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

CG 32 CODE RT-618-D PKG ___

MAY -0-81 - E1280
(DATE) (LOT NUMBER)

PROCESSES
( )RT-618-D (S)
( )ALTERNATE ( )
( ) ( )
TYPED BY: JMH

APPROVED BY
JJG 3-18-81

ESTIMATED WGT 2902 LBS. STANDARD HRS. _____ TIME _____M

PREPARATION NOTES: Pre Coat Sparkler

EQUIPMENT		NAME: WATCHUNG RED Y	USE LBS	N-CODE	ACCT LBS
PREP 1	1	RECORD: 4 BATCHES SINCE SPARKLER LAST CLEANED. AFTER 5 BATCHES, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15#	____	777-A	____
	2	OBTAIN FOR S11		740-C	
	3	OBTAIN FOR S24		253-C	
	4	INSTALL DV & CV RECORDER & CONTROLLER CHART NOTE: NOTIFY PRESS ROOM AND ROPE OFF AREA UNDER V-922			
~~[illegible]~~ 931 2	5	RUN 10"(100G) WATER INTO V-931 & ADJ TO 80-100 DEG F			
	6	ADD IN 1-2 MIN	63	530-A	63
	7	STIR 2 MIN & RECORD: PH 10.0 (9.5-10.5)			
	8	STIR 20 MIN OR LONGER FOR S27			
922 3	9	RUN 31" (700G) WATER INTO V-922			
	10	WEIGH IN V-926 & RUN IN M 8, 49.83 %	403	7-D	201
	11	TURN ON AGITATOR & STEAM & DUMP IN FROM S2		740-C	1035
		LOT 100% %	865		
		173 864 99.9			
		188 171 99.50	172		
	12	DUMP IN	50	113-B	50
	13	DUMP IN	10	777-A	10
	14	HEAT TO 212-214 DEG F, RECORD HT 214 F, 214 DEG F WATCH FOAM			
	15	RECORD BY 4 (+), IF NECESSARY ADJ TO +BY ASSUME 50%	____	7-D	____
	16	STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM NOTE: RECORD: SPARKLER PRESSURE 1 PSI IF NOT ZERO, NOTIFY SUPERVISOR			
	17	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 F FOR S19 & RECORD: HT 195 DEG F AND RECORDER 195 DEG F RECORD: START 10 15, TOTAL MIN 210, CLARITY OK. NOTE: SAMPLE FROM HOSE - SHOW TO SUPERVISOR FOR O.K.			

Note: Rcvd. V904 @ 12:40 pm

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 2 OF 3 CG 32 CODE RT-618-D (S)	USE LBS	N-CODE	ACCT LBS
904 4	18	RUN 1" (50G) WATER INTO V-904			
	19	WHEN S17 COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F			
		RECORD: START 1245, TOTAL MIN 35			
MISC 5	20	WEIGH IN 84 LBS FOR S65 M 7, 32.93 %	1008	725-A	332
	21	MEASURE UNITS IN V-928 FOR S33	1309	28-D	419
		M 2, 32.00 %			
CV 6	22	RUN 16" (1530G) WATER INTO V 901			
	23	WEIGH IN V-926 & RUN IN M 8, 49.82 %	1017	7-D	507
	24	DUMP IN FROM S3 LOT 536		253-C	912
	25	~~WEIGH ON POSTAL SCALE & DUMP IN LOT~~			
	26	ADJ TO 70-90 DEG F & STIR TO DISSOLVE			
	27	STEAM EJECT V-921/931 INTO CV			
922 7	28	WHEN S19 COMPLETE, SHUT OFF PUMP & INSERT V-922 FOOT PLUG			
	29A	RUN IN 10" (207G) WATER & HEAT TO 190-195 F			
		CIRCULATE 15 MIN THRU SPARKLER.			
904 8	29B	PUMP V-922 THRU SPARKLER INTO V-904			
922 9	30A	RUN IN 5" (103G) WATER INTO V-922 & HEAT TO 190-195 F. CIRCULATE 15 MIN THRU SPARKLER			
904 10	30B	PUMP V-922 THRU SPARKLER INTO V-904			
	31	WHEN MTY BLOW OUT SPARKLER INTO V-904			
	32	HEAT TO 165-170 F (SMPL TO SUPVR FOR O.K.)			
	33	RUN IN N-28-D FROM S21 IN 12-15 MIN & STIR 5 MIN AT 165-170 DEG F			
	34	ADJ TO 129"(3409G) AT 28-30 DEG F AND			
		RECORD: TEMP 28 DEG F, 129"	51 X330	57-A	10830
	35	RUN IN N-725-A FROM S20 AFAP (5-10 MIN)			
	36	STIR 30 MIN AT 28-35 DEG F MAINTAINING +CR, +KI FOR S41 AND RECORD:			
		TIME START 4:30 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			
		RECORD: CR_____(+), KI_____(+) ASSUME 33%	_____	725-A	_____

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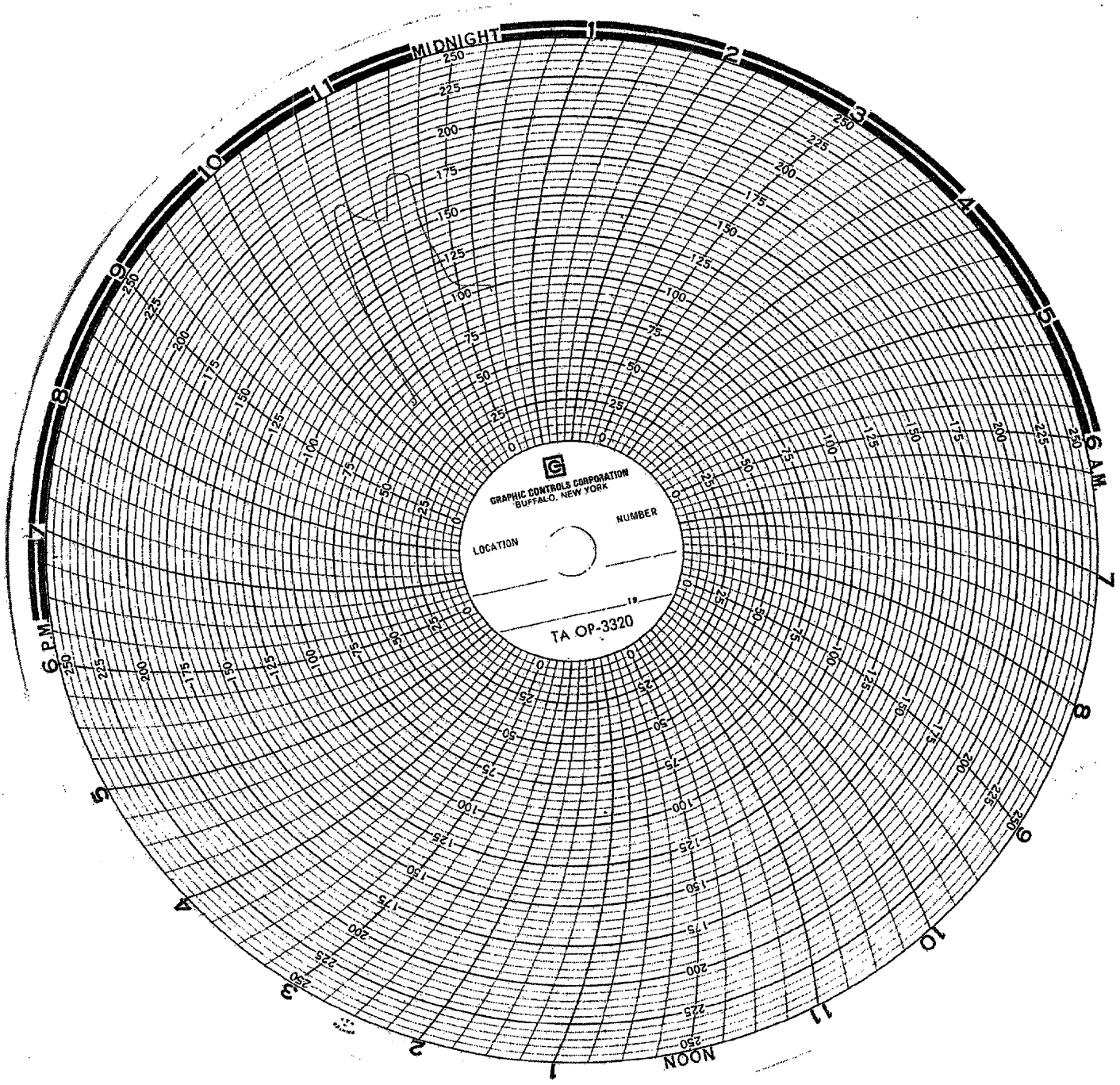
EQUIPMENT		PAGE 3 OF 3 CG 32 CODE RT-618-D (S)	USE LBS	N-CODE	ACCT LBS
CV 11	37	DUMP INTO CV	180	65-A	180
	38	ADJ TO 37" (3496G) AT 28-32 DEG F	35X330	57-A	____
		RECORD: TEMP 35 NT28 DEG F & VOLUME 59 "			
	39	WEIGH IN FROM DRUM	239	165-A	239
	40	STIR 2-3 MIN			
	41	IMMEDIATELY COUPLE DV THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 45-60 MIN. MAINTAIN CV AT 28-32 DEG F. RECORD: START 5.05 Pm TOTAL MIN 53	____	57-A	____
	42	STIR 30 MIN & RECORD: BASE + (+), DIAZO − (-), PH 9.65 (9.0-9.8) FINAL TEMP 34 DEG F			
	43	IF NECESSARY, ADJ TO PH 9.0-9.8 ASSUME 50%	____	7-D	____
		& RECORD: PH_____ ASSUME 32%	____	28-D	____
	44	HEAT TO 184-186 DEG F IN 65-70 MIN AND RECORD: HT 184 DEG F & RECORDER 182 DEG F			
DV 12	45	RUN 24 " (600G) WATER INTO DV			
	46	TURN ON AGITATOR & STEAM & DUMP IN	1620	16-B	1620
	47	HEAT TO ~~155-160~~ 184-186 DEG F & STIR TO DISSOLVE			
CV 13	48	WHEN S44 COMPLETE, IMMEDIATELY STRIKE DV THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 7-10 MIN. MAINTAIN CV AT 184-186 DEG F. RECORD: START 7:38 Pm, TOTAL MIN 12			
	49	HEAT CV TO 198-202 DEG F IN 10-12 MIN			
	50	STIR 5 MIN AT 198-202 DEG F			
	51	FLOOD TO 180-190" (+/-18,000G)			
	52	RECORD: PH 8.8 (9.0-9.4) & STOP AGITATOR			
		9 START 1:15 AM FIN 3 Pm OPTR 120			
		3:00 Pm 10:00 Pm 144			
		WHEN INSTRUCTED BY PROCESSING AREA HALF WAY THRU PRESSING, DUMP IN, STIR 5 MIN. AND STOP AGITATOR. RESUME PRESSING.	10	588-A	10



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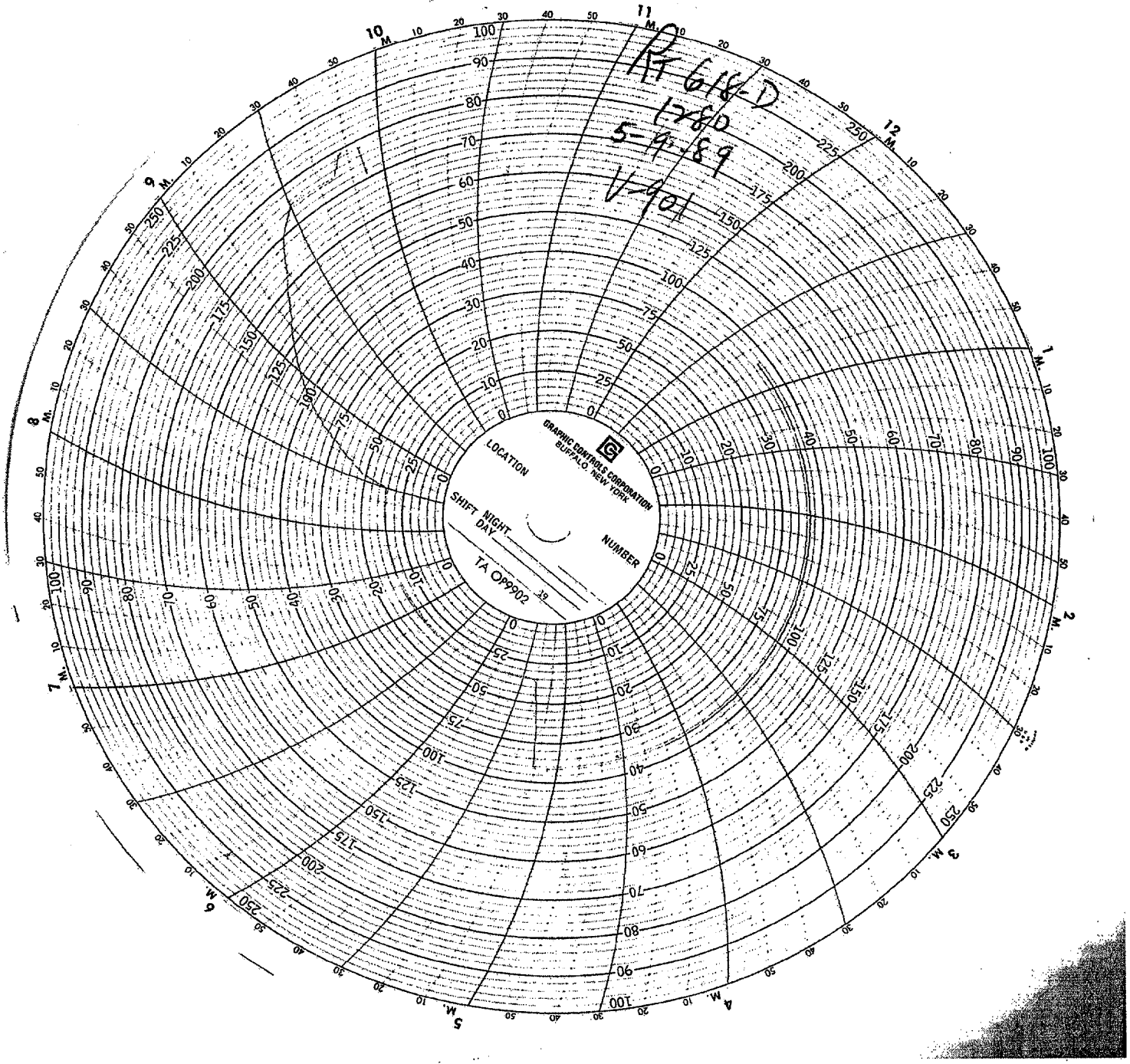

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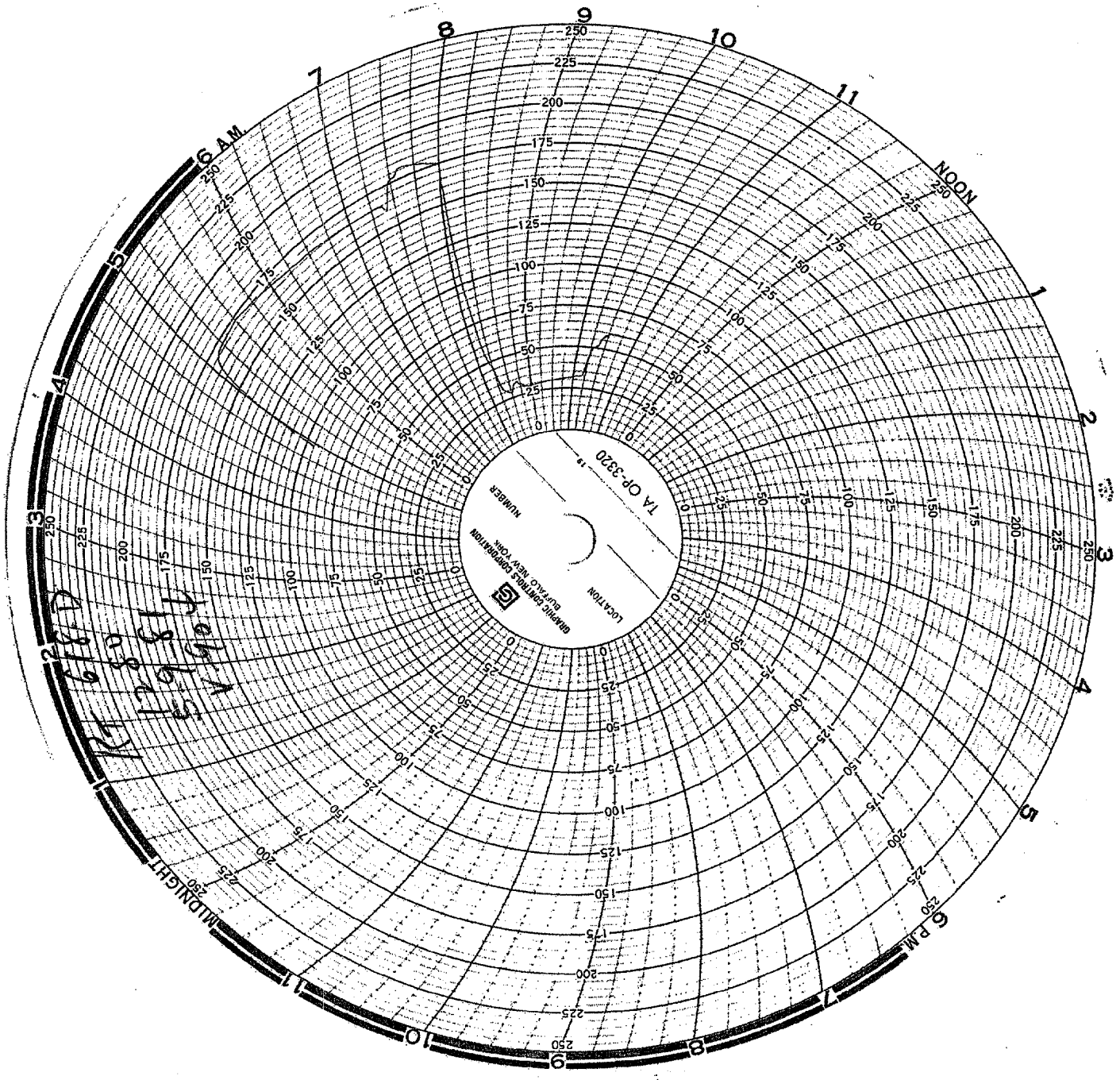

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