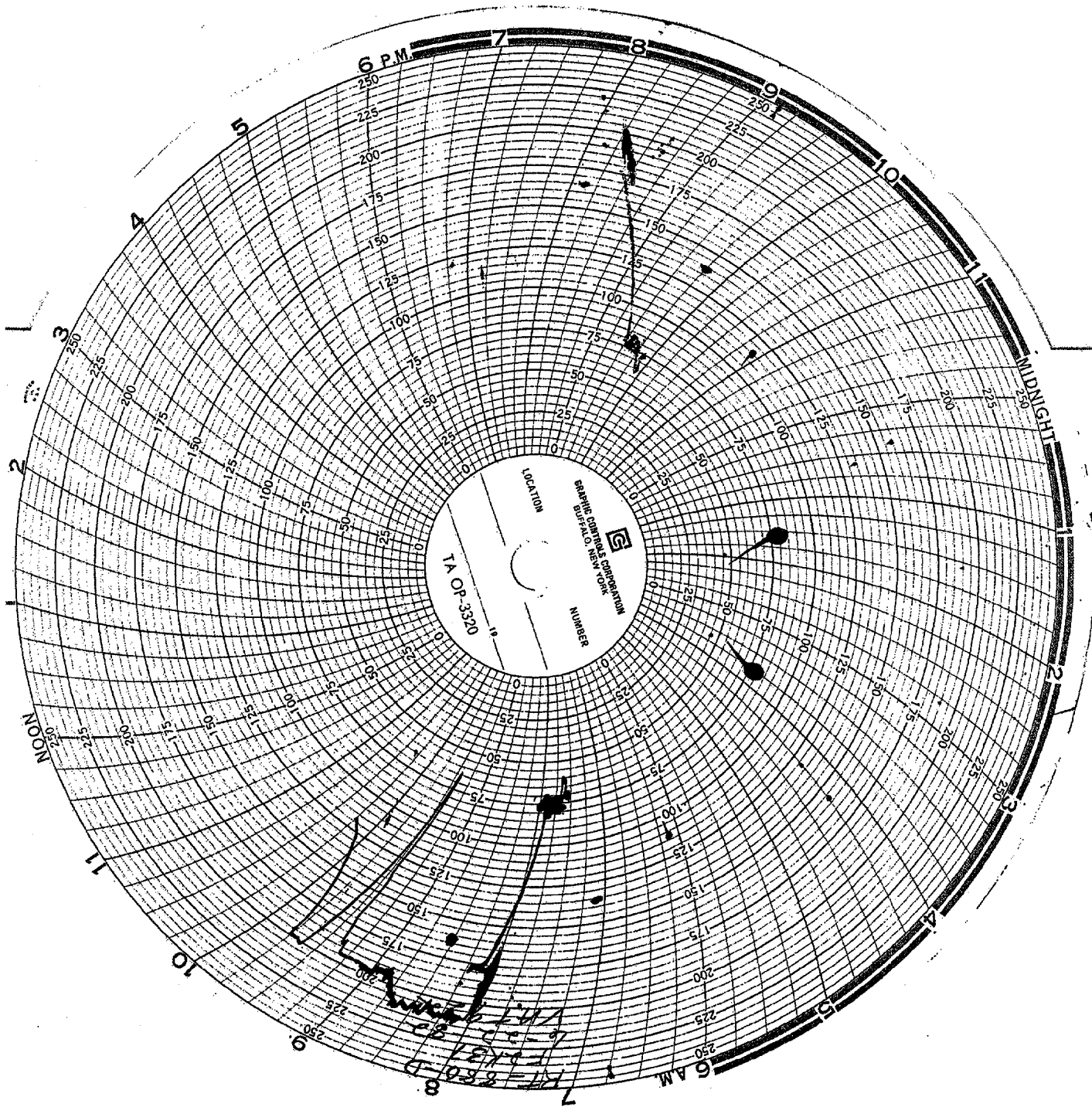
DUP050047255

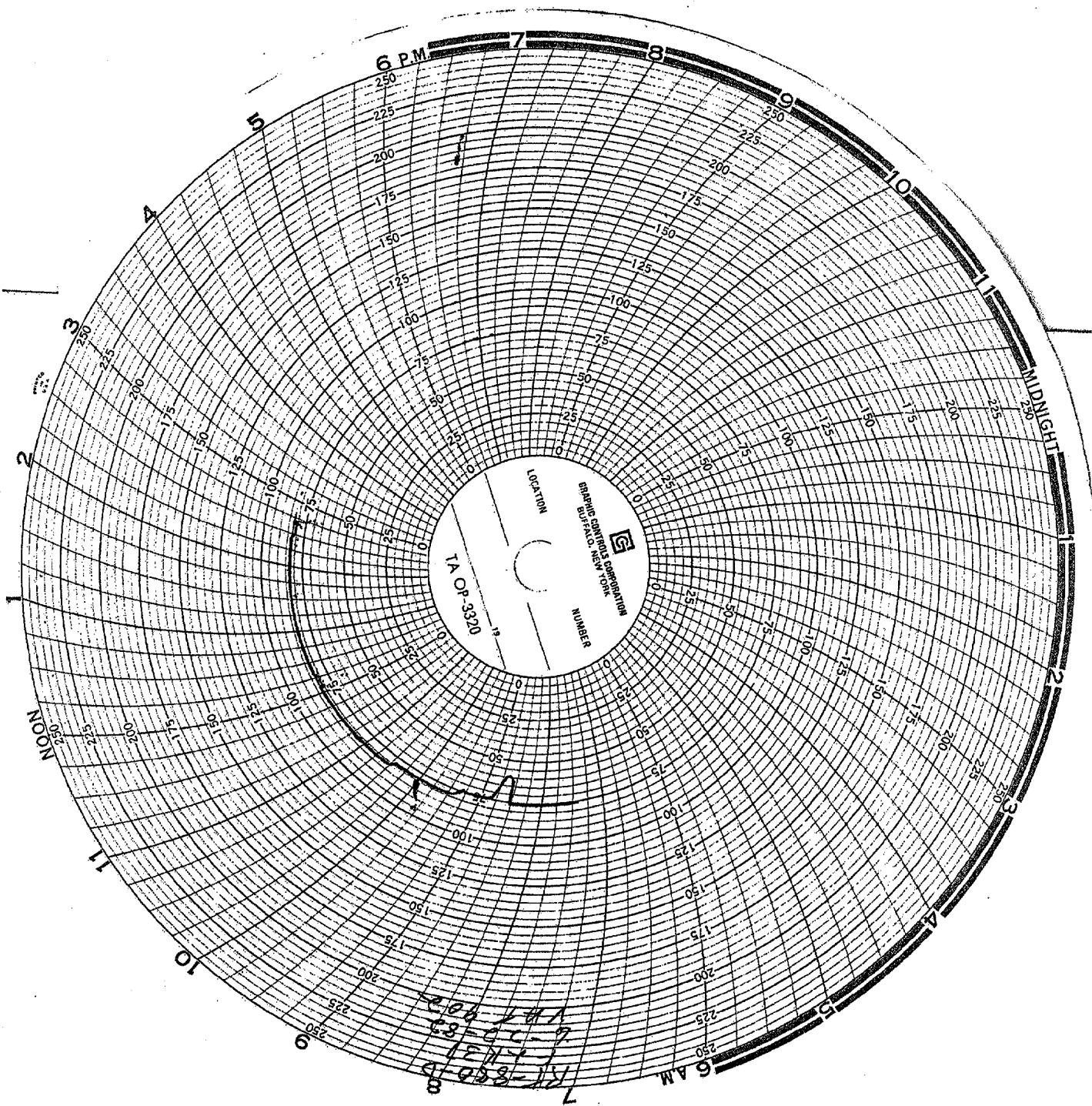
DATE PRINTED: 6/02/82

EQUIP MENT		PAGE 4 OF 4 CG 32 CODE RT-880-D (F)	USE LBS	N-CODE	ACCT LBS
CV	57	RUN IN N-7-D FROM S39 THRU 5/16" ORIFICE			
15		& RINSE IN RECORD: <u>45</u> MIN (40-50 MIN)			
CONT	58	STIR 20 MIN & RECORD: PH <u>6.5</u> (7.0-8.5)			
	59	IF PH BELOW 7.0 ADJ TO PH 7.0-8.5 WITH			
		N-7-D ONLY. RECORD PH <u>7.1</u> ASSUME 50%	<u>50</u>	7-D	<u>25</u>
	60	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN			
		ASSUME 50%	88	7-D	44
	61	STIR 15 MIN & RECORD: BASE <u>-</u> (+)			
		DIAZO <u>+</u> (-) PH <u>8.5</u> (9.0-9.8)			
	62	IF PH BELOW 9.0 ADJ TO PH 9.0-9.8 WITH			
		N-7-D ONLY. RECORD PH <u>9.5</u> <u>BASE +</u>			
		SODIUM HYDROXIDE ASSUME 50%	<u>120</u>	7-D	<u>60</u>
	63	MEASURE I OCTANOL IN CALIBRATED CONTAINER			
		& POUR IN	31	588-A	31
	64	HEAT TO 193-195 DEG F IN 75-80 MIN. RECORD			
		START <u>5:50 PM</u>			
	65	RECORD: HT <u>-</u> DEG F & REC <u>195</u> DEG F			
	66	STIR 60 MIN AT 193-195 DEG F. RECORD:			
		START <u>7:00 PM</u>			
	67	AFTER 20 MIN S66 STIR RECORD:			
		PH <u>8.4</u> (8.8-9.3)			
	68	IF PH BELOW 8.8, ADJ TO PH 8.8-9.3 WITH			
		N-7-D ONLY. RECORD PH <u>9.2</u>			
		SODIUM HYDROXIDE ASSUME 50%	<u>100</u>	7-D	<u>50</u>
	69	WHEN S66 COMPLETE, FLOOD TO 180-190"			
		(+/-18,000G)			
	70	STOP AGITATOR			
		WHEN INSTRUCTED BY PROCESSING AREA HALFWAY			
		THRU PRESSING			
		(1) DUMP IN I OCTANOL	10	588-A	10
		(2) STIR 5 MIN			
		(3) ADVISE PROCESSING TO RESUME PRESSING			
		START FIN OPTR			
		<u>7:00 PM</u> <u>3:15 PM</u> <u>54</u>			
		<u>3:00 PM</u> <u>8:15 PM</u> <u>381</u>			

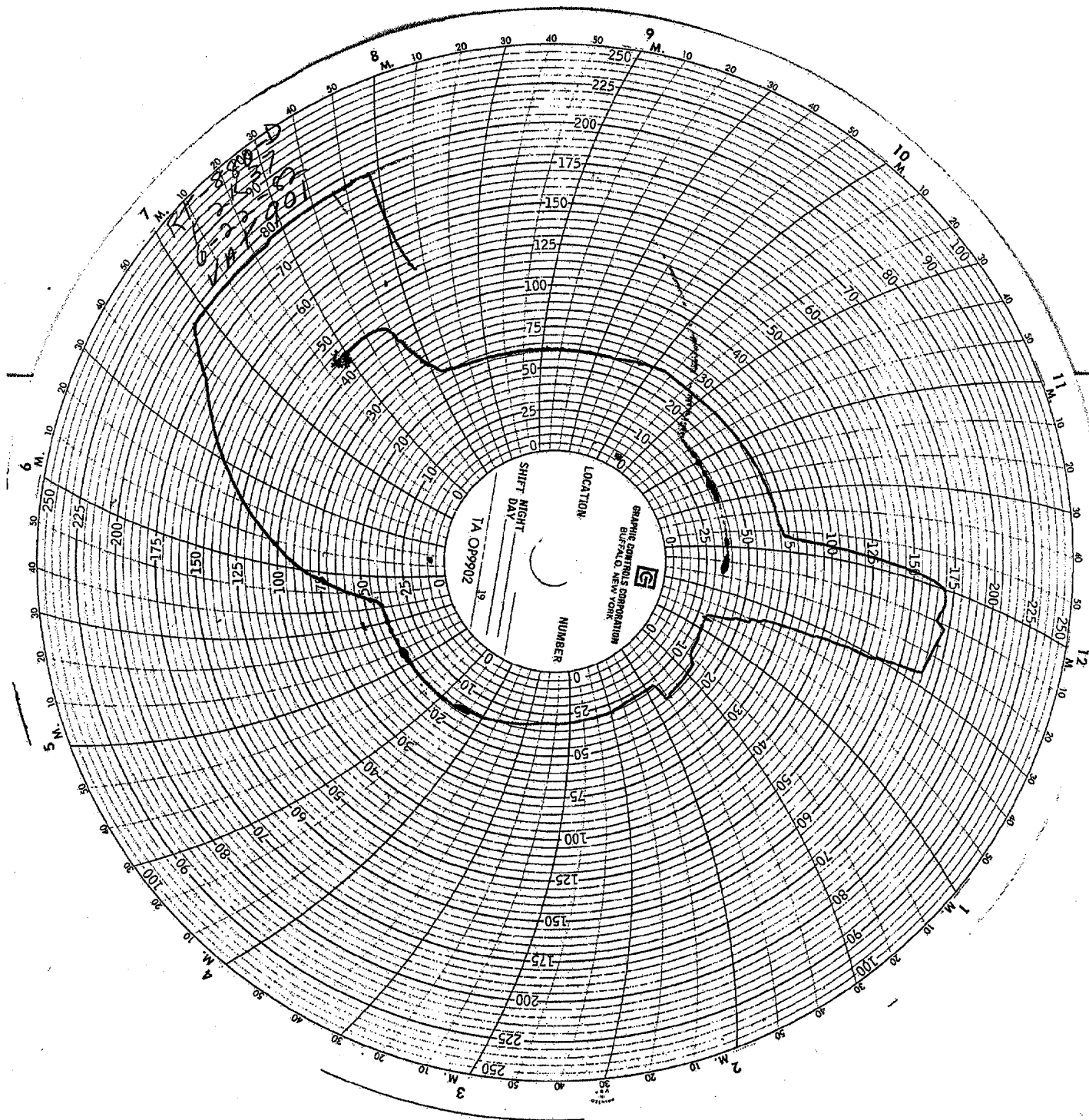
DUP050047256

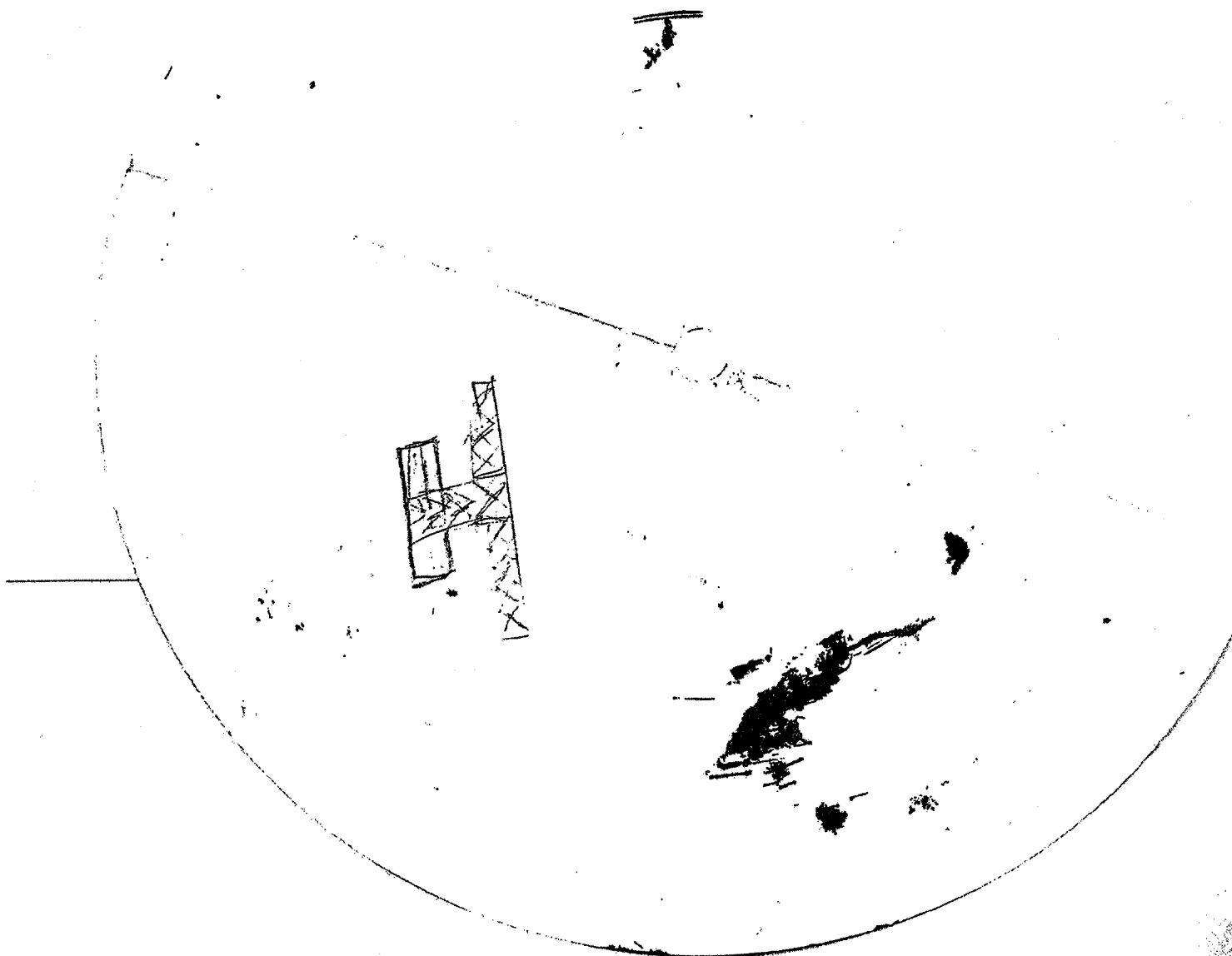












DUP050047262