S.V. C.V. 901, 903 D.V. 902, 904

CG 32 CODE RT-428-D PKG.

→ EST. WGT. ~~3160~~ 3118 LBS.

MAY -0-81-E-1387 gsit
LOT ~~[illegible]~~

STD. HRS. _____ TIME _____ M

PROCESSES		APPROVED BY
( ) RT-428-D	(X)	JJG 05-12-78
( )	( )	DCG 08-10-78
( )	( )	MW 08-11-78
( )	( )	X00-7B
TYPED BY emw081678		

Note: Pump water from Vat 904 thru distributor. If water does not issue from all holes with force, notify supervisor.

NON-BLEEDING

EQUIPMENT		NAME: WATCHUNG® RED B	USE LBS.	N CODE	ACCT. LBS.
		Note: Do not start if press will not be available within 3 hours 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 11		740-C	
	3	Obtain for S 40		82-C	
	4	Install DV & CV Recorder & Controller Charts			
921/931 2	5	Run 13" (130 G) water into V-931 & heat to 80 - 100°F			
	6	Add in 2 - 3 min	125	530-A	125
	7	Stir 5 min & Record: pH 10.0 (9.5 - 10.5)			
	8	Stir 20 min or longer to dissolve for S 53			
922 3	9	Run 35" (722 G) water into V-922			
	10	Weigh in V-926 & run in M 8, 49.83%	[illegible]	7-D	216
	11	Turn on agitator & steam & dump in from S 2		740-C	1107
		Lot 173 #100% 1107 % 99.9	1108		
	12	Dump in	25	113-B	25
	13	Dump in	10	777-A	10
	14	Heat to 212 - 214°F Watch Foam			
	15	Record: BY 7 (+) If necessary adj to +BY Assume 50%		7-D	
	16	Stir 30 min at 212 - 214°F, then shut off steam Watch Foam	RECORD SPARKLER		
	17	Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190 - 195°F for S 22 If not 0, notify SUPERVISOR Record: Start 6:10 PM Total Min 20 Clarity OK HT 194°F & Rec 195°F	PRESSURE 0 PSI		
Misc 4	18	Measure 97 3/4 units in V-928 for S 33 M 2, 32.0 %	1066	28-D	533
	19	Dissolve in 30 gal water in 55 gal drum at 90 - 110°F for S 52	60	246-E	60
	20	Weigh in PT for S 36 M 7, 32.93%	1084	725-A	~~[illegible]~~ 357

13129 REV.

EQUIPMENT		PAGE 2 OF 32 CODE RT-428-D (X) EST. WGT. 3168 LBS.	USE LBS.	N CODE	ACCT. LBS.
904/CV 5	21	Run 1" (G) water into V-901			
		Note: Use coupling vat if MTY. If CV is not available, use V-904			
	22	When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190 - 195°F. Record: Start 6:30 P.M. Total Min 30			
902 6	23	Run 56" (1618 G) water into V-902			
	24A	Dump in & stir to smooth slurry for S 42	525	542-A	525
	B	WEIGH and RUN IN 49.83		7-D	62
922 7	25	When S 22 complete, stop pump & insert V-922 foot plug			
	26	Run in 12" (247 G) water & heat to 180 - 190°F			
		REFER TO ATTACHED PAGE for STEPS 26 & 27			
904/CV 8	27	Pump V-922 thru Sparkler into V-904/CV			
	28	When MTY blow out Sparkler into V-904/CV			
	29	Pour in	75	979-D	75
	30	Heat to 165 - 170°F			
CV 9		NOTE: If N-740-C sol'n (S's 20 & 22) was pumped directly from Sparkler to CV, omit S's 31 & 32			
	31	Run in 1" (95 G) water into V-			
	32	Pump V-904 at 165 - 170°F thru undersurface distributor into CV AFAP (12 - 15 min). Maintain 165 - 170°F in CV			
	33	Run in N-28-D from S 18 in 12 - 15 min			
	34	Stir 15 min at 165 - 170°F			
	35	Adj to 43" (4080 G) at 32 - 38°F	60 ~~50~~ x 330	57-A	19,800
	36	Run in N-725-A from S 20 AFAP (5 - 10 min)			
	37	Stir 20 min at 32 - 38°F maintaining + CR, + KI			
		Record: Time Start 10:15 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 (+)			
	38	Dump in	184	246-E	184
	39	Dump in	520	65-A	520
	40	Dump in from S 3 & stir 10 min Lot		82-C	1012
		6181	1000		
		6182	12		
		ICE IF TEMP IS ABOVE 38°F			
	41	Add ~~for maintaining 32 - 38°F thru S 48~~	[illegible] x 330	57-A	
		DESIRED TEMPERATURE 36-38°F			
902 10	42	Dump into V-902 & stir 2 - 3 min	250	165-A	250
CV 11	43	Immediately after S 42 complete, pump V-902 thru undersurface distributor into CV in 18 - 20 min. Maintain ~~32 - 38~~°F in CV		57-A	
		Record: Start 1140 Total Min 20. 39-50°F (51°-53°F)			
PT 12	44	During S 43, weigh in PT M 8, 49.83%	191	7-D	~~[illegible]~~ 95
	45	Dilute to maximum volume (±100 G) for S 48			

K 13830 REV.

DUP050098260

EQUIPMENT		PAGE 3 CG 32 CODE RT-428-D (X) EST. WGT. 3168 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 13	46	When S 43 is complete, stir 30 min 51-53°			
	47	Record: pH 5.7 (5.6-6.6), Temp 50 °F ([illegible]°F)			
	48	Run in N-7-D from S 45 thru undersurface line			
	49	Stir 5 min & Record: pH 9.7 (9.0-9.8) TEMP. 55			
	50	If pH is below 9.0, adj to pH 9.0-9.8 Assume 50%		7-D	
	51	Record: pH , Diazo — (-), Base + (+)			
	52	Pour in N-246-E solution from S 19			
	53	Steam eject in V-921/931 solution from S 8			
	54	Heat to 180-182°F in 65-75 min & Record: HT 182 °F & Rec 185 °F			
	55	Stir 30 min at 180-182°F Record: Start 730			
	56	Flood to 180-190" (±18,000 G)			
	57	Stir 5 min & Record: pH 8.9 (8.8-9.3)			
	58	If pH below 8.8, adj to pH 8.8-9.3 Assume 50% Record: pH TAKE VAT CONTROL SAMPLE		7-D	
	59	Stop agitator			
		When instructed by Processing Area halfway thru pressing, dump in & stir 5 min	10	588-A	10
		Stop agitator & resume pressing			
		START 11 PM FIN 3 AM OPTR 282			

K 13830 REV.

DUP050098261

EQUIPMENT		PAGE ____ CG ____ CODE ____ EST. WGT. ____ LBS.	USE LBS.	N CODE	ACCT. LBS.
V922	26A	RUN IN 10" (206 G) WATER INTO V922 & HEAT TO 190-195°F. CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR. MAINTAIN 190-195°F DURING S-26.			
V904	26B	PUMP V922 THRU SPARKLER INTO V-904			
V922	27A	RUN 8" (165 GAL) WATER INTO V922 & HEAT TO 190-195°F CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR. MAINTAIN 190-195F THRU S-27			
V904	27B	PUMP V-922 THRU SPARKLER INTO V-904			
		CONTINUE WITH S-28			

DUP050098262

FORM A

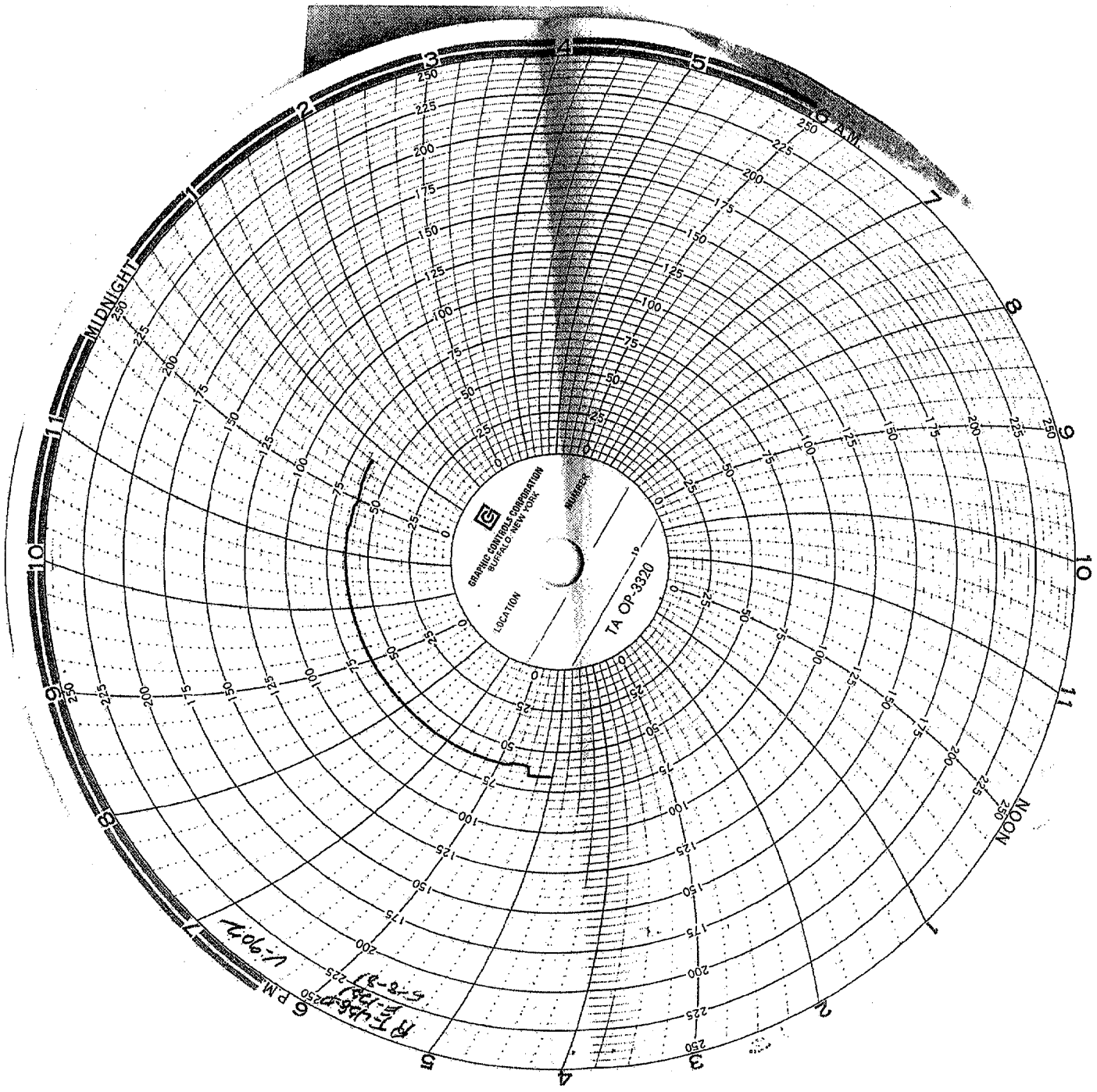
CODE RT-428-P LOT E-1221 VATS 901-902-922 EQUIP. SPRK

DATE 8-8-81 OPER 37 SUPERVISOR IKE

1. Used all stumps, leave 1 stump identified.
2. Clean shovel.
3. Chute washed & top replaced.
4. Water hose coiled.
5. Steam ejector turned off after finished in vat.
6. Scale left clean.
7. Added ice to vat only when volume reaches agitator.
8. Floor cleaned around vats used.
9. Hoses coiled or on rack on diazo press.
10. Hoses not crossing walkway after finished.
11. Pump shut off after removing hose from intake.
12. Ice blower shut off after using.
13. All spills in area worked clean.
14. Door on instruments closed.
15. All empty drums removed from area & discarded.
16. Corrosive containers properly covered.
17. Top of vats cleaned of color, paper cups, strings, etc.
18. Vat door after finished - hatches on abbe's.
19. All tools cleaned & placed in rack or proper place.
20. Ice house clean - tools on racks.
21. Revolvator cleaned - platform & pit.

ATTACH TO MAKE CARD

DUP050098263



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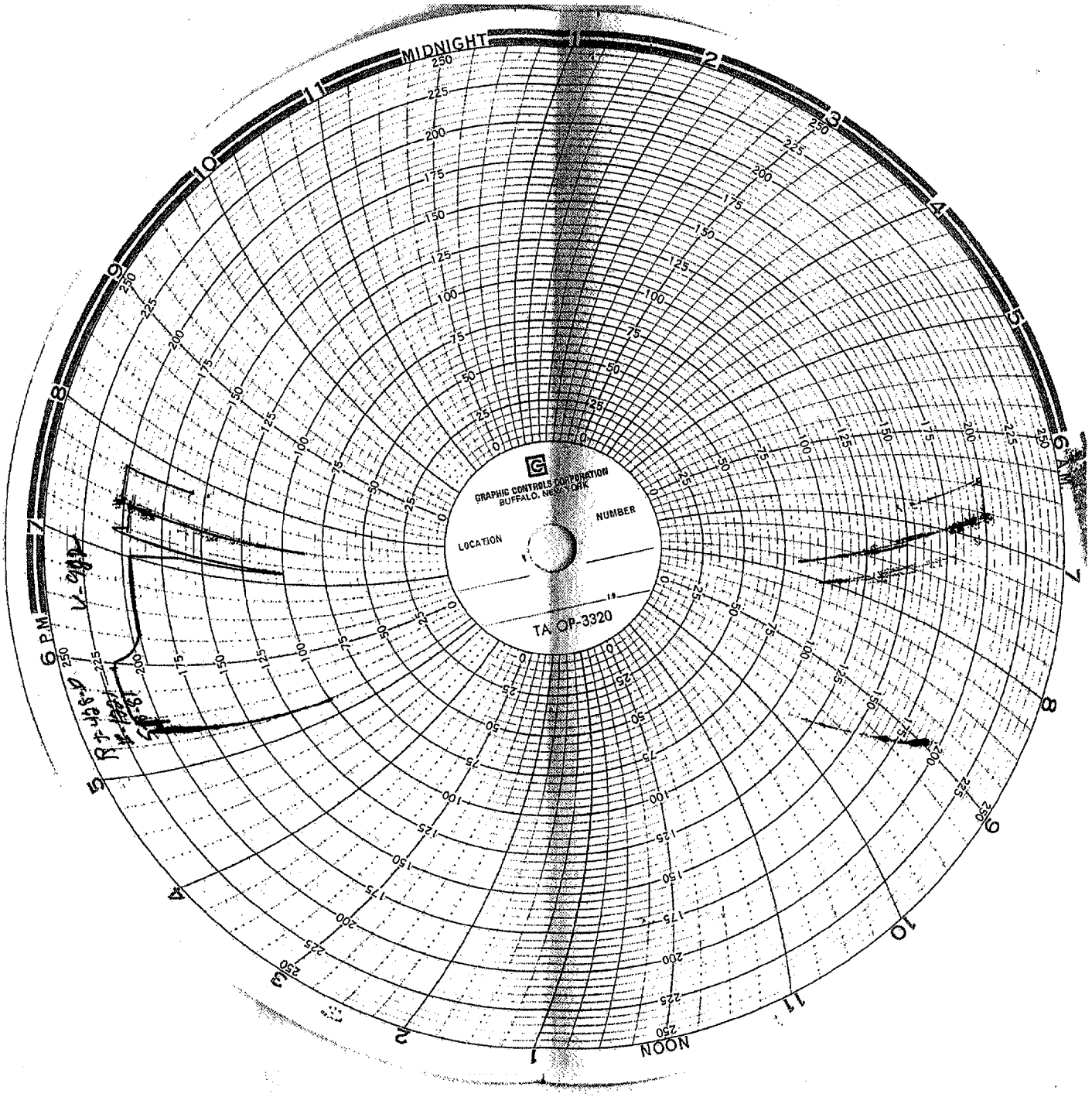
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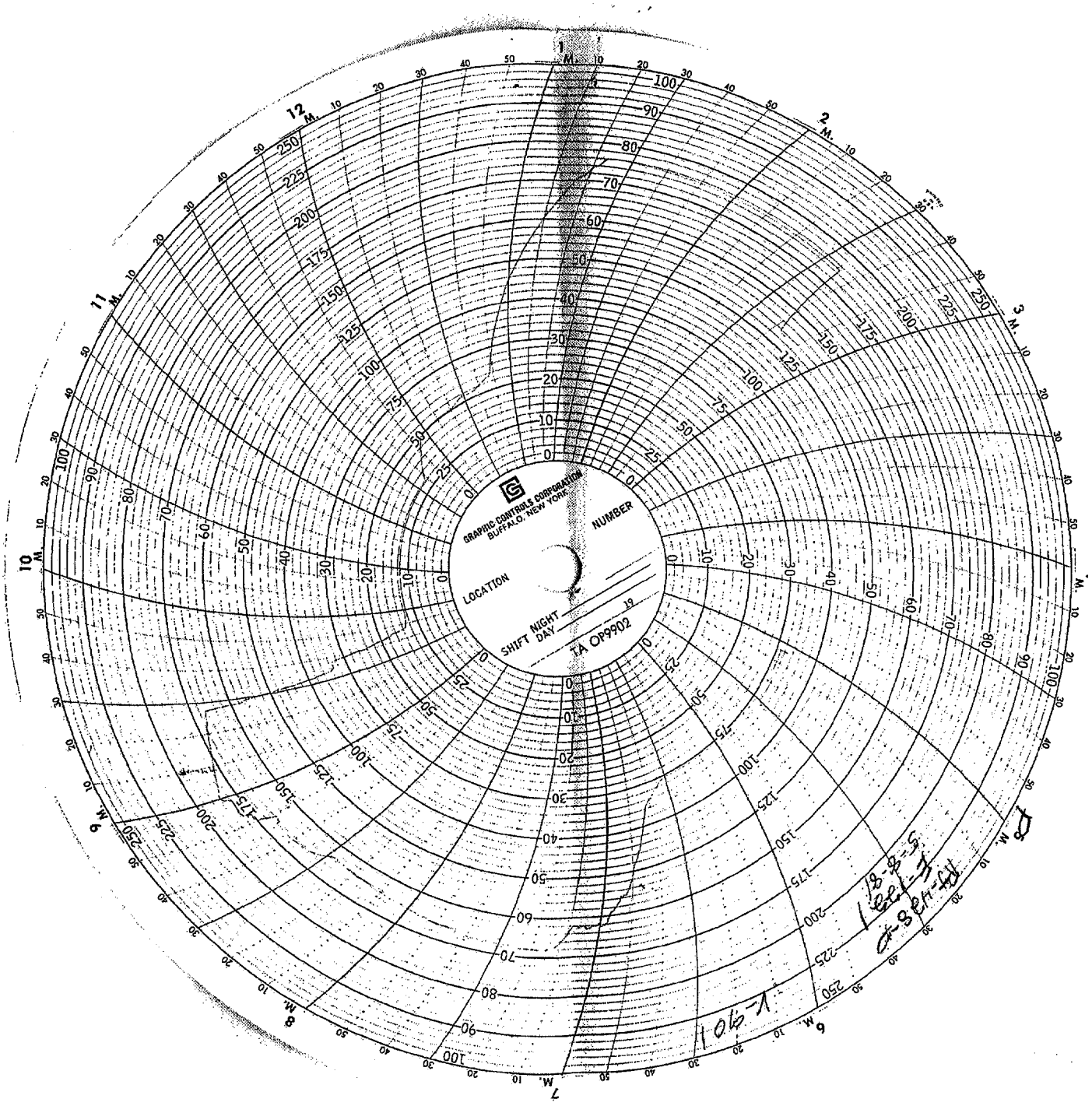

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