DATE PRINTED: 6/02/82

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

CG 32 CODE RT-880-D PKG ___ PROCESSES APPROVED BY

JUN 15 1982 F2K36 ( )RT-880-D (F) EWK 12-28-81

(DATE) (LOT NUMBER)

TYPED BY: JMH

EST. WT. 2026* LBS. STANDARD HRS. 9.3 TIME _____M

PREPARATION NOTES: _____

Pre Coat Sparkler NON-BLEEDING

EQUIP MENT		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____,_____PR SUPV START MAKING_____M_____/_____MAKING SUPV			
		NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V-922			
		NOTE: RUN 15" WATER INTO V-904. PUMP WATER FROM V-904 THRU DISTRIBUTOR. IF WATER DOES NOT COME OUT OF ALL DISTRIBUTOR HOLES WITH FULL FORCE, NOTIFY SUPERVISOR			
PREP 1	1	RECORD:____BATCHES SINCE SPARKLER LAST CLEANED. AFTER 4 BATCHES, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15# DICALITE, FILTER AID	15	777-A	15
	2	OBTAIN FOR S11 2-CHLORO-4-AMINOTOLUENE-5-SULFONIC ACID		740-C	
	3	OBTAIN FOR S27 3-HYDROXY-2-NAPHTHOIC ACID		82-C	
	4	INSTALL DV & CV RECORDER & CONTROLLER CHART			
921/ 931 2	5	RUN 9" (90G) WATER INTO V-921 & ADJ TO 80-100 DEG F			
	6	ADD IN 2-3 MIN DRESINATE XX	88	99-A	88
	7	STIR 5 MIN & RECORD PH 9.8 (9.5-10.5)			
	8	STIR 20 MIN OR LONGER TO DISSOLVE FOR S36		JUN 22 1982	
922 3	9	RUN 31" (639G) WATER INTO V-922			
	10	WEIGH IN SODIUM HYDROXIDE IN V-926 & RUN IN M 10 49.55 %	367	7-D	182
	11	TURN ON AGITATOR & STEAM & DUMP IN FROM S2		740-C	927
		LOT ÷100% %			
		2-CHLORO 284 927 98.57	940		
		4-AMINO TOLUENE _____ _____ _____			
		5-SULFONIC _____ _____ _____			

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EQUIPMENT		PAGE 2 OF 4 CG 32 CODE RT-880-D (F)	USE LBS	N-CODE	ACCT LBS
922 3 CONT.	12	DUMP IN ACTIVATED CARBON	25	113-B	25
	13	DUMP IN FILTER AID	10	777-A	10
	14	HEAT TO 212-214 DEG F WATCH FOAM!!			
	15	RECORD: BY +__ MUST BE +, ADJ IF NECESSARY SODIUM HYDROXIDE ASSUME 50%		7-D	
	16	STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM! NOTE: RECORD SPARKLER PRESSURE 0 PSI. IF NOT ZERO NOTIFY SUPERVISOR.			
	17	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 DEG F FOR S24. RECORD: START 12:NOON TOTAL MIN 15 CLARITY CLEAR.			
	18	RECORD: HT 195 F & REC 195 F			
MISC 4	19	WEIGH SODIUM NITRITE IN PT-1 FOR S45 M 9 , 33.36%	902	725-A	301
	20	WEIGH SODIUM NITRITE IN DRUM FOR S51 M 9 , 33.36%	105	725-A	35
	21	WEIGH SODUM NITRITE IN DRUM FOR S52 M 9 , 33.36%	105	725-A	35
	22	MEASURE 91½ UNITS IN V-928 FOR S42 HYDROCHLORIC ACID M 1 , 29.89%	1475	28-D	447
904/CV 5	23	RUN 1* (G) WATER INTO V- 901			
	24	NOTE USE CV IF MTY, IF CV NOT MTY USE V-904 WHEN S18 IS COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F. RECORD: START 2:17PM TOTAL MIN 30			
902 6	25	RUN 53* (1383G) WATER INTO V-902			
	26	WEIGH SODUM HYDROXIDE IN V-926 & RUN IN M 10 , 49.55%	767	7-D	380
	27	DUMP IN FROM S3 LOT		82-C	848
		3-HYDROXY 7488	145		
		2-NAPHTHOIC ACID 7664	703		
	28	ADJ TO 70-90 DEG F & STIR TO DISSOLVE			
922 7	29	WHEN S24 COMPLETE, SHUT OFF PUMP & INSERT V-922 FOOT-PLUG			
	30A	RUN IN 10* (209G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER.			
		CIRCULATE 15 MIN THRU SPARKLER.			
904/CV 8	30B	PUMP V-922 THRU SPARKLER INTO V-904/CV			
922 9	30C	RUN IN 5* (104G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER.			
904/CV 10	31	PUMP V-922 THRU SPARKLER INTO V-904/CV			
	32	WHEN MTY BLOW OUT SPARKLER INTO V-904/CV			

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EQUIPMENT		PAGE 3 OF 4 CG 32 CODE RT-880-D (F)	USE LBS	N-CODE	ACCT LBS
~~904~~/CV 10 CONT	33	DISSOLVE ALKANOL XC IN 20G WATER AT 135-145			
		WATER FROM HOT WATER MIXER IN DRUM & POUR IN	26	133-B	26
	34	HEAT V-~~904~~/CV TO 165-170 F FOR S41			
902 11	35	WHEN S28 COMPLETE, MEASURE TRISULPHOIL SOAP D IN CALIBRATED CONTAINER, SLURRY WITH 46G	84	39-A	84
		WATER IN DRUM & POUR INTO V-902			
	36	STEAM EJECT IN V-921/931 FROM S8			
PT-2 12	37	RUN SODIUM HYDROXIDE INTO PT M 10 .4955%	214	7-D	106
	38	ADJ TO 17* (59G)			
	39	STIR 5 MIN OR LONGER FOR S57			
		NOTE: IF N-740-C SOLUTION WAS PUMPED DIRECTLY FROM SPARKLER TO CV AT S'S 23 & 24, OMIT S'S 40 & 41			
CV 13	40	RUN 1* (95G) WATER INTO V-_____			
	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 DEG F			
		RECORD: START_____ TOTAL MIN_____			
	42	RUN IN N-28-D HYDROCHLORIC ACID FROM S22 IN 12-15 MIN.			
	43	STIR 5 MIN	44		
	44	ADJ TO 37* (3496G) AT 32-38 DEG F	~~40~~X330	57-A	14570
		RECORD: TEMP 30 F, STICK 39 *			
	45	RUN IN N-725-A SODIUM NITRITE FROM S19 AFAP (5-10 MIN) & RINSE IN			
	46	STIR 20 MIN AT 32-38 F MAINTAINING +CR, +KI FOR S54 RECORD: TIME START 3:45 PM		57-A	
		CR_____(+) KI_____(+) NOTE:			
		1) IF CR-, KI-, ADD 20# "AS IS" INCREMENTS			
		RECORD: CR_____(+) KI_____(+)			
		HYDROCHLORIC ACID ASSUME 32%		28-D	
		2) IF CR+, KI-, ADD 20# "AS IS" INCREMENTS			
		RECORD: CR_____(+) KI_____(+)			
		SODIUM NITRITE ASSUME 33%		725-A	
	47	DUMP IN CALCIUM CHLORIDE	935	20-A	935
	48	DUMP IN STRONTIUM NITRATE	205	246-B,E	205
	49	DUMP IN BARIUM SULFATE	44	65-A	44
	50	ADD FOR MAINTAINING AT 32-38 DEG F DURING COUPLING	~~32~~X330 20	57-A	6600
	51	POUR IN N-725-A SODIUM NITRITE FROM S20			
902 14	52	POUR N-725-A SODIUM NITRITE FROM S21 INTO V-902			
	53	DUMP IN AMMONIUM CHLORIDE & STIR 2-3 MIN	172	165-A	172
CV 15	54	IMMEDIATELY COUPLE 902 THRU UNDERSUFACE DISTRIBUTOR INTO CV IN 18-22 MIN. MAINTAIN CV AT 32-38 DEG F. RECORD: START 4:25 PM			
		TOATL MIN. 20			
	55	INSTALL 5/16" ORIFICE IN UNDERSURFACE ADDITION LINE			
	56	WHEN S54 COMPLETE, STIR 30 MIN & RECORD:			
		BASE ___ (+) DIA70 ___ (+) PH 50 (5.0-6.0)			

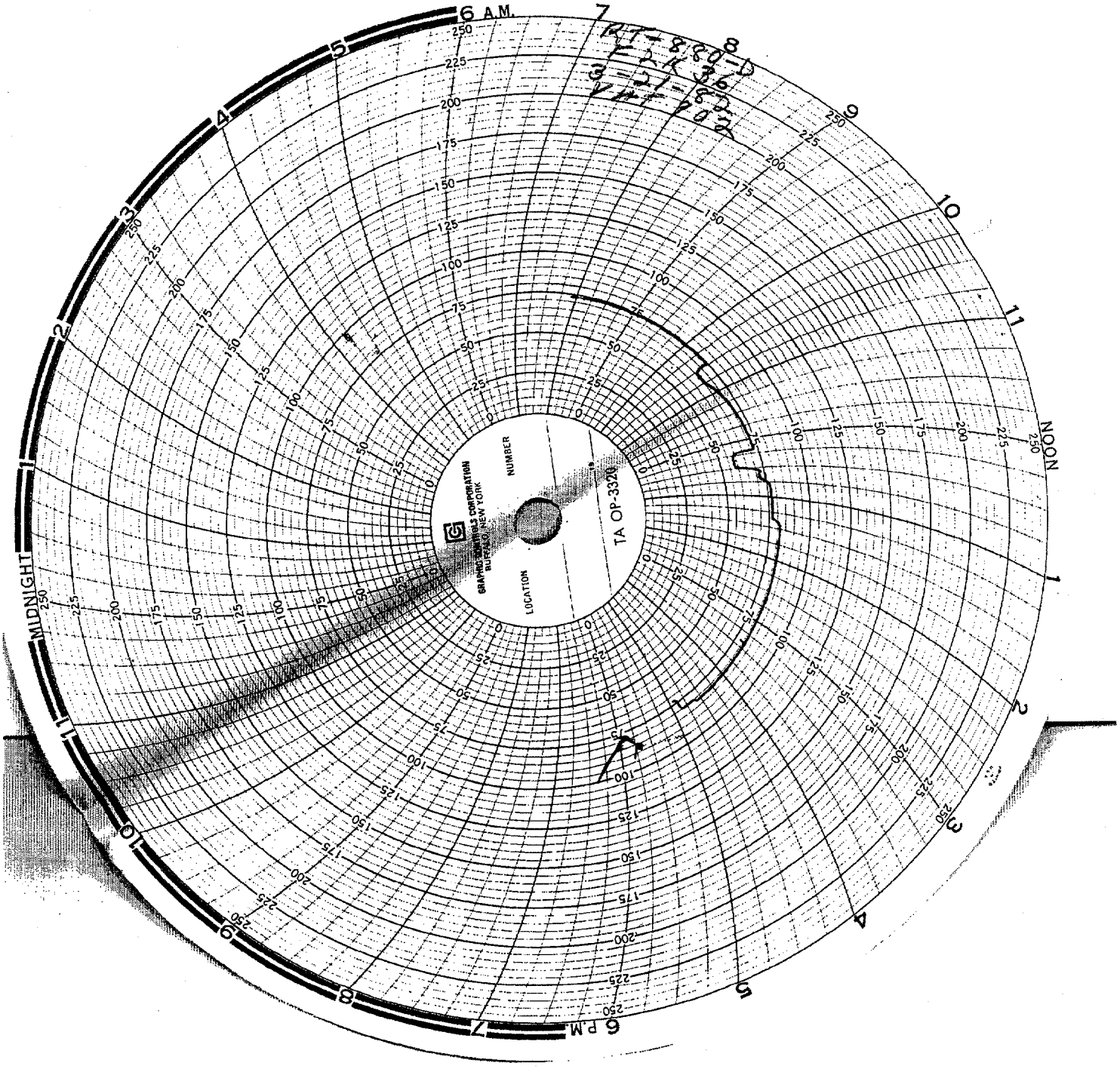
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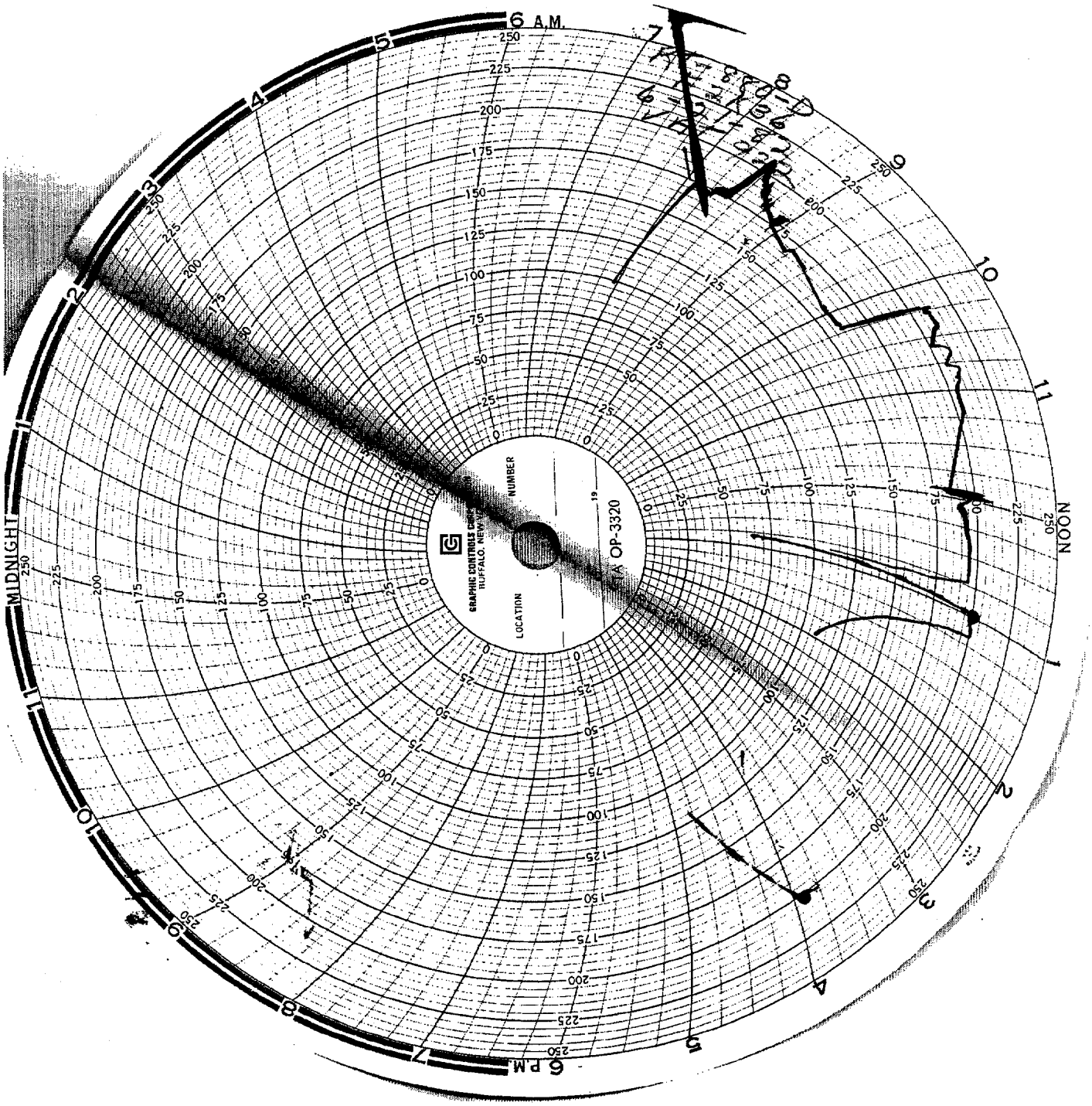
EQUIPMENT		PAGE 4 OF 4 CG 32 CODE RT-880-D (F)	USE LBS	N-CODE	ACCT LBS
CV 15 CONT	57	RUN IN N-7-D FROM S39 THRU 5/16" ORIFICE & RINSE IN RECORD: 42 MIN (40-50 MIN)			
	58	STIR 20 MIN & RECORD: PH 6.7 (7.0-8.5)			
	59	IF PH BELOW 7.0 ADJ TO PH 7.0-8.5 WITH N-7-D ONLY. RECORD PH 7.8 ASSUME 50%	40	7-D	20
	60	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN ASSUME 50%	88	7-D	44
	61	STIR 15 MIN & RECORD: BASE + (+)			
		DIAZO + (-) PH 8.7 (9.0-9.8)			
	62	IF PH BELOW 9.0 ADJ TO PH 9.0-9.8 WITH N-7-D ONLY. RECORD PH 9.6 DIAZO - BASE +			
		SODIUM HYDROXIDE ASSUME 50%	50	7-D	25
	63	MEASURE I OCTANOL IN CALIBRATED CONTAINER & POUR IN	31	588-A	31
	64	HEAT TO 193-195 DEG F IN 75-80 MIN. RECORD START 6:45 PM			
	65	RECORD: HT ___ DEG F & REC 196 DEG F			
	66	STIR 60 MIN AT 193-195 DEG F. RECORD: START 8:00 P.M.			
	67	AFTER 20 MIN S66 STIR RECORD: PH 8.4 (8.8-9.3)			
	68	IF PH BELOW 8.8, ADJ TO PH 8.8-9.3 WITH N-7-D ONLY. RECORD PH 9.0			
		SODIUM HYDROXIDE ASSUME 50%	110	7-D	55
	69	WHEN S66 COMPLETE, FLOOD TO 180-190° (+/-18,000G)			
	70	STOP AGITATOR			
		WHEN INSTRUCTED BY PROCESSING AREA HALFWAY THRU PRESSING			
		(1) DUMP IN I OCTANOL	10	588-A	10
		(2) STIR 5 MIN			
		(3) ADVISE PROCESSING TO RESUME PRESSING			

START	FIN	OPTR
7 A.M.	3 PM	54
3:00 PM	9:30 P.M.	321

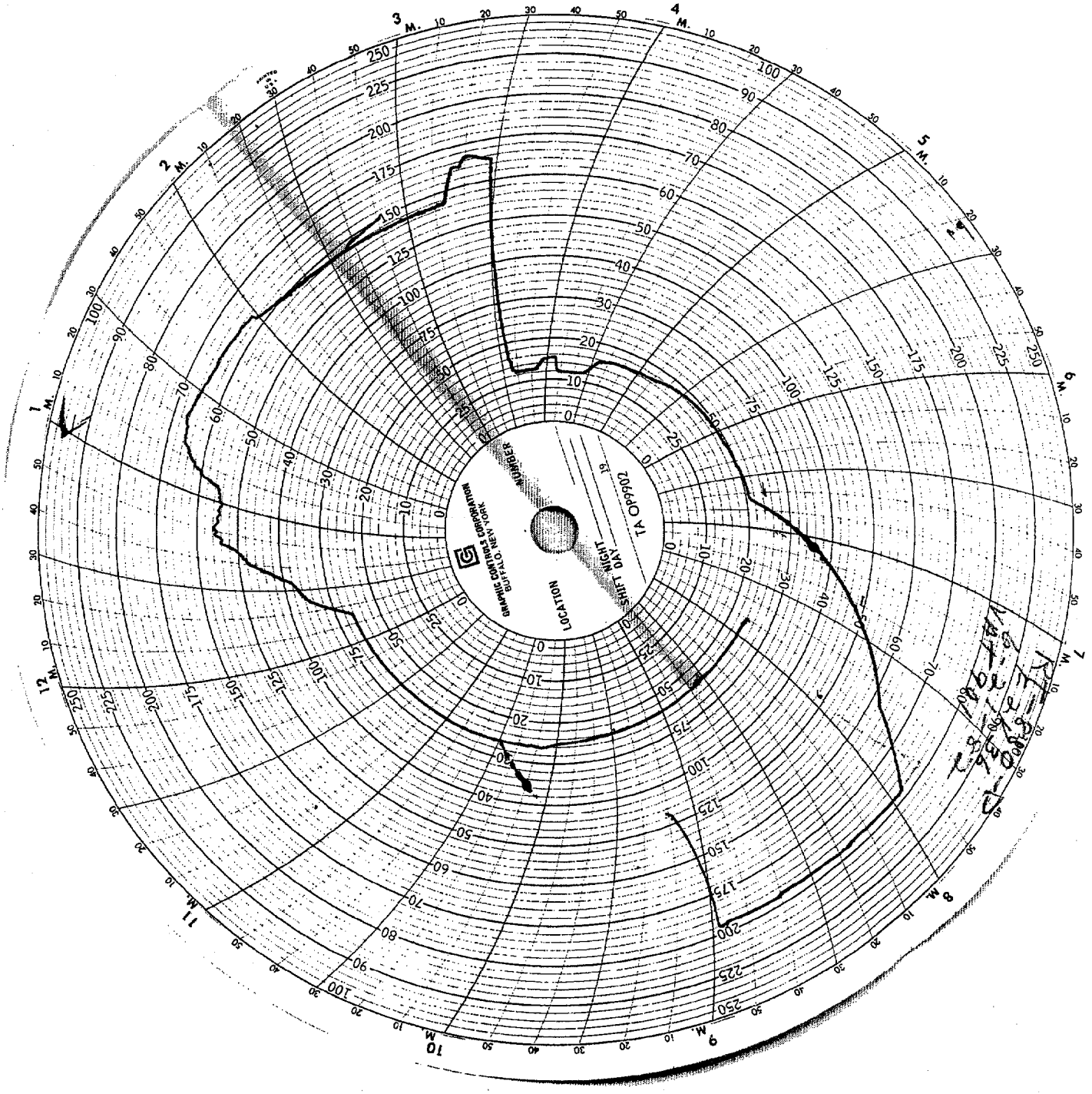
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