

CG 36 CODE RT-444-D PKG
MAY 25 1982 F2H17
(DATE) (LOT)

PROCESSES
() RT-444-D(A)
COMTYP JOB NAME:
TYPED BY: KLW

APPROVED BY
EWK 02/05/82
36RT444DMA

ESTIMATED WGT ~~1689~~ LBS. STANDARD HRS. TIME 3 P. M.

PREPARATION NOTES:

NON-BLEEDING				
EQUIP MENT	NAME: DUOL CARMINE	USE LBS	N-CODE	ACCT LBS
MISC 1	FIRST BATCH FOLLOWING WATCHUNGS, CLEAN DRESS SPARKLER & PRECOAT SPARKLER WITH 15# FILTER AID.	✓ 15	777-A	15
	2 RUN 15" WATER IN V-904 & PUMP INTO V-901 THRU DISTRIBUTOR. IF WATER DOES NOT COME OUT OF ALL DISTRIBUTOR HOLES WITH FULL FORCE, NOTIFY SUPERVISOR.			
PREP 2	6 RECORD: 0 BATCHES SINCE SPARKLER LAST CLEANED. AFTER 4 BATCHES, CLEAN, DRESS SPARKLER & PRECOAT WITH 15# FILTER AID.	⊗	777-A	
	4 OBTAIN 4-AMINOTOLUENE-3-SULFONIC ACID FOR S18.		549-C	
	5 OBTAIN 3-HYDROXY-2-NAPHTHOIC ACID FOR S35		82-C	
932 3	6 RUN 29" (597 G) WATER INTO V-932			
	7 WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M 9 49.59%	117	7-D	58
	8 TURN ON AGITATOR & STEAM			
	9 WHILE HEATING, ADD DRESINATE X IN 8-9 MIN	460	530-A	460
	10 HEAT TO 180-185°F RCD: TEMP. 180 *F			
	11 STIR 30 MIN. OR LONGER TO DISSOLVE			
	12 RECORD: PH 12.0 (11.8-12.0)			
	13 IF PH BELOW 11.8, ADJ. TO PH 11.8 OR ABOVE FOR S68 RCD: PH ASSUME 50%		7-D	
922 4	14 NOTIFY PROCESSING BEFORE ROPING OFF AREA BENEATH V-922. THEN ROPE IT OFF.			
	15 RUN 64" (1318 G) WATER INTO V-922			
	16 WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M 9 49.59%	268	7-D	133
	17 TURN ON AGITATOR & STEAM & HEAT TO 85-90°F			
	18 DUMP IN 4-AMINOTOLUENE-3-SULFONIC ACID FROM S4		549-C	543
	LOT #100%			
	209 281 98.34	286		
	808 197 98.53	200		
	886 65 98.3	66		

Note: Check weight all N-549-C

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EQUIP MENT		PAGE 02 OF 04 CG 36 CODE RT-444-D (A)	USE LBS	N-CODE	ACCT LBS
922 4 CON'T	19	STIR 15 MIN & RECORD: BY <u>+</u> (MUST BE +) BY PAPER TURNS RED.			
	20	IF NECESSARY, ADD SODIUM HYDROXIDE TO + BY RECORD: BY _____ ASSUME 50%		7-D	
	21	CHECK FOR COMPLETE SOLUTION RECORD: RESULTS _____			
	22	DUMP IN ACTIVATED CARBON	22	113-B	22
	23	DUMP IN FILTER AID	20	777-A	20
	24	STIR 15 MIN.			
	25	RECORD: SPARKLER PRESSURE <u>0</u> PSI IF NOT ZERO, NOTIFY SUPERVISOR			
	26	CIRCULATE 15 MIN OR LONGER AT 85-90°F THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 85-90°F FOR 8-28. RECORD: START <u>10:00</u> TOTAL MIN <u>45</u> CLARITY <u>OK</u>			
901 5	27	RUN 1" (95 G) WATER INTO V-901			
	28	WHEN S26 COMPLETE, PUMP IN V-922 THRU SPARKLER. MAINTAIN V-922 AT 85-90°F RECORD: START <u>11:00</u> TOTAL MIN <u>75</u>			
MISC 6	29	WEIGH SODIUM NITRITE IN PT FOR S57 M <u>9</u> <u>33.36</u> %	<u>647</u>	725-A	216
	30	MEASURE <u>66.30</u> UNITS IN V-928 FOR S58 HYDROCHLORIC ACID M <u>1</u> <u>29.89</u> %	<u>897</u>	28-D	268
	31	MEASURE <u>14</u> UNITS IN V-927 ACETIC ACID FOR S80 M <u>1</u> <u>68.93</u> %	<u>290</u>	30-D	200
902 7	32	RUN 20" (503 G) WATER INTO V-902.			
	33	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M <u>9</u> <u>49.59</u> %	<u>762</u>	7-D	378
	34	TURN ON AGITATOR & STEAM & HEAT TO 95-100°F			
	35	DUMP IN 3-HYDROXY-2-NAPHTHOIC ACID FROM S5 LOT <u>7552</u> <u>7557</u> <u>7558</u>	<u>253</u> <u>252</u> <u>77</u>	82-C	<u>582</u>
922 8	36	STIR 30 MIN OR LONGER TO DISSOLVE FOR S67.			
	37	WHEN S28 COMPLETE, SHUT OFF SPARKLER PUMP & INSERT FOOT PLUG.			
	38	RUN IN 10" (206 G) WATER			
	39	TURN ON AGITATOR & HEAT TO 85-90°F.			
	40	RECORD: SPARKLER PRESSURE <u>6</u> PSI. IF NOT ZERO NOTIFY SUPERVISOR.			
	41	CIRCULATE 15 MIN OR LONGER AT 85-90°F THRU SPARKLER UNTIL SOL'N IS CLEAR.			
	42	RECORD: CLARITY <u>OK</u> THEN SHUT OFF STEAM.			

EQUIP MENT		PAGE 03 OF 04 CG 36 CODE RT-444-D (A)	USE LBS	N-CODE	ACCT LBS
901 9	43	WHEN S41 COMPLETE, PUMP V-922 THRU SPARKLER INTO V-901.			
922 10	44	WHEN S43 COMPLETE, SHUT OFF SPARKLER PUMP & INSERT FOOT PLUG.			
	45	RUN IN 5" (103 G) WATER & HEAT TO 85-90°F THEN SHUT OFF STEAM.			
	46	RECORD: SPARKLER PRESSURE <u>0</u> PSI. IF NOT ZERO NOTIFY SUPERVISOR			
	47	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR.			
	48	RECORD: CLARITY <u>OK</u>			
901 11	49	WHEN S47 COMPLETE, PUMP V-922 THRU SPARKLER INTO V-901.			
	50	WHEN V-922 EMPTY, BLOW OUT SPARKLER INTO V-901.			
904 12	51	RUN 12" (322 G) WATER INTO V-904	700	20-A	700
	52	TURN ON AGITATOR & ADD CALCIUM CHLORIDE			
	53	HEAT TO 70-80°F.			
	54	STIR 15-20 MIN TO DISSOLVE FOR S77.			
901 13	55	ADJUST TO <u>38-44</u> °F WITH ICE.	20X330	57-A	7260
	56	TURN ON STACK EJECTOR.			
	57	RUN IN SODIUM NITRITE (N-725-A) FROM S29 IN 5-10 MIN & RINSE IN PT.			
	58	ADJUST TO 74" (6480 G) AT <u>38-44</u> °F WITH WATER & ICE.	8X330	57-A	7260
	59	RUN IN V-928 HYDROCHLORIC ACID FROM S30 AFAP			
	60	IMMEDIATELY ADJ TO 42-44°F RECORD: ACCURACY HT <u>42</u> °F REC <u>42</u> °F			
	61	RECORD: CR <u>+</u> (+) CONGO RED PAPER TURNS BLUE KI <u>+</u> (+) KI PAPER TURNS BLUE			
		NOTE: (1) IF CR+, KI- ADD 20% "AS IS". INCREMENTS SODIUM NITRITE ASSUME 33%		725-A	
		(2) IF CR-, KI- ADD 20% "AS IS". INCREMENTS HYDROCHLORIC ACID ASSUME 32%		28-D	
		(3) REPEAT ABOVE AS NECESSARY TO +CR, +KI RECORD: CR <u>+</u> (+); KI <u>+</u> (+)			
	62	WEIGH SULFAMIC ACID IN PLASTIC BUCKET & RINSE IN	25	395-D	25
	63	STIR 10 MIN & RECORD KI <u>+</u> (MUST BE -) KI PAPER STAYS WHITE.			
	64	IF NECESSARY ADJ TO -KI WITH SULFAMIC ACID RECORD: KI <u>-</u> (-)	10	395-D	10
	65	TURN OFF STACK EJECTOR.			
	66	ADJ TO 85" (7560 G) AT <u>38-44</u> °F WITH WATER & ICE.		57-A	

EQUIP MENT	PAGE 04 OF 04 CG 36 CODE RT-444-D (A)	USE LBS	N-CODE
901 13 CON'T	67 COUPLE V-902 THRU UNDERSURFACE DISTRIBUTOR INTO V-901 IN 30-35 MIN. MAINTAIN 42-50°F OPEN VALVE <u>8</u> TURNS RECORD: START <u>3:47P</u> TOTAL MIN <u>35</u>, TEMP <u>50</u> *F 68 WHEN S67 COUPLING COMPLETE, IMMEDIATELY STEAM EJECT IN V-932 SODIUM DRESINATE SOL'N FROM S13 IN 12-17 MIN. 69 STIR 10 MIN & RECORD: PH <u>12.2</u> (12.0-12.4) DIAZO <u>---</u> (-) BASE <u>VST</u> (+) 70 IF NECESSARY ADJ TO PH 12.0-12.4 RECORD: PH <u>---</u> ASSUME 50% DIAZO <u>---</u> (-) ASSUME 32% BASE <u>---</u> (+) 71 IF DIAZO TEST +, STIR ADDITIONAL 15 MIN RECORD: DIAZO <u>---</u> (-) BASE <u>---</u> (+) 72 IF DIAZO TEST STILL +, TREAT AS FOLLOWS: (1) ADD +/- 30 GAL WATER TO METAL DRUM (2) ADD 14# "AS IS" SODIUM HYDROXIDE ASSUME 50% (3) ADD 10# "AS IS" 3-HYDROXY-2-NAPHTHOIC ACID (4) STIR 10 MIN TO DISSOLVE (5) POUR INTO V-901 & STIR 5 MIN (6) RECORD: DIAZO <u>---</u> (-), BASE <u>---</u> (+) 73 REPEAT S72 AS NECESSARY TO - DIAZO, + BASE RECORD: DIAZO <u>---</u> (-) SODIUM HYDROXIDE ASSUME 50% BASE <u>---</u> (+) 3-HYDROXY-2-NAPHTHOIC ACID 74 STIR 60 MIN RECORD: START <u>4:50</u> 75 AFTER S74 STIR RCD: TEMP <u>62</u> *F (60-65°F) 76 HEAT TO 90-94°F 77 PUMP IN V-904 CALCIUM CHLORIDE SOL'N FROM STEP 54 THRU UNDERSURFACE DISTRIBUTOR AFAP 78 STIR 10 MIN 79 RECORD: PH <u>10.8</u> (11.5-12.2) 80 RUN IN V-927 ACETIC ACID FROM S31 & STIR 10 MIN 81 RECORD: PH <u>9.9</u> (9.3-9.7) 82 IF NECESSARY, ADJ TO PH 9.3-9.7 RECORD: PH <u>9.4</u> NOTE: (1) IF PH ABOVE 9.7 ADD ACETIC ACID IN SMALL AMOUNTS ASSUME 70% (5 TO 2# "AS IS" INCREMENTS) BECAUSE THERE IS A SUDDEN DROP IN PH BELOW 10.5. (2) IF PH BELOW 9.3, ADD 6# "AS IS" INCREMENTS SODIUM HYDROXIDE TO A PLASTIC BUCKET & DILUTE WITH WATER. ASSUME 50% 83 HEAT TO 183-187°F AFAP RECORD: ACCURACY HT <u>183</u> *F, REC <u>105</u> *F 84 STIR 40 MIN AT 183-187°F. RCD: START <u>7:55P</u> 85 WHEN S84 STIR COMPLETE, FLOOD TO 140°F OR LOWER 86 SHUT OFF AGITATOR START <u>4:30P</u> FIN <u>7:45P</u> OPTR <u>12.6</u> <u>3:00</u> <u>8:45</u> <u>342</u>		
			7-D
			28-D
			7-D
			82-C
			7-D
			82-C
			30-D
			7-D

Delayed - Cleaning 500000

RT-444-D HOT F2 H17

• CHECK WEIGH N-549-C & RECORD RESULTS Below:

N-549-C	%	DRUM STENCILLING			RECORD NEWARK CHECK WEIGH		
		GROSS	TARE	NET	GROSS	TARE	NET
K909	98.34	NOT A DRUM WGT LISTED			306	20	286
908	98.53	STAMP			220	20	200
886	98.3	STAMP			92	USED 66 NET	

* Take pint sample of this lot. Jar with label is on top of K8901.



