

32 CODE RT-761-D PKG.

MAY -0.81-1072
EST. WGT. 2709 LBS.

STD. HRS. TIME M

PROCESSES	APPROVED BY
() RT-761-D	(J) JGG 4-4-78
() RT-838-D	(I) DCG 4-5-78
()	() MTW 4-13-78
()	()
TYPED BY	
NSA 4-19-78	

NON-BLEEDING

INPIMENT	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 / P.R. Supv. Start Making M / Making Supv			
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 12		740-C	
	3 Obtain for S 27		82-C	
	4 Install DV & CV Recorder & Controller charts			
921/ 931	5 Run 16" (160 G) water into V- & adi to 80-100°F			
	6 Add in 2-3 min	110	99-A	110
	7 Add in 1-2 min	50	530-A	50
	8 Stir 5 min & Record: pH (9.5-10.5)			
	9 Stir 20 min or longer to dissolve for S 30			
922 3	10 Run 35" (722 G) water into V-922			
	11 Weigh in V-926 & run in M %		7-D	216
	12 Turn on agitator & steam & dump in from S 2		740-C	1105
	Lot #100% %			
	13 Dump in	25	113-A	25
	14 Dump in	10	777-A	10
	15 Heat to 212-214°F Watch Foam			
	16 Record: BY must be +. Adi if needed Assume 50%		7-D	
	17 Stir 15 min at 212-214°F, then shut off steam. Watch Foam			
	18 Record: HT F & Rec F			
	19 Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 24			
Misc. 4	20 Measure units in V-928 for S 39 M %		28-D	633
	21 Weigh in PT for S 42 M %		725-A	401
	22 Weigh in drum for S 48		725-A	40
904/CV 5	23 Run 1" (G) water into V- Note: Use CV if MTY. If CV is not MTY, use V-904			
	24 When S 19 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start Total Min.			

EQUIPMENT		PAGE 2 CG 32 CODE KI-761-D (J)	LBS.	USE LBS.	N CODE	ACCT LBS.
902 6	25	Run 56" (1566 G) water into V-902				
	26	Weigh in V-926 & run in M %			7-D	682
	27	Dump in from S 3 Lot			82-C	1012
922 & 904/CV 7	28	Adj to 70-90°F & stir 10 min to dissolve				
	29	Slurry in 30 Gal water & pour into V-902		100	39-A	100
	30	Steam eject in V-921-931 from S 9				
	31	When S 24 complete, stop pump & insert V-922 foot plug				
	32	Run in 12" (247 G) water & heat to 180-190°F				
CV 8	33	Pump V-922 thru sparkler into V-904/CV				
	34	When V-922 MTY blow out sparkler into V-904/CV				
	35	Weigh & add to V- Lot		18 oz	749-C	1
	36	Heat V-904/CV to 165-170°F for S 39				
		NOTE: If N-740-C solution was pumped directly from sparkler to CV at S's 23 & 24 omit S's 37 & 38				
CV 8	37	Run in 1" (95 G) water into V-				
	38	If V-904 is used, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min) maintain CV at 165-170°F				
	39	Run in N-28-D from S 21 in 12-15 min				
	40	Stir 5 min				
	41	Adj to 43" (4080 G) at 32-38°F	45 x 330		57-A	
	42	Run in N-725-A from S 21 AFAP (5-10 min)				
	43	Stir 10 min at 32-38°F maintaining + CR, + KI				
		Record: Time Start CR (+) KI (+)				
		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 (+)				
	44	Dump in	1116		20-A	1116
902 9	45	Dump in	244		246-B	244
	46	Dump in	130		65-A	130
	47	Add for maintaining 32-38°F during coupling	36x330		57-A	
902 9	48	Pour N-725-A from S 22 into V-902				
	49	Dump in	189		165-A	189
CV 10	50	Immediately couple V-902 thru undersurface distributor into CV in 18-22 min. Maintain CV at 32-38°F				
		Record: Start Total Min				
	51	Stir 5 min & Record: Base (+), Diazo (-)				
		pH (9.0-9.8)				
	52	If necessary, adj to pH 9.0-9.8 Record: pH Assume 50%			7-D	
					28-D	
	53	Weigh in drum & pour in	45		588-A	45
	54	Heat to 184-186°F in 70-75 min				
	55	Record: HT °F & Rec °F				
	56	Stir 30 min at 184-186°F				
	57	After 10 min S 56 stir, record: pH (8.8-9.3)				
CV 10	58	If necessary, adj to pH 8.8-9.3 Assume 50%			7-D	
		Record: pH If pH above 9.3 do not adjust				
	59	When S 56 complete, flood to 180-190" (± 18000 G) & stop agitator				

EQUIPMENT		PAGE 2 CG 32 CODERT-880-D (D) EST. WGT.	2516 LBS.	USE LBS.	N CODE	ACCT. LBS.
902	25	Run 60" (1566 G) water into V-902				
6	26	Weigh in V-926 & run in	M 8.49.83 %	949	7-D	473
	27	Dump in from S 3	Lot		82-C	1018
			6179	1018		1018
	27A	through on Portal Scale & dump in		40	180C	40
	28	Adj to 70-90°F & stir to dissolve				
922	29	When S 24 complete, shut off pump & insert V-922 foot-plug				
7	30	Run in 18" (209 G) water & heat to 180-190°F - CIRCULATE 15 MIN THRU SPARKLER				
	31A	Run in 5" (50 G) water into V-922 - HEAT TO 190-195°F - PUMP V-922 THRU SPARKLER				
904/CV	31	Pump V-922 thru Sparkler into V-904/CV	CIRCULATE INTO V-904/CV			
8	32	When MT blow out Sparkler into V-904/CV	15 MIN THRU SPARKLER			
	33	Dissolve in 20 G water at 150-160°F in drum & pour in		32	133-B	32V
	34	Heat V-904/CV to 165-170°F for S 40				
902	35	When S 28 complete, measure in calibrated container.		105	39-A	105
9		sturry with 46 G water in drum & pour into V-902				
	36	Steam eject in V-921/931 from S 8				
PT-2	37	Run into PT-2	M 8.49.83 %	865	7-D	132
10	38	Adj to 19" (68 G)				
	39	Stir 5 min or longer for S 57				
		NOTE: If N-740-C solution was pumped directly from Sparkler to CV at S's 23 & 24, omit S's 40 & 41				
CV	40	Run 1" (95 G) water into V-				
11	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°F				
		Record: Start Total Min				
	42	Run in N-28-D from S 22 in 12-15 min				
	43	Stir 5 min				
	44	Adj to 43" (4080 G) at 32-38°F		60 50 x 330	57-A	17830
		Record: Temp 34 °F Stick 50 "				
	45	Run in N-725-A from S 19 AFAP (5-10 min)				
	46	Stir 30 min at 32-38°F maintaining +CR, +KI for S 54			57-A	
		Record: Time Start 7:00 P.M. CR (+) KI (+)				
		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 (+)				
	47	Dump in		1166	20-A	1166
	48	Dump in		255	246-E	255
	49	Dump in		135 100	65-A	650135
	50	Add for maintaining at 32-38°F during coupling		36 x 330	57-A	14880
	51	Pour in N-725-A from S 20				
902	52	Pour N-725-A from S 21 into V-902				
12	53	Dump in & stir 2-3 min		228	165-A	228
CV	54	Immediately couple 902 thru undersurface distributor into CV				
13		in 18-22 min. Maintain CV at 32-38°F				
		Record: Start 8:25 P.M. Total Min 25				
	55	Install 1/16" orifice in undersurface addition line				
	56	When S 54 complete, stir 30 min &				
		Record: Base (+), Diazo (+), pH 4.6 (5.0-6.0)				

EQUIPMENT	PAGE 3	CG 32	CODE RT-880-D (D)	EST. WGT.	2516 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 13 cont'd	57	Run in N-7-D from S 39 thru 5/16" orifice						
		Record: 60 Min (40-50 min)						
	58	Stir 20 min & Record: pH 7.6 (7.0-8.5)						
	59	If pH below 7.0 adj to pH 7.0-8.5 with N-7-D only Assume 50%					7-D	
		Record: pH						
	60	Weigh in V-926 & run in Assume 50%				110	7-D	55
	61	Stir 15 min & Record: Base (+), Diazo (-), pH 8.8 (9.0-9.8)						
	62	If pH below 9.0, adj to pH 9.0-9.8 with N-7-D only Assume 50%				60	7-D	30
		& Record: pH 9.5						
	63	Measure in calibrated container & pour in				35	588-A	35
	64	Heat to 193-195°F in 75-80 min Start 10:20						
	65	Record: HT 148 OF & Rec 200 OF						
	66	Stir 60 min at 193-195°F Record: Start 12:15 PM						
67	After 20 min S 66 stir Record: pH 8.4 (8.8-9.3)							
68	If pH 8.8, adj to pH 8.8-9.3 with N-7-D only Assume 50%				60	7-D	30	
	Record: pH 8.9							
69	When S 66 complete, flood to 180-190" (±18,000 G)							
70	Stop agitator							
When instructed by Processing Area halfway thru Pressing								
1. Dump in						10	588-A	10
2. Stir 5 min								
3. Advise Processing to resume Pressing								
START FINISH OPTR								
7:00 A 3:00 P 12:6								
6:30 PM 11:00 PM 37								
Delayed 1 HR Ice MACHINE								
11:00 AM 1:25 PM 3X2								
Delayed 4 HRS → HYDRAULIC LIFT BRICK AL.								

K 13830 REV.

EQUIPMENT

PAGE 3 CU 32 CODE RT-76-D (J)

GSE
LBS.H
CODEACCT.
LBS.

When instructed by Processing Area half-way thru pressing

1. Dump in

10

588-A

10

2. Stir 5 min

3. Advise processing to resume pressing

START

PTR

OPTR

DUP050098278



