MAKING INSTRUCTIONS: BATCH UNIT

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

CG 32 CODE RT-870-D PKG. _____

→ DEC -8 00 38183

EST. WGT. 2530 LBS.

STD. HRS. _____ TIME _____ M

2 gp

PROCESSES	APPROVED BY
( ) RT-870-D (E)	JJG 06-21-77
( ) ( )	DCG 06-23-77
( ) ( )	MTW 06-24-77
( ) ( )	
TYPED BY emw062977	

CLEAN UP AS YOU GO ALONG

LEAVE ONE STUMP ONLY

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 hrs after making. Supv to review with P.R. Supv & Record:			
		A. Press will be ready M / P.R. Supv			
		B. Start Making M / Making Supv			
Prep 1	1	If necessary, clean, dress Sparkler & pre-coat with 15#		777-A	
	2	Obtain for S 11		740-C	
	3	Obtain for S 25		82-C	
	4	Install DV & CV Recorder & Controller Charts			
921-931 2	5	Run 10" (100 G) water into V-931 & adj to 80-100°F			
	6	Add in 2-3 min	100	530-A	100
	7	Stir 5 min & Record: pH 10.0 (9.5-10.5)			
	8	Stir 20 min or longer to dissolve for S 49			
922 3	9	Run 32" (661 G) water into V-922			
	10	Weigh in V-926 & run in M 13 .48.77%	1	7-D	196
	11	Turn on agitator & steam & dump in from S 2		740-C	1006
		Lot 109 #100% 1006 % 1967	1020		
	12	Dump in	25	113-A	25
	13	Dump in	10	777-A	10
	14	Heat to 212-214°F WATCH FOAM			
	15	Record: BY 1 (+), if necessary, adj to + BY Assume 50%		7-D	
	16	Stir 15 min at 212-214°F, then shut off steam WATCH FOAM	16h - Record: Sparkler Pressure PSI Phone ages Notify Supervisor		
	17	Circulate 15 min or longer thru Sparkler until sol'n is clear			
		Maintain at 190-195°F for S 22			
		Record: Start 4:30 PM Total Min 15 Clarity ok			
		HT 192 °F & Rec 193 °F			
Misc 4	18	Measure 86% - units in V-928 For S 39 M 12 .30.56%	1320	28-D	~~185~~ 906
	19	Weigh in PT for S 42 M 13 .33.47%	1020	725-A	368
	20	Weigh in drum for S 50 M 13 .33.47%	120	725-A	40
904 5	21	Run 2" (58 G) water into V-904			
	22	When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 4:56 PM Total Min 20			

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EQUIPMENT		PAGE 2 CG 32 CODE RT-870-D (E) EST. WGT. 2530 LBS.	USE LBS.	N CODE	ACCT LBS.
922	23	When S 22 complete, shut off pump & insert V-922 foot plug			
6	24	Run in 15" (309 G) water & heat to ~~180-190°F~~ 190-195F. Circulate 15 Min Thru Sparkler. Pump V922 thru Sparkler into V904			
902	25	Run 56" (1566 G) water into V-902			
7	26	Weigh in V-926 & run in M 13 , 48.77%	151	7-D	224
	27	Dump in from S 3 Lot 3388 3389	40 890	82-C	920
	28	Adj to 70-90°F & stir to dissolve			
V322	29	Run in 8" (906) Water into V322 heat to 190-195F. Circulate 15 Min Thru Sparkler			
904	29	Pump V-922 thru Sparkler into V-904			
8	30	When MTY blow out Sparkler into V-904			
	31	Dissolve in 20 G water at 150-160°F in drum & pour in	30	133-B	30
	32	Heat to 165-170°F for S 38			
932	33	Run 15" (308 G) water into V-932 & adj to 80-100°F			
9	34	Add in 6-7 min	350	530-A	350
	35	Stir 5 min & Record: pH 10.1 (9.5-10.5)			
	36	Stir 20 min or longer to dissolve for S 59			
CV	37	Run 1" (95 G) water into V-903			
10	38	Pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min)			
	39	Run in N-28-D from S 18 in 12-15 min. Maintain 165-170°F in CV			
	40	Stir 15 min at 165-170°F			
	41	Adj to 43" (4080 G) at 32-38°F	50 x 330	57-A	16,500
		Record: Temp 32 °F, Volume 43 "			
	42	Run in N-725-A from S 19 AFAP (5-10 min) (Make sure CR (+)			
	43	Stir 20 min at 32-38°F maintaining +CR, + KI for S 44		57-A	
		Record: Time Start 10.00 PM , CR , KI			
		NOTE: 1. if CR-, KI- add 20# "as is" increments Assume 32%		28-A	
		Record: CR (+), KI (+)			
		2. if CR+, KI- add 20# "as is" increments Assume 33%		725-A	
		Record: CR (+), KI (+)			
	~~44~~	Dump in	35 950	20-A	950
	45	Add for maintaining 32-38°F thru S 52	~~30~~ x 330	57-A	11,55
PT	46	Fill PT approximately one half full with water			
11	47	Heat to 90-110°F			
	48	Dump in & stir 30 min or longer with lightning mixer to solution for S 58	63	246-B	63
902	49	When S 28 complete, steam eject V-921/931 from S 8 into V-902			
12	50	Pour in N-725-A from S 20			
	51	Pour in	226	122-B	226
CV	52	Immediately couple V-902 thru undersurface distributor into CV			
13		in 18-22 min. Record: Start 1:25 PM Total Min 25			
PT	53	During S 52 weigh in PT M 13 , 48.77%		7-D	130
14	54	Dilute to maximum volume (±100 G) for S 56			

EQUIPMENT		PAGE 3 CG 32 CODE RT-870-D (E) EST. WGT. 2530 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 15	55	When S 52 complete, stir 30 min & Record: Diazo — (+), Base — (+), pH 5.6 (5.0-6.0), Temp 32 °F (32-38°F)			
	56	Run in PT from S 54 thru undersurface line & stir 15 min			
	57	Record: Diazo — (-), Base — (+), pH 9.6 (9.0-9.8)			
	58	Run in N-246-B sol'n from S 48			
	59	Steam eject in V-932 from S 36			
	60	Stir 5 min & Record: pH 9.4 (9.0-9.8)			
	61	If pH below 9.0 adj to pH 9.0-9.8 with N-7-D only Assume 50% & Record: pH		7-D	
	62	Pour in	35	588-A	35
	63	Heat to 193-195°F in 70-75 min & Record: HT 194 °F & Rec 195 °F			
	64	Stir 60 min at 193-195°F Record: Start 4:15 AM			
	65	After 20 min S 64 stir, Record: pH 8.4 (8.8-9.3) & if below pH 8.8, adj to pH 8.8-9.3 with N-7-D only Assume 50% Record: pH 9.0	70	7-D	35
	66	After S 64 stir, flood to 180-190" (±18000 G) & stop agitator			

START	FIN	OPTR
8:00 PM	11:00 PM	328
12:30 AM	4:30 AM	37
4:30 A.M	5:45 A.M	381

When instructed by Processing Area half way thru pressing, dump in, stir 5 min & stop agitator. Resume pressing.	10	588-A	10

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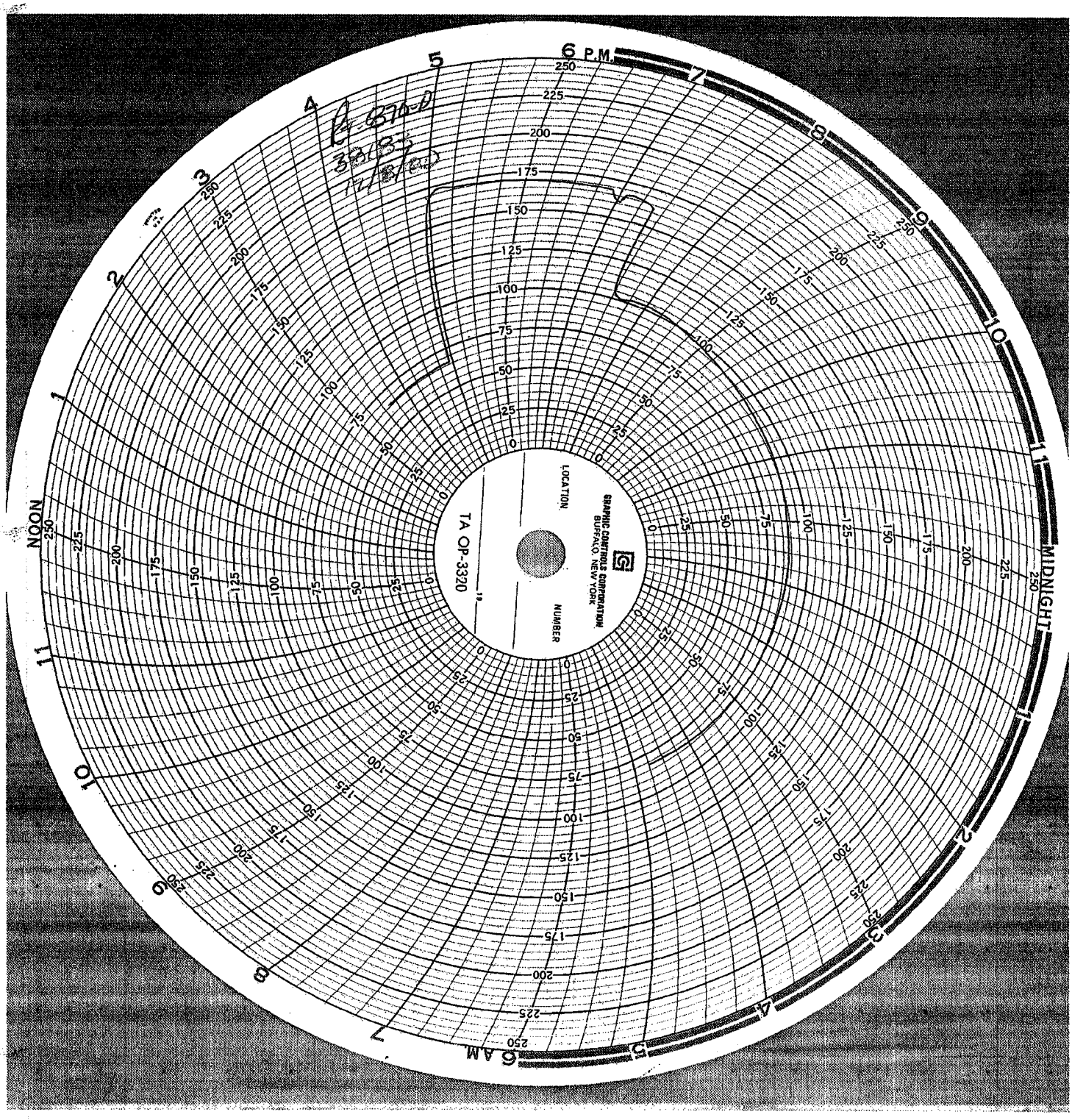

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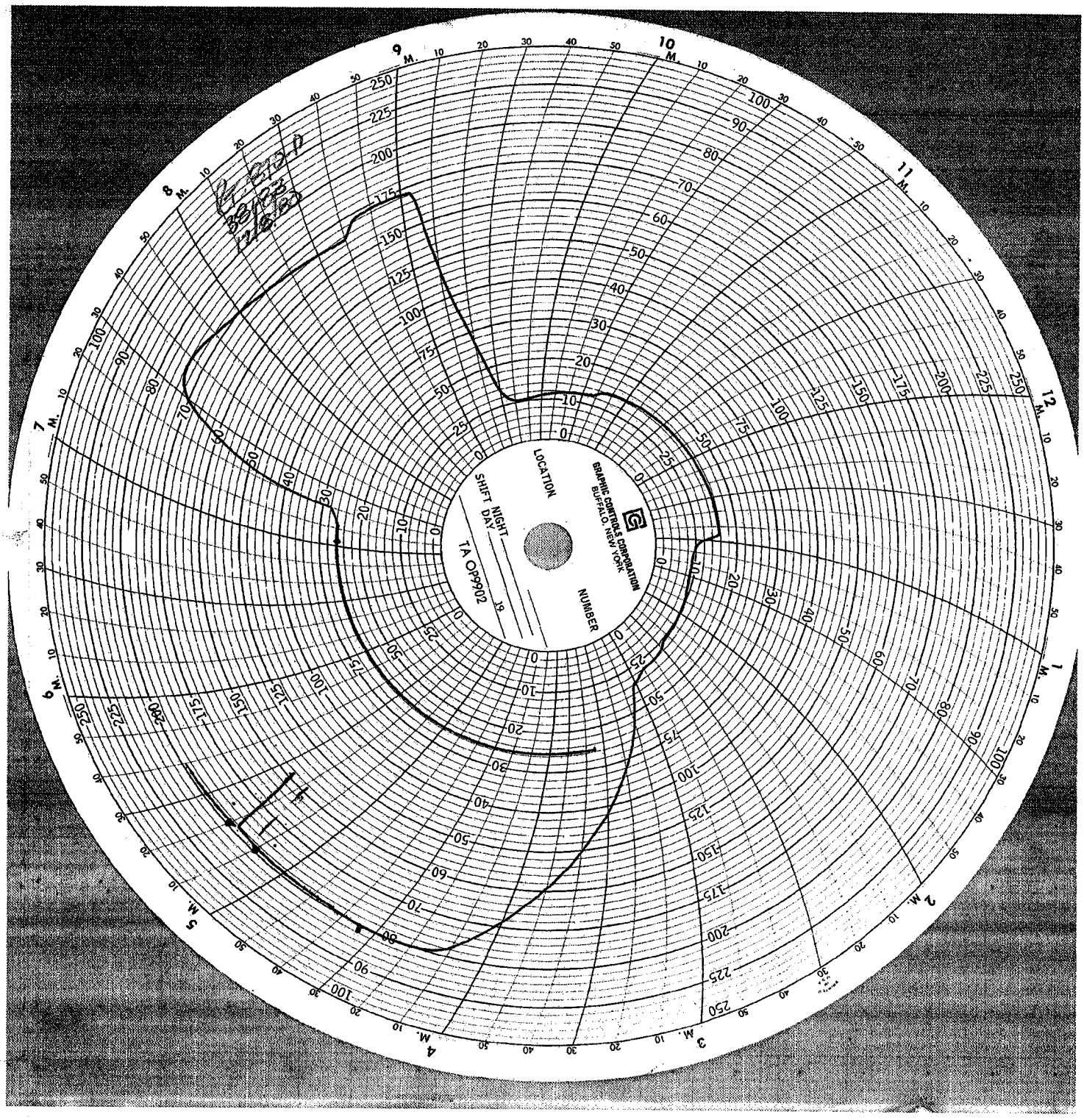

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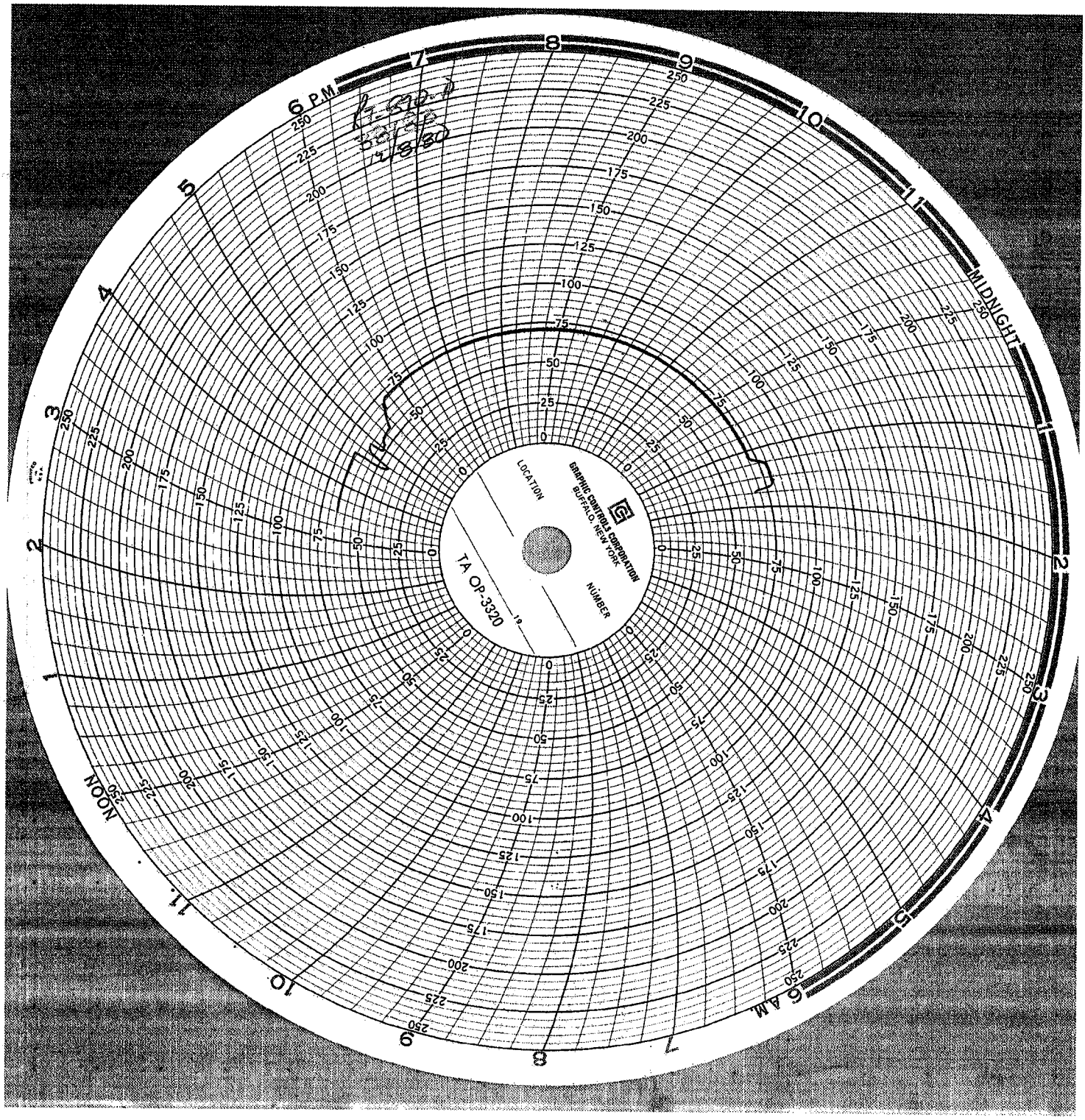

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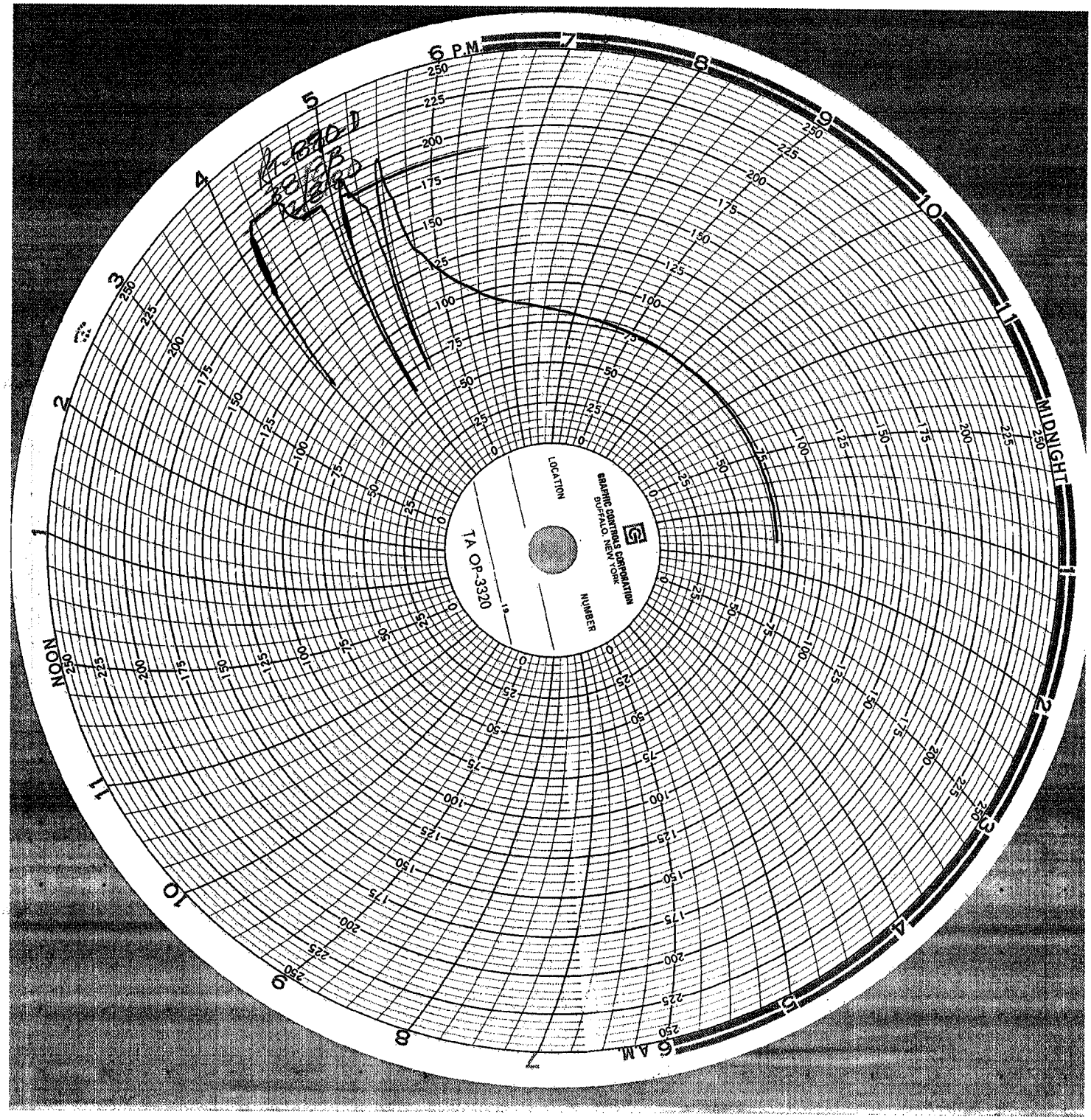

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