DIV. 902, 904

CG 36 CODE RT-444-D PKG ___

PROCESSES
( )RT-444-D(A)
COMTYP JOB NAME: 36RT444DMA
TYPED BY: KLW

APPROVED BY
EWK 02/05/82

MAY 27 1982 (DATE)

F2H18 (LOT)

ESTIMATED WGT 1689 LBS. STANDARD HRS. _____ TIME _____M

PREPARATION NOTES: _____

NON-BLEEDING

EQUIPMENT		NAME: DUOL CARMINE	USE LBS	N-CODE	ACCT LBS
MISC 1	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	3	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 7 , 4851 %	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 12.3 (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.	MAY 28 1982		
	15	RUN 64" (1318 G) WATER INTO V-922			
	16	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M 4 , 4851 %	264	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 986 #100% 543 % 98.2	552		

Note: Check weigh all V-549-C and record results on sheet attached

(KLW)

EQUIPMENT		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 + (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 0 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 S-28. RECORD: START 930			
		TOTAL MIN 15 CLARITY OK			
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 945 TOTAL MIN 70			
MISC 6	29	WEIGH SODIUM NITRITE IN PT FOR S57			
		M 9, 3336 %	647	725-A	216
	30	MEASURE 66 UNITS IN V-928 FOR S59			
		HYDROCHLORIC ACID M 1, 3487 %	897	28-D	268
	31	MEASURE 14 UNITS IN V-927 ACETIC ACID			
		FOR S80 M 1, 6893 %	290	30-D	200
902 7	32	RUN 20* (503 G) WATER INTO V-902.			
	33	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN			
		M 9, 9957 %	762	7-D	378
	34	TURN ON AGITATOR & STEAM & HEAT TO 95-100*F			
	35	DUMP IN 3-HYDROXY-2-NAPHTHOIC ACID FROM S5		82-C	[redacted]
		EOT			582
		7555	582		
	36	STIR 30 MIN OR LONGER TO DISSOLVE FOR S67			
922 8	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 0 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 OK THEN SHUT OFF STEAM.			

EQUIPMENT		PAGE 03 OF 04 CG 36 CODE RT-444-D (A)	USE LBS	N-CODE	ACCT LBS
901 9	42	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 0 PSI. IF NOT ZERO NOTIFY SUPERVISOR			
	47	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR.			
	48	RECORD: CLARITY OK			
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			
	52	TURN ON AGITATOR & ADD CALCIUM CHLORIDE	[redacted] 700	20-A	[redacted] 700
	53	HEAT TO 70-80*F.			
	54	STIR 15-20 MIN TO DISSOLVE FOR S77.			
901 13	55	ADJUST TO 38-44 [redacted]*F WITH ICE.	[redacted]X330 30	57-A	9900
	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 42-44*F WITH WATER & ICE.	[redacted]X330 10	57-A	3300
	59	RUN IN V-928 HYDROCHLORIC ACID FROM S30 AFAP			
	60	IMMEDIATELY ADJ TO 38-44 [redacted]*F RECORD: ACCURACY HT 38 *F REC 38 *F			
	61	RECORD: CR [redacted] (+) CONGO RED PAPER TURNS BLUE KI [redacted] (+) 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_____(+); KI_____(+)			
	62	WEIGH SULFAMIC ACID IN PLASTIC BUCKET & RINSE IN	25	395-D	25
	63	STIR 10 MIN & RECORD KI [redacted] (MUST BE -) KI PAPER STAYS WHITE.			
	64	IF NECESSARY ADJ TO -KI WITH SULFAMIC ACID RECORD: KI_____(-)	_____	395-D	_____
	65	TURN OFF STACK EJECTOR.			
	66	ADJ TO 85" (7560 G) AT [redacted]*F WITH WATER & ICE. 38-44	_____	57-A	_____

EQUIPMENT		PAGE 04 OF 04 CG 36 CODE RT-444-D (A)	USE LBS	N-CODE	ACCT LBS
901 13 CON'T	S67	COUPLE V-902 THRU UNDERSURFACE DISTRIBUTOR INTO V-901 IN 30-35 MIN. MAINTAIN 42-50*F OPEN VALVE _____TURNS RECORD: START 1255, TOTAL MIN 30, TEMP 50 *F			
	S68	WHEN S67 COUPLING COMPLETE, IMMEDIATELY STEAM EJECT IN V-932 SODIUM DRESINATE SOL'N FROM S13 IN 12-17 MIN.			
	S69	STIR 10 MIN & RECORD: PH 12.0 (12.0-12.4) DIAZO 7 (-) BASE 4 (+)			
	S70	IF NECESSARY ADJ TO PH 12.0-12.4 RECORD: PH_____ ASSUME 50% DIAZO_____(-) ASSUME 32% BASE_____(+)	_____	7-D 28-D	_____
	S71	IF DIAZO TEST +, STIR ADDITIONAL 15 MIN RECORD: DIAZO_____(-) BASE_____(+)			
	S72	IF DIAZO TEST STILL +, TREAT AS FOLLOWS: (1) ADD +/- 20 GAL WATER TO METAL DRUM (2) ADD 14# "AS IS" SODIUM HYDROXIDE ASSUME 50%	_____	7-D	_____
		(3) ADD 10# "AS IS" 3-HYDROXY-2-NAPHTHOIC ACID	_____	82-C	_____
		(4) STIR 10 MIN TO DISSOLVE (5) POUR INTO V-901 & STIR 5 MIN (6) RECORD: DIAZO_____(-), BASE_____(+)			
	S73	REPEAT S72 AS NECESSARY TO - DIAZO; + BASE RECORD: DIAZO_____(-) SODIUM HYDROXIDE ASSUME 50%	_____	7-D	_____
		BASE_____(+) 3-HYDROXY-2-NAPHTHOIC ACID	_____	82-C	_____
	S74	STIR 60 MIN RECORD: START 230PM			
	S75	AFTER S74 STIR RCD: TEMP 68 *F (60-65*F)			
	S76	HEAT TO 90-94*F			
	S77	PUMP IN V-904 CALCIUM CHLORIDE SOL'N FROM STEP 54 THRU UNDERSURFACE DISTRIBUTOR AFAP			
	S78	STIR 10 MIN			
	S79	RECORD: PH 11.8 (11.5-12.2)			
	S80	RUN IN V-927 ACETIC ACID FROM S31 & STIR 10 MIN			
	S81	RECORD: PH 9.6 (9.3-9.7)			
	S82	IF NECESSARY, ADJ TO PH 9.3-9.7 RECORD: PH 9.4 NOTE: (1) IF PH ABOVE 9.7 ADD ACETIC ACID IN SMALL AMOUNTS ASSUME 70%	_____	30-D	_____
		(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 ASSUME 50%	14	7-D	7
		BUCKET & DILUTE WITH WATER.			
	S83	HEAT TO 183-187*F AFAP RECORD: ACCURACY HI 183 *F, REC 184 *F			
	S84	STIR 40 MIN AT 183-187*F. RCD: START 5:45pm			
	S85	WHEN S84 STIR COMPLETE, FLOOD TO 140*F OR LOWER.			
	S86	SHUT OFF AGITATOR			

START	FIN	OPTR
7Am	3PM	292
3:00pm	11:50pm	320

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