

S.V.

RT-261-0

C.V. (901) 903

MAKING INSTRUCTIONS: BATCH UNIT

D.V. 902, 904

CG 32

CODE

RT-880-D

PKG.

Nov 18 80

37978

EST. WGT. 2660 2548 LBS.

STD. HRS. 9.3

TIME

M

PROCESSES		APPROVED BY	
()	RT-880-D (D)	JJG 08-16-78	
()	()	AMJ 01-22-79	
()	()		
()	()		
TYPED BY			
emw012979			

Not 100% of N7-Dec
V922. Make weight with 740

NON-BLEEDING

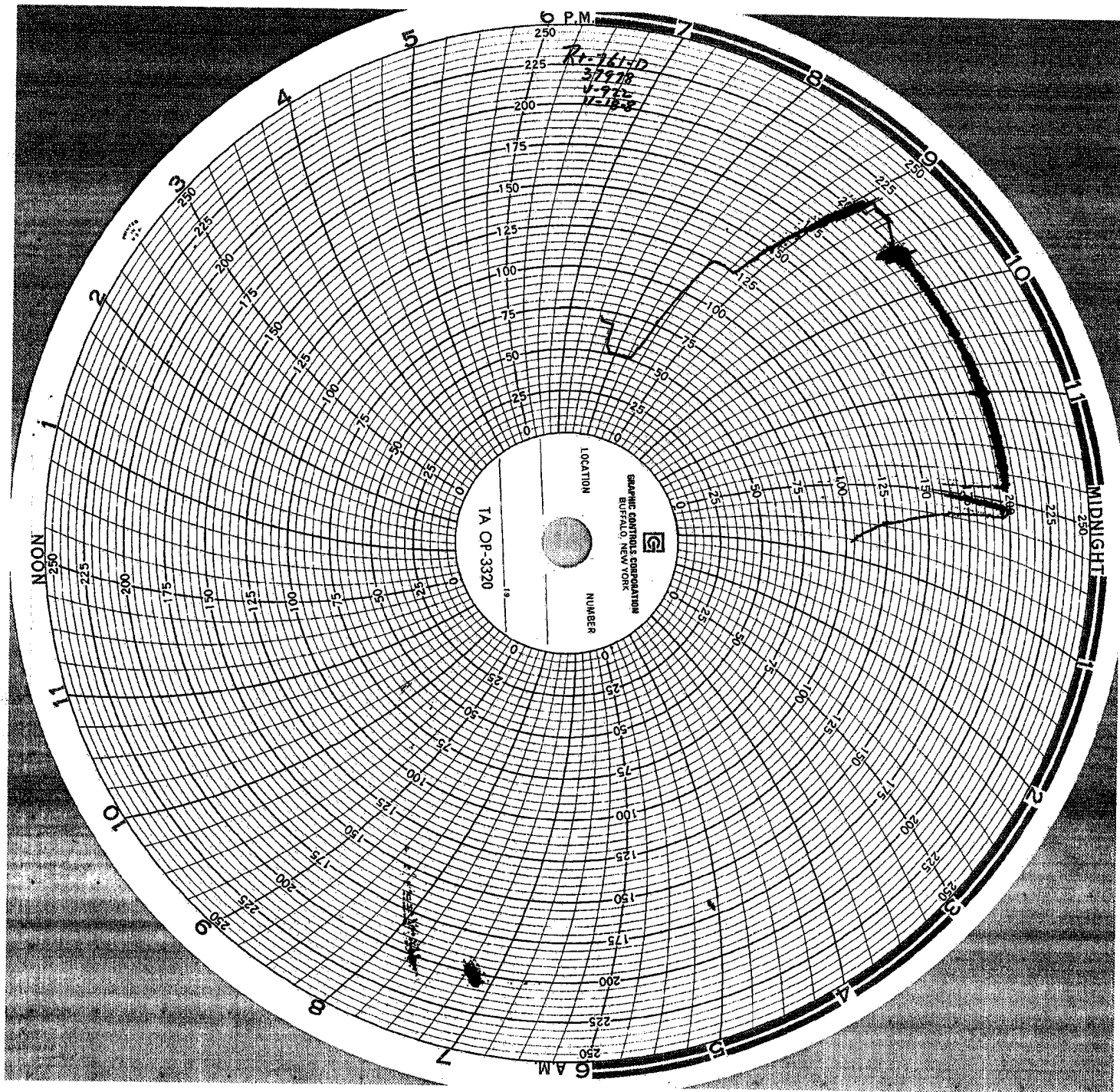
EQUIPMENT	NAME: WATCHUNG® RED B	USE LBS.	N CODE	ACCT. LBS.
	NOTE: Batch must be pressed promptly to control color. Do not start if press will not be available within 3 hrs after making. Record: Press will be ready M P R Supv Start making 7-AM 11-118-80 Making Supv S C.			
Prep 1	1 Record: batches since 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 27		82-C	
	4 Install DV & CV recorder & Controller charts			
921/902	5 Run 10" (100 G) water into V-921 & adj to 80-100°F			
	6 Add in 2-3 min	110 100	99-A	110 110
	7 Stir 5 min & Record: pH 10.3 (9.5-10.5)	50	530A	50
	8 Stir 20 min or longer to dissolve for S 36			
922	9 Run 88" (722 G) water into V-922	138	721-D	138
	10 Weigh in V-926 & run in M, 49.92 %	156	7-D	156 78
	11 Turn on agitator & steam & dump in from S 2		740-C	1107
	Lot #100% %			
	111 1107 98.82			
	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 + Must be + (Adj if Necessary) Assume 50% WATCH FOAM		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 24			
	Record: Start 10:45 AM Total Min. 60 Clarity OK			
	18 Record: HT 195°F & Rec 195°F			
Misc 19	Weigh in PT-1 for S 45 M 12, 33.16 %	12830	725-A	359
	20 Weigh in drum for S 51 M 12, 33.16 %	12830	725-A	42
	21 Weigh in drum for S 52 M 12, 33.16 %	12830	725-A	42
	22 Measure 99 units in V-928 for S 42 M 10, 31.35 %	1700	28-D	533
904/CW 23	Run 1" (G) water into V-901			
	5 NOTE: Use CV if MTY, if CV is not MTY use V-904			
	24 When S 18 is complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 11:55 AM Tot Min 20			

N35095

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	Flake %	453	453
✓	27	Dump in from S 3 <i>Don't use N-226</i>	Lot	5347	82-C	1012
		<i>Lot 5320 01 5327</i>		1012		
✓	27A	<i>Weigh on Porter Scale & Dump in</i>		30	1820	30
✓	28	Adj. to 70-90°F & stir to dissolve				
922	29	When S 24 complete, shut off pump & insert V-922 front-plug				
7	30	Run in 15" (389 G) water & heat to 180-190°F				
		<i>See attached for S 30 & 31</i>				
904/CV	31	Pump V-922 thru Sparkler into V-904/CV				
8	32	When MT blow out Sparkler into V-904/CV				
✓	33	Dissolve in 20 G water at 150-160°F in drum & pour in		31	133-B	31
✓	34	Heat V-904/CV to 165-170°F for S 40				
902	35	When S 28 complete, measure in calibrated container,		100	39-A	100
9		slurry 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	%	126	126
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				
CW	40	Run 1" (95 G) water into V- 901				
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		45 x 330	57-A	14,850
		Record: Temp 35 °F Stick +3 "				
✓	45	Run in N-725-A from S 19 AFAP (5-10 min)				
✓	46	Stir 10 min at 32-38°F maintaining +CR, +KI for S 54			57-A	
		Record: Time Start 1:45 PM 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		1116	20-A	1116
✓	48	Dump in		244	246-E	244
✓	49	Dump in		50	65-A	50
✓	50	Add for maintaining at 32-38°F during coupling		36 x 330	57-A	11,880
✓	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		218	165-A	218
CW	54	Immediately couple 902 thru undersurface distributor into CV				
13		in 18-22 min. Maintain CV at 32-38°F				
		Record: Start 2:45 PM Total Min 180				
✓	55	Install 1/16" orifice in undersurface addition line				
✓	56	When S 54 complete, stir 5 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	52	Run in N-7-D from S 39 thru 5/16" orifice					
	53	Record: 50 Min (40-50 min)					
	54	Stir 10 min & Record: pH 7.4 (7.0-8.5)					
	55	If pH below 7.0 adj to pH 7.0-8.5 with N-7-D only Assume 50%				7-D	
	56	Record: pH					
	57	Weigh in V-926 & run in Assume 50%		106	72	7-D	53
	58	Stir 5 min & Record: Base (+), Diazo (-), pH 7.4 (9.0-9.8)					
	59	If pH below 9.0, adj to pH 9.0-9.8 with N-7-D only Assume 50%				7-D	
	60	& Record: pH					
	61	Measure in calibrated container & pour in		35	588-A		35
	62	Heat to 193-195°F in 75-80 min Start 8:45 PM					
	63	Record: HT 195 °F & Rec 195 °F					
	64	Stir 60 min at 193-195°F Record: Start 9:45 PM					
	65	After 20 min S 66 stir Record: pH 8.0 (8.8-9.3)					
	66	If pH 8.8, adj to pH 8.8-9.3 with N-7-D only Assume 50%		35	72	7-D	35
	67	Record: pH 9.0					
	68	When S 66 complete, flood to 180-190" (±18,000 G)					
	69	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: AM 3: PM 223					
		9: 00 PM 11: 00 PM 322					

EQUIPMENT	PAGE	CG	CODE	EST. WGT.	LBS.	USE LBS.	N CODE	ACCT. LBS.
V922	30	A	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-30					
V904	30	B	PUMP V922 THRU SPARKLER INTO V-904					
V922	30A		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-30A+B					
V904	30B		PUMP V-922 THRU SPARKLER INTO V-904					
CONTINUE WITH S-32								



DUP050107630

