CG 32 CODE RT-761-D PKG. _____

→ MAY -0·81- Σ1087

EST. WGT. ~~2660~~ 2790 LBS.

STD. HRS. _____ TIME _____ M

PROCESSES		APPROVED BY
( ) RT-761-D	(J)	JJG 4-4-78
( ) RT-838-D	(I)	DCG 4-5-78
( )	( )	MTW 4-13-78
( )	( )	
TYPED BY		
NSA 4-19-78		

NON-BLEEDING

JIPMENT		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. Making Supv to review with P.R. Supv. & Record: Press will be ready ____ M ____ / ____ P.R. Supv ____ Start Making ____ M ____ / ____ Making Supv ____			
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 12		740-C	
	3	Obtain for S 27		82-C	
	4	Install DV & CV Recorder & Controller charts			
921/ 931	5	Run 16" (160 G) water into V-____ & adj to 80-100°F			
	6	Add in 2-3 min	110	99-A	110
	7	Add in 1-2 min	50	530-A	50
	8	Stir 5 min & Record: pH ____ (9.5-10.5)			
	9	Stir 20 min or longer to dissolve for S 30			
922 3	10	Run 35" (722 G) water into V-922			
	11	Weigh in V-926 & run in ____ M ____ %		7-D	216
	12	Turn on agitator & steam & dump in from S 2 Lot ____ #100% ____ %		740-C	1106
	13	Dump in	25	113-A	25
	14	Dump in	10	777-A	10
	15	Heat to 212-214°F Watch Foam			
	16	Record: BY ____ must be +. Adj if needed Assume 50%		7-D	
	17	Stir 15 min at 212-214°F, then shut off steam. Watch Foam			
	18	Record: HT ____ F & Rec ____ F			
	19	Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 24			
Misc. 4	20	Measure ____ units in V-928 for S 39 M ____ %		28-D	533
	21	Weigh in PT for S 42 M ____ %		725-A	401
	22	Weigh in drum for S 48		725-A	40
904/CV 5	23	Run 1" (____ G) water into V-____ Note: Use CV if MTY. If CV is not MTY, use V-904			
	24	When S 19 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start ____ Total Min ____			

EQUIPMENT		PAGE 2 CG 32 CODE RT-761-D (J) LBS.	USE LBS.	N CODE	ACCT. LBS.
902 6	25	Run 56" (1566 G) water into V-902			
	26	Weigh in V-926 & run in M %		7-D	682
	27	Dump in from S 3 Lot		82-C	1012
	28	Adj to 70-90°F & stir 10 min to dissolve			
	29	Slurry in 30 Gal water & pour into V-902	100	39-A	100
	30	Steam eject in V-921-931 from S 9			
922 & 904/CV 7	31	When S 24 complete, stop pump & insert V-922 foot plug			
	32	Run in 12" (247 G) water & heat to 180-190°F			
	33	Pump V-922 thru sparkler into V-904/CV			
	34	When V-922 MTY blow out sparkler into V-904/CV			
	35	Weigh & add to V- Lot	18 oz	749-C	1
	36	Heat V-904/CV to 165-170°F for S 39			
		NOTE: If N-740-C solution was pumped directly from sparkler to CV at S's 23 & 24 omit S's 37 & 38			
CV 8	37	Run in 1" (95 G) water into V-			
	38	If V-904 is used, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min) maintain CV at 165-170°F			
	39	Run in N-28-D from S 21 in 12-15 min			
	40	Stir 5 min			
	41	Adj to 43" (4080 G) at 32-38°F	45 x 330	57-A	
	42	Run in N-725-A from S 21 AFAP (5-10 min)			
	43	Stir 10 min at 32-38°F maintaining + CR, + KI			
		Record: Time Start 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 (+)			
	44	Dump in	1116	20-A	1116
	45	Dump in	244	246-B	244
	46	Dump in	130	65-A	130
	47	Add for maintaining 32-38°F during coupling	36x330	57-A	
902 9	48	Pour N-725-A from S 22 into V-902			
	49	Dump in	189	165-A	189
CV 10	50	Immediately couple V-902 thru undersurface distributor into CV in 18-22 min. Maintain CV at 32-38°F			
		Record: Start Total Min			
	51	Stir 5 min & Record: Base (+), Diazo (-) pH (9.0-9.8)			
	52	If necessary, adj to pH 9.0-9.8 Record: pH Assume 50%		7-D	
		Assume 32%		28-D	
	53	Weigh in drum & pour in	45	588-A	45
	54	Heat to 184-186°F in 70-75 min			
	55	Record: HT °F & Rec °F			
	56	Stir 30 min at 184-186°F			
	57	After 10 min S 56 stir, record: pH (8.8-9.3)			
	58	If necessary, adj to pH 8.8-9.3 Assume 50%		7-D	
		Record: pH If pH above 9.3 do not adjust			
	59	When S 56 complete, flood to 180-190" (± 18000 G) & stop agitator			

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EQUIPMENT		PAGE 2 CG 32 CODE RT-761-D (J), RT-838-D (H) LBS.	USE LBS.	N CODE	ACCT LBS.
902	25	Run 56" (1566 G) water into V-902			
6	26	Weigh in V-926 & run in M 8 49.83 %	1475	7-D	735
	27	Dump in from S 3 Lot		82-C	1058
		6099	1000		
		6094	58		
	28	Adj to 70-90°F & stir 10 min to dissolve			
	29	Slurry in 30 Gal water & pour into V-902	105	39-A	105
	30	Steam eject in V-921-931 from S 9			
922 &	31	When S 24 complete, stop pump & insert V-922 foot plug			
[redacted]/CV	32	Run in 10" (247 G) water & heat to 180-190°F + Circulate 15 MIN thru Sparkler			
7	32	Pump V-922 thru sparkler into V-904/CV (See Below For S 33)			
	34	When V-922 MTY blow out sparkler into V-904/CV			
903	35	Weigh & add to V- 903 Lot 1	4	148-C	4
	36	Heat V-[redacted]/CV to 165-170°F for S 39			
		NOTE: If N-740-C solution was pumped directly from sparkler to CV at S's 23 & 24 omit S's 37 & 38			
CV	37	~~Run in 1" (55 G) water into V-903~~			
8	38	~~If V-904 is used, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min) maintain CV at 165-170°F~~			
	39	Run in N-28-D from S 21 in 12-15 min			
	40	Stir 5 min (SMALL)			
	41	Adj to 43" (4080 G) at 32-38°F	71 ~~50~~ x 330	57-A	2243
71	42	Run in N-725-A from S 21 AFAP (5-10 min)			
	43	Stir 30 min at 32-38°F maintaining + CR, + KI			
		Record: Time Start 9 AM 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 (+)			
	44	Dump in	1166	20-A	1166
	45	Dump in	255	246-B	255
	46	Dump in	135	65-A	135
25	47	Add for maintaining 32-38°F during coupling	25 ~~36~~x330	57-A	8250
902	48	Pour N-725-A from S 22 into V-902			
9	49	Dump in	189	165-A	189
CV	50	Immediately couple V-902 thru undersurface distributor into			
10		CV in 18-22 min. Maintain CV at 32-38°F			
		Record: Start 10 95 Total Min 25			
	51	Stir 30 min & Record: Base + (+), Diazo + (-)			
		pH 10.3 (10.0-10.5)			
	52	If necessary, adj to pH 10.0-10.5 Record: pH ✓ Assume 50%		7-D	
		Assume 32%		28-D	
	53	Weigh in drum & pour in	45	588-A	45
	54	Heat to 184-186°F in 70-75 min (AT 150°F, OPEN WATER SPRAYS 1 1/4 TURNS)			
115	55	Record: HT 185 °F & Rec 185 °F			
	56	Stir 30 min at 184-186°F			
	57	After 10 min S 56 stir, record: pH 9.1 (9.5-10.0)			
	58	If necessary, adj to pH 9.5-10.0 Assume 50%	50	7-D	25
		Record: pH 9.7 If pH above 10.0 do not adjust			
	59	When S 56 complete, flood to 180-190" (± 18000 G) & stop agitator			
		SHUT OFF WATER SPRAYS			
922/904/CV	33	RUN IN 5" (100G) WATER INTO V922. HEAT TO 190-195F. CIRCULATE 15 MIN THRU SPARKLER. PUMP V922 THRU SPARKLER INTO V904/CV			

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EQUIPMENT		PAGE 3 CG 32 CODE RT-761-D (J), RT-838-D (H)	USE LBS.	N CODE	ACCT LBS.
		When instructed by Processing Area half-way thru pressing			
		1. Dump in	10	588-A	10
		2. Stir 5 min			
		3 Advise processing to resume pressing			

START	FIN	OPTR
7am	2 PM	120

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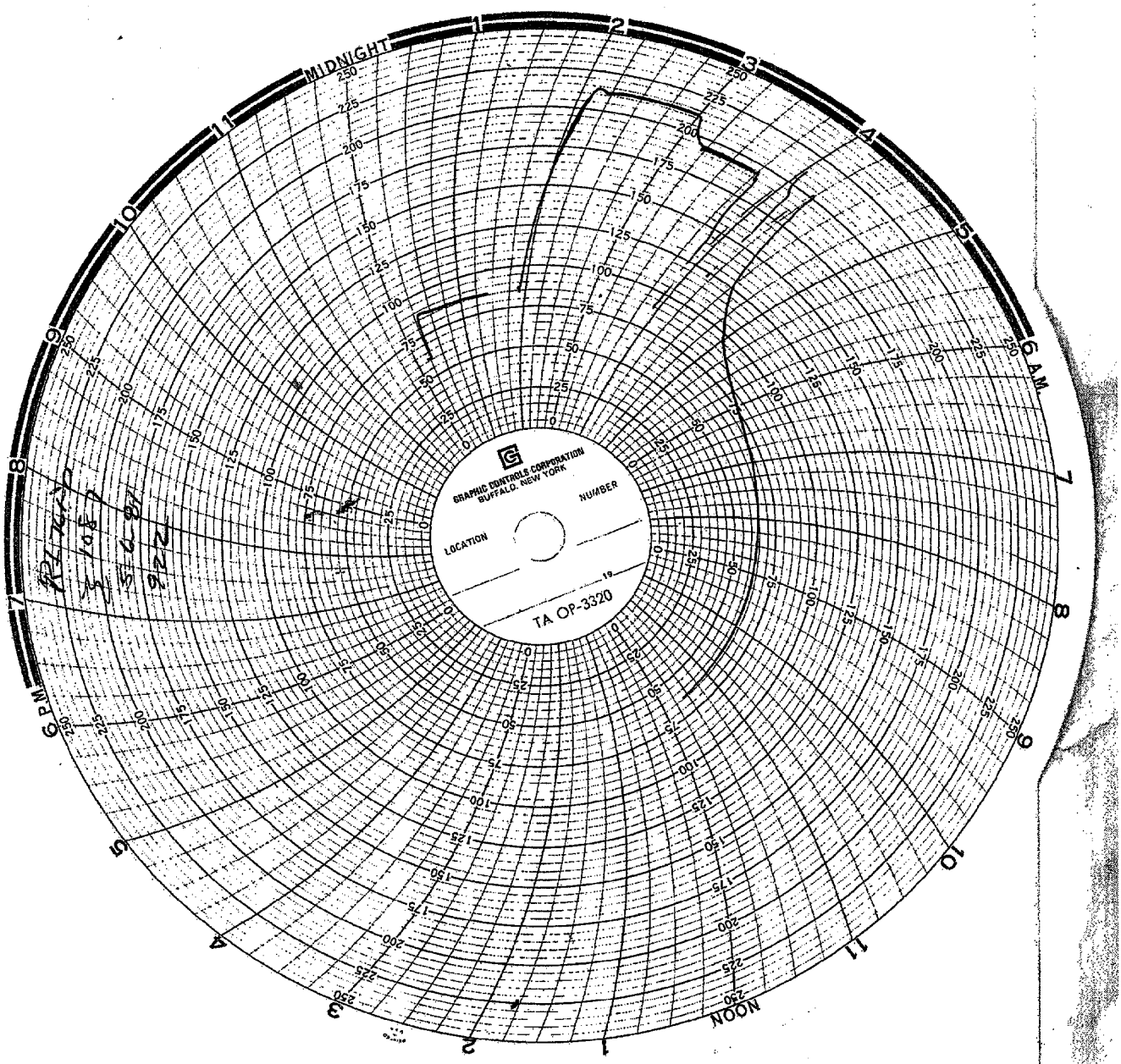
QUIPMENT	PAGE 3 CG 32 CODE PI-761-D (J)	USE LBS.	N CODE	ACCT. LBS.
	When instructed by Processing Area half-way thru pressing			
	1. Dump in	10	588-A	10
	2. Stir 5 min			
	3 Advise processing to resume pressing			

START	FIN	OPTR



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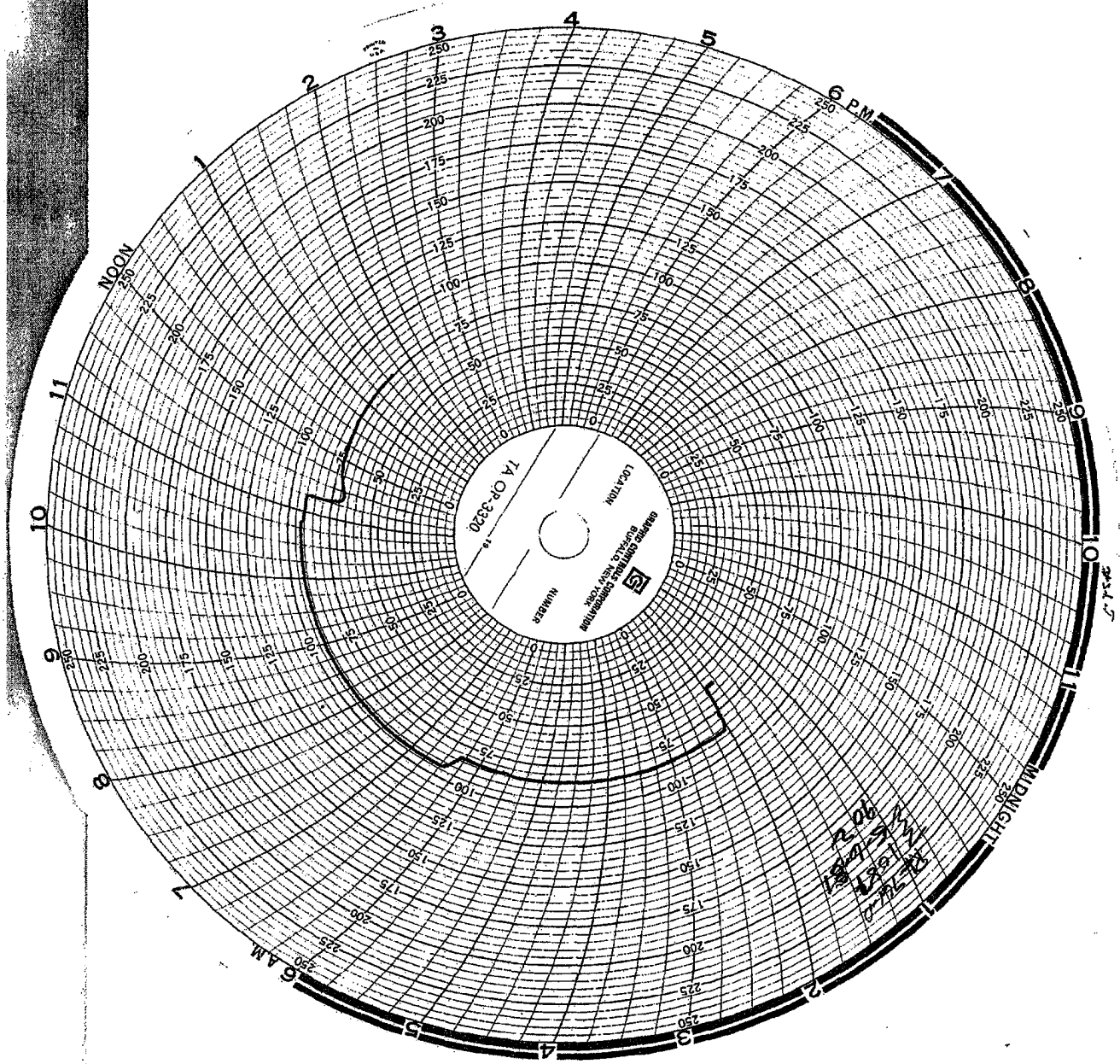

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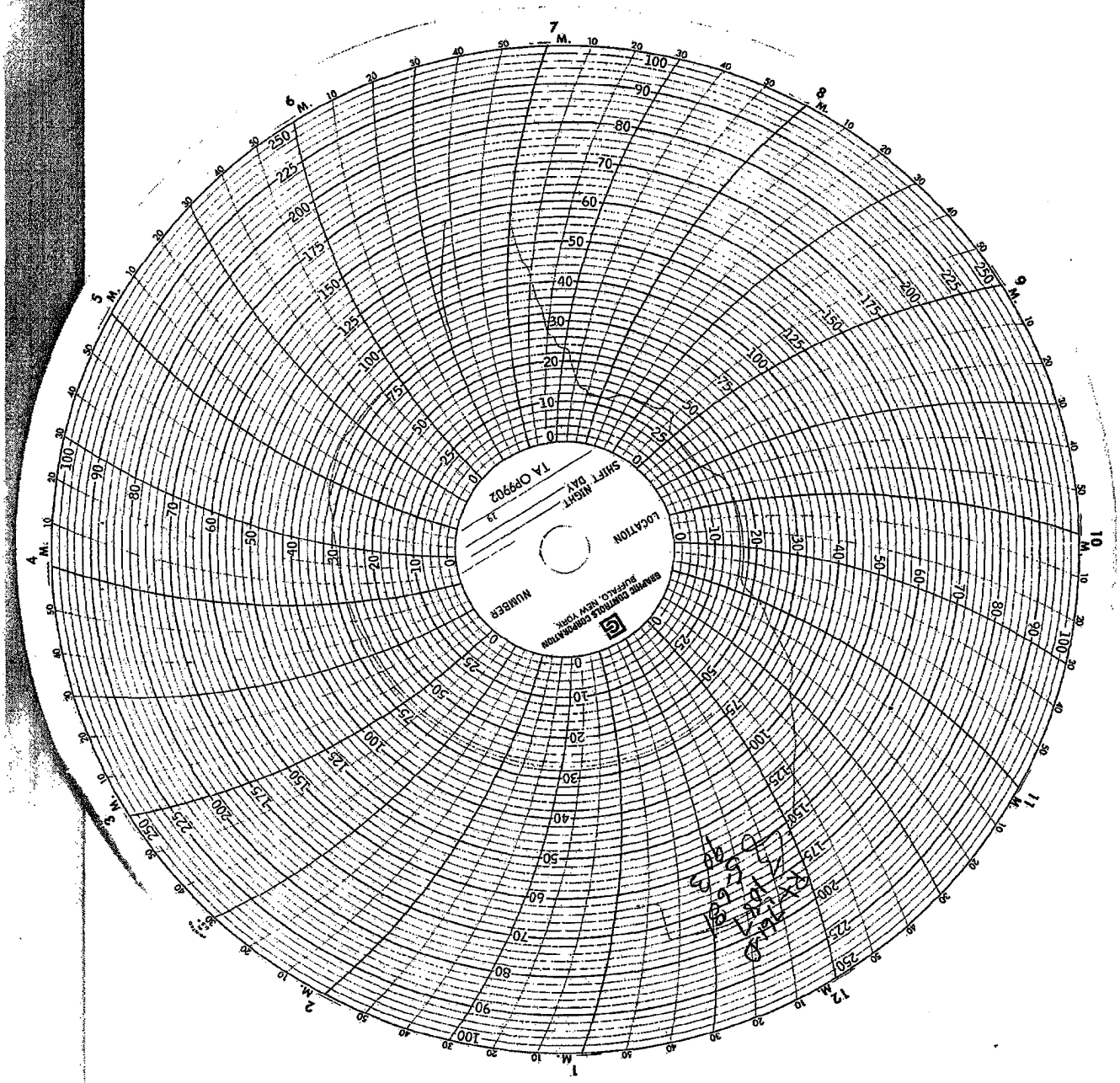

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