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

CG 32 CODE RT-618-D PKG. ____

→ DEC 12 80 38228

EST. WGT. 2597 LBS.

STD. HRS. ____ TIME ____ M

PROCESSES		APPROVED BY
( ) RT-618-D	(T)	JJG 08-15-78
( ) Alternate	( )	AMJ 09-20-78
( )	( )	
( )	( )	
retyped BY		P/R
emw061279		Ewk 061579

PUNCHED & CHECKED DEC 1 1980

NON-BLEEDING

EQUIPMENT		NAME: WATCHUNG® RED Y	USE LBS.	N CODE	ACCT. LBS.
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 11		740-C	
	3	Obtain for S 24		253-C	
	4	Install DV & CV Recorder & Controller charts			
921/ 931 2	5	Run 10" (100 G) water into V-921 & adj to 80-100°F			
	6	Add in 1-2 min	50	530-A	50
	7	Stir 2 min & Record: pH 10.2 (9.5-10.5)			
	8	Stir 20 min or longer for S 27			
922 3	9	Run 28" (620 G) water into V-922			
	10	Weigh in V-926 & run in M 14 . 9887 %	931	7-D	178
	11	Turn on agitator & steam & dump in from S 2		740-C	920
		Lot 118 100% 920 % 9887	931		
	12	Dump in	40	113-B	40
	13	Dump in	10	777-A	10
	14	Heat to 212-214°F. Record: HT 212 ; 212 °F WATCH FOAM			
	15	Record: BY + (÷), if necessary adj to +BY Assume 50%		7-D	
	16	Stir 30 min at 212-214°F, then shut off steam WATCH FOAM		16A- Record: Sparkler Pressure 20 PSI	
	17	Circulate 15 min or longer thru Sparkler until sol'n is clear Maintain at 190-195°F for S 19 & Record: HT 195 °F & Recorder 195 °F Record: Start 830 , Total Min 45 , Clarity OK NOTE: Sample from hose — show to Supervisor for OK		If not zero, notify Supervisor	
904 4	18	Run 1" (50 G) water into V-904			
	19	When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 915 , Total Min 20			
Misc 5	20	Weigh in PT for S 35 M 12 . 3241 %	281	725-A	295
	21	Measure 50¾ units in V-928 for S 33 M 12 . 3241 %	121	28-D	372
CV 6	22	Run 14" (1330 G) water into V-901			
	23	Weigh in V-926 & run in M 14 . 4811 %	915	7-D	450
	24	Dump in from S 3 Lot 504	810	253-C	810
	25	Weigh on postal scale & dump in Lot -		~~180-C~~	~~20~~
	26	Adj to 70-90°F & stir to dissolve			
	27	Steam eject V-921/931 into CV			

F 13829 REV.

EQUIPMENT		PAGE 2 CG 32 CODE RT-618-D (T) EST. WGT. 2597 LBS.	USE LBS.	N CODE	ACCT. LBS.
922	28	When S 19 complete, shut off pump & insert V-922 foot plug			
7	29	Run in 10" (247 G) water & heat to ~~150-190°F~~ 190-195F - circulate 15 Min Thru Sparkler			
		PUMP V922 thru Sparkler in V904			
904	30	~~Pump V-922 thru Sparkler into V-904~~ See attached page for S-30			
8	31	When MTY blow out Sparkler into V-904			
	32	Heat to 165-170°F (Sample to Supervisor for O K)			
	33	Run in N-28-D from S 21 in 12-15 min & stir 5 min at 165-170°F	37		
	34	Adj to 90" (2390 G) at 28-30°F & Record: Temp 25 °F, "	42 x 330	57-A	12210
	35	Run in N-725-A from S 20 AFAP (5-10 min)			
	36	Stir 20 min at 28-35°F maintaining + CR, + KI for S 41		57-A	
		Record: Time Start 1130 , 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 (+)			
CV	37	Dump into CV	25 150	65-A	150
9	38	Adj to 33" (3130 G) at 28-32°F	25 x 330	57-A	8250
		Record: Temp 25 °F & Volume 34 "			
	39	Dump in	212	165-A	212
	40	Stir 2-3 min			
	41	Immediately couple V-904 thru undersurface distributor into CV			
		in 45-60 min. Maintain CV at 28-32°F		57-A	
		Record: Start 1155 , Total Min 35 , Final Temp 25 °F			
	42	Stir 30 min & Record: Base + (+), Diazo — (-),			
		pH 8.8 (9.0-9.8)			
	43	If necessary, adj to pH 9.0-9.8 Assume 50%	80	7-D	40
		& Record: pH 9.7 Assume 32%		28-D	
	44	Heat to 176-178°F in 65-70 min &			
		Record: HT 177 °F & Recorder 177 °F			
DV	45	Run 23 " (600 G) water into DV			
10	46	Turn on agitator & steam & dump in	1440	16-B	1440
	47	Heat to 155-160°F & stir to dissolve			
CV	48	When S 44 complete, immediately strike DV thru undersurface			
11		distributor into CV in 7-10 min. Maintain CV at 176-178°F			
		Record: Start 2PM , Total Min 10			
	49	Heat CV to 198-202°F in 10-12 min			
	50	Stir 5 min at 198-202°F			
	51	Flood to 180-190" (±18,000 G)			
	52	Record: pH 9.2 (9.0-9.4) & stop agitator SAMPLE			
		START FINISH OPTR			
		7AM 3PM 282			
		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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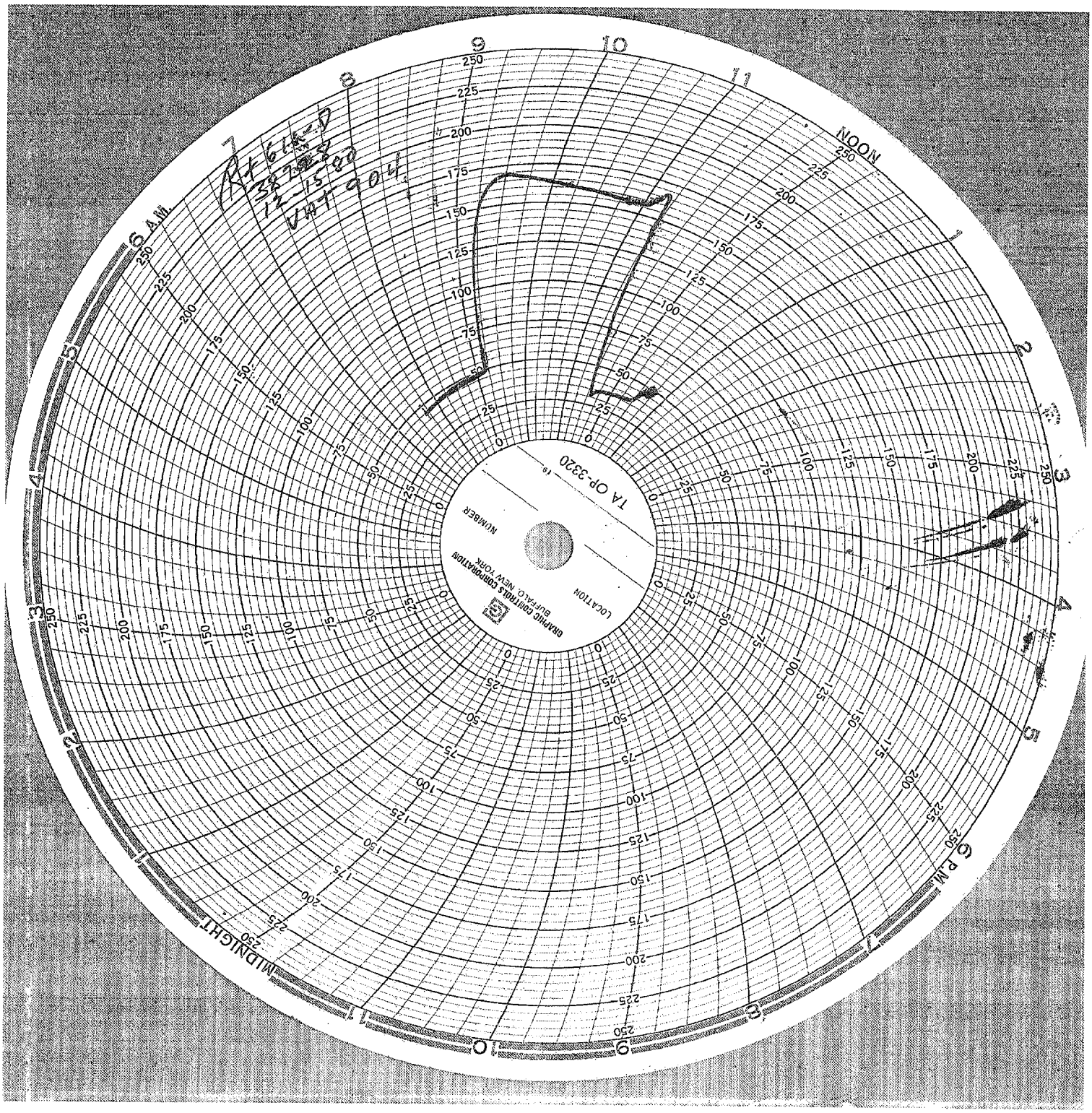
V922	30A	RUN 8" (165 GAL) WATER INTO V-922 & HEAT TO 190-195°F CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR. MAINTAIN 190-195F THRU S-30		
V904	30B	PUMP V-922 THRU SPARKLER INTO V-904		
		CONTINUE WITH S-31		



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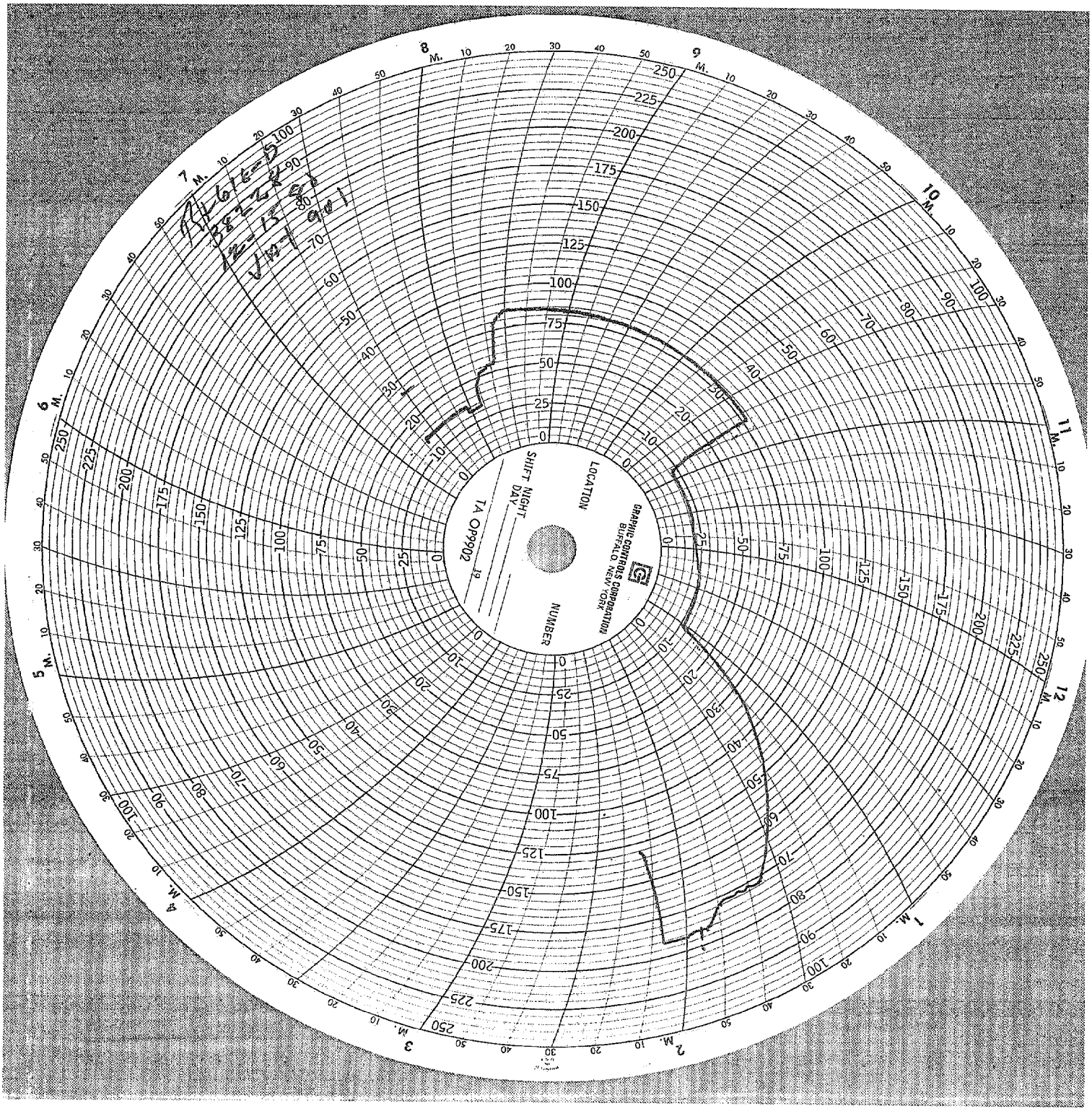

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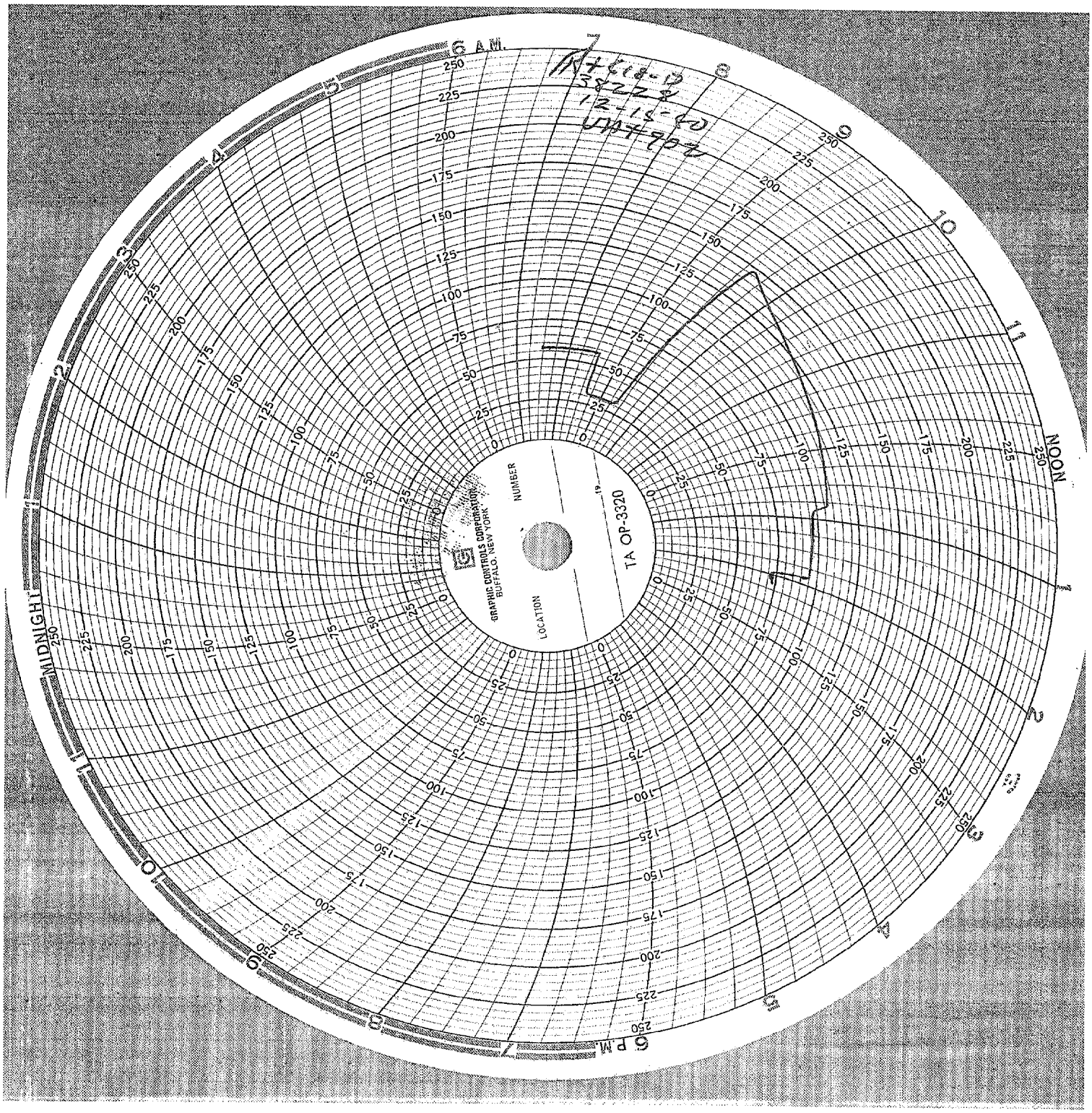

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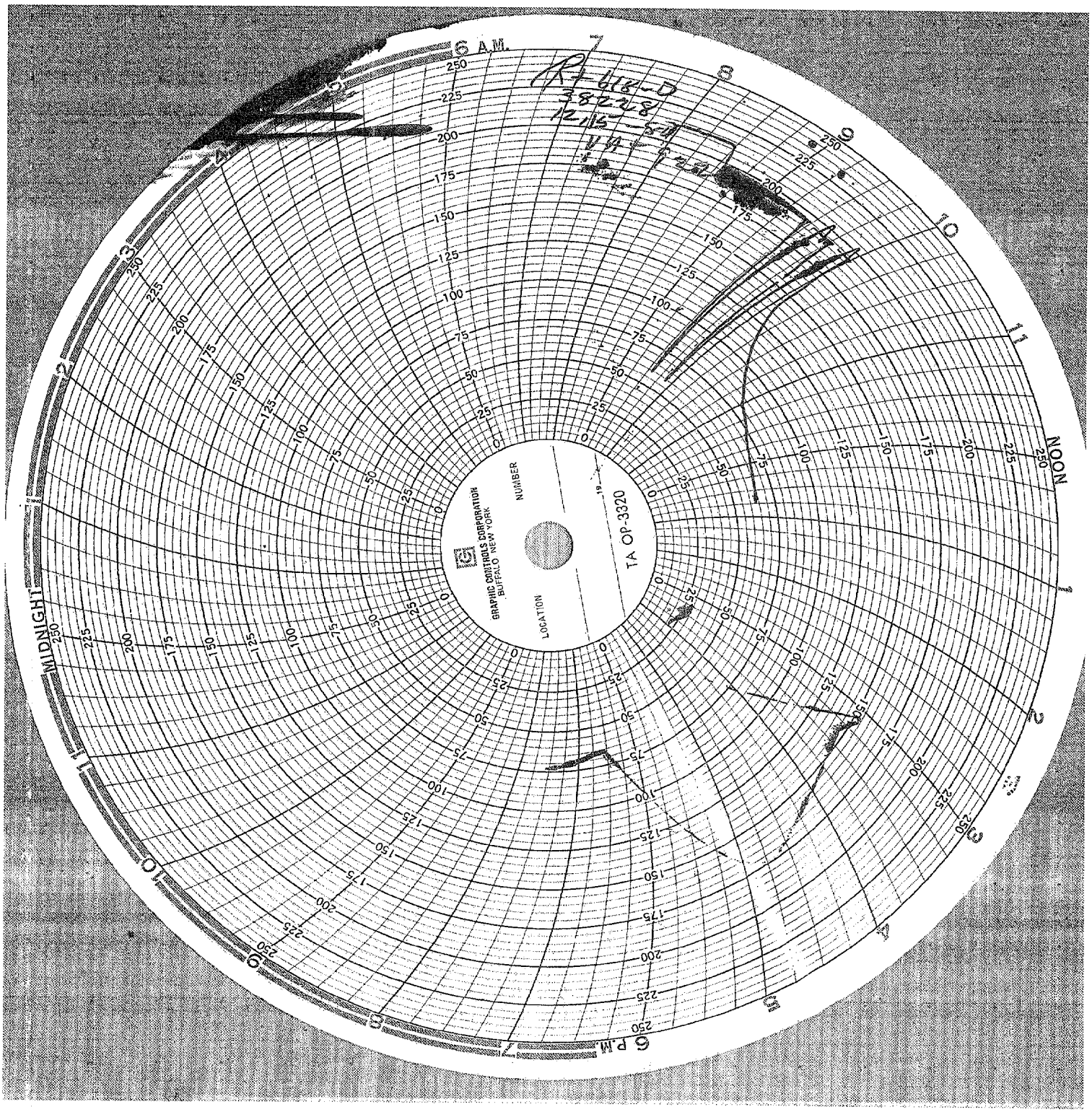

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