

S.V.

C.V. 901,903

D.V. 902,904

CG 32 CODE RT-698-D PKG

PROCESSES

APPROVED BY

E1274

() RT-698-D (M)

(J) RT-698-D ()

() X00-33 ()

(DATE) (LOT NUMBER)

TYPED BY: JMH

ESTIMATED WGT 2757 LBS.

STANDARD HRS.

TIME M

PREPARATION NOTES:

Precoat Sparkler

EQUIP MENT	NAME: WATCHUNG RED B	USE LBS	N-CODE	ACCT LBS
PREP 1	1 IF NECESSARY, CLEAN, DRESS SPARKLER & PRE- 2 COAT WITH 15# 3 OBTAIN FOR S11 4 OBTAIN FOR S41 5 INSTALL DV & CV RECORDER & CONTROLLER CHART 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	15	777-A 740-C 82-C	15
932 2	5 RUN 20" (415G) WATER INTO V-932 & HEAT TO 6 80-100 DEG F 7 ADD IN 8-9 MIN 8 STIR 5 MIN & RECORD: PH <u>10.3</u> (9.5-10.5) 9 STIR 20 MIN OR LONGER TO DISSOLVE FOR S49	400	530-A	400
922 3	NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V-922 10 RUN 35" (722G) WATER INTO V-922 11 WEIGH IN V-926 & RUN IN M <u>9</u> , <u>50.22</u> % 12 TURN ON AGITATOR & STEAM & DUMP IN FROM S2 LOT #100% <u>79.3</u> % <u>172</u> <u>10.87</u> <u>99.50</u> <u>188</u> <u>40</u> 13 DUMP IN 14 DUMP IN 15 HEAT TO 212-214 DEG F WATCH FOAM!!!! 16 RECORD: BY <u>+</u> (+) IF NECESSARY ADJ TO +BY ASSUME 50% 17 STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM. WATCH FOAM. RECORD: SPARKLER PRES- SURE <u>40</u> PSI IF NOT ZERO NOTIFY SUPVR. 18 CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 F FOR S19. RECORD: START <u>11:22pm</u> TOTAL MIN <u>30</u> CLARITY <u>Good</u> HT <u>172</u> F & REC <u>200</u> F	438 1,095 40 25 10	7-D 740-C 113-A 777-A 7-D	220 1127 25 10

MAY 21 1981

5/11

MAKING INSTRUCTIONS: BATCH UNIT

V. C.V. 901, 903

D.V. 902, 904

CG 32 CODE RT-698-D PKG.

→ E 1274

EST. WGT 2760225 LBS.

STD. HRS. TIME M.

PROCESSES	APPROVED BY
() RT-698-D (IT)	JJG 06-01-77
() ()	DCG 06-02-77
() ()	MTW 06-06-77
() ()	
TYPED BY	
EW061677	

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

NON-BLEEDING

EQUIPMENT	NAME: WATCHUNG® RED B	USE LBS.	N CODE	ACCT. LBS.
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 41		82-C	
	4 Install DV & CV Recorder & Controller Charts			
932 2	5 Run 20" (415 G) water into V-932 & heat to 80-100°F			
	6 Add in 8-9 min			
	7 Stir 5 min & Record: pH (9.5-10.5)	400	530-A	400
	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 %		7-D	220
	11 Turn on agitator & steam & dump in from S 2		740-C	1127
	Lot #100% %			
	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 (+) If necessary adj to +BY Assume 50%		7-D	
	16 Stir 15 min at 212-214°F, then shut off steam WATCH FOAM			
	17 Circulate 15 min or longer thru Sparkler until sol'n is clear			
	maintain at 190-195°F for S 19			
	Record: Start Total Min Clarity			
	HT °F & Rec °F			
904 4	18 Run 2" (58 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 Total Min			
902 5	20 Run 55" (1566 G) water into V-902			
	21 Dump in & stir to smooth slurry for S 43	533	542-A	533
Misc 6	22 Measure Units in V-928 for S 35 M %		28-D	543
	23 Weigh in PT for S 38 M %		725-A	402
	24 Weigh in drum for S 44 M %		725-A	30
922 7	25 When S 19 complete, stop pump & insert V-922 foot plug			
	26 Run in 15" (309 G) water & heat to 190-195°F - CIRCULATE 15 MIN THRU SPARKLER - PUMP V922 THRU SPARKLER INTO V904			

S.V.

MAY 05 1981

C.V. 901,903

D.V. 902,904

DATE PRINTED: 4/13/81

CG 32 CODE RT-698-D PKG ---

PROCESSES

APPROVED BY

MAY -0.81-31274

(DATE) (LOT NUMBER)

() RT-698-D (I)
() ALTERNATE ()
() ()

TYPED BY: JMH

ESTIMATED WGT 2449 LBS.

STANDARD HRS. ---

TIME ---M

PREPARATION NOTES: ---

EQUIP MENT		NAME: WATCHUNG RED B	USE LBS	N-CODE	ACCT LBS
PREP 1	1	IF NECESSARY, CLEAN, DRESS SPARKLER & PRE- COAT WITH 15#		777-A	
	2	OBTAIN FOR S11		740-C	
	3	OBTAIN FOR S36		82-C	
	4	INSTALL DV & CV RECORDER & CONTROLLER CHART 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			
932 2	5	RUN 19" (391G) WATER INTO V-932 & HEAT TO 130-140 DEG F			
	6	ADD IN 8-9 MIN	420	99-A	420
	7	STIR 5 MIN & RECORD: PH _____ (9.5-10.5)			
	8	STIR 20 MIN OR LONGER TO DISSOLVE FOR S39			
		NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA AROUND V-922			
922 3	9	RUN 35" (708G) WATER INTO V-922			
	10	WEIGH IN V-926 & RUN IN M _____ %		7-D	196
	11	TURN ON AGITATOR & STEAM & DUMP IN FROM S2 LOT #100% %		740-C	1006

	12	DUMP IN	25	113-A	25
	13	DUMP IN	10	777-A	10
	14	HEAT TO 212-214 DEG F WATCH FOAM!!!!			
	15	RECORD: BY _____ (+) IF NECESSARY ADJ TO +BY ASSUME 50%		7-D	
	16	STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM. WATCH FOAM. RECORD: SPARKLER PRES- SURE _____ PSI IF NOT ZERO NOTIFY SUPVR.			
	17	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 F FOR S21. RECORD: START _____ TOTAL MIN _____ CLARITY _____, HT _____ F & REC _____ F			

DATE PRINTED: 4/15/81

EQUIP MENT		PAGE 2 OF 3 CG 32 CODE RT-698-D (I)	USE LBS	N-CODE	ACCT LBS
CV 4	18 19	RUN 6" (569G) WATER INTO V- MEASURE _____ UNITS IN V-928 FOR S31A M _____ %		28-D	485
904 5	20 21	RUN 2" (58G) WATER INTO V-904 WHEN S17 COMPLETE, PUMP IN V-922 THRU SPARKLER. MAINTAIN V-922 AT 190-195 DEG F RECORD: START _____ TOTAL MIN _____			
902 6	22 23	RUN 56" (1566G) WATER INTO V-902 DUMP IN & STIR TO SMOOTH SLURRY FOR S37	476	542-A	476
MISC 7	24	WEIGH IN PT FOR S33 M _____ %		725-A	328
922 8	25 26A	WHEN S21 COMPLETE, STOP PUMP & INSERT V-922 FOOT PLUG RUN IN 10" (200G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904 9	26B	PUMP V-922 THRU SPARKLER INTO V-904			
922 10	27A	RUN IN 5" (100G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904 11	27B 28 29 30	PUMP V-922 THRU SPARKLER INTO V-904 WHEN MTY BLOW OUT SPARKLER INTO V-904 POUR IN HEAT TO 165-170 DEG F FOR S31	60	979-D	60
CV 12	31 31A 32 33 34 35 36	WHEN S30 COMPLETE, PUMP V-904 AT 165-170 F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (12-15 MIN). MAINTAIN 165-170 DEG F RUN IN N-28-D FROM S19 IN 12-15 MIN AND STIR 15 MIN AT 165-170 DEG F. ADJ TO 36" (3168G) AT 32-38 F USING MAND RECORD: MAND _____ " STICK _____ RUN IN N-725-A FROM S24 AFAP (5-10 MIN) STIR 30 MIN AT 32-38 DEG F MAINTAINING +KI M _____ % RECORD: KI _____ (+) DUMP IN FROM S3 & STIR 10 MIN LOT	50X330	57-A 725-A 82-C	 900

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EQUIP MENT		PAGE 2 OF 3 CG 32 CODE RT-698-D (M)	USE LBS	N-CODE	ACCT LBS
904 4	18 19	RUN 2" (58G) WATER INTO V-904 WHEN S17 COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F RECORD: START <u>11:20</u> TOTAL MIN <u>25</u>			
902 5	20 21	RUN 56" (1566G) WATER INTO V-902 DUMP IN & STIR TO SMOOTH SLURRY FOR S43	530	542-A	530
MISC 6	22 23	MEASURE <u>79</u> UNITS IN V-928 FOR S35 WEIGH IN PT FOR S38	<u>1120</u> <u>1114</u>	28-D 725-A	544 367
922 7	24 25 26	WHEN S19 COMPLETE, STOP PUMP & INSERT V-922 FOOT PLUG RUN IN 15" (309G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER PUMP V-922 THRU SPARKLER INTO V-904			
PT 8	27	DILUTE TO MAXIMUM VOLUME V-100G FOR S47			
922 9	28	RUN IN 9" (177G) WATER INTO V-922 AND HEAT TO 190-195 F. CIRCULATE 15 MIN THRU SPARKLER			
904 10	29 30 31 32	PUMP V-922 THRU SPARKLER INTO V-904 WHEN MTY BLOW OUT SPARKLER INTO V-904 POUR IN HEAT TO 165-170 DEG F FOR S34	70	979-D	70
CV 11	33 34 35 36 37 38 39 40	RUN IN 1" (95G) WATER INTO V- <u>901</u> WHEN S32 COMPLETE, PUMP V-904 AT 165-170 F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (12-15 MIN). MAINTAIN 165-170 DEG F IN CV RECORD: START <u>2:15 PM</u> TOTAL MIN <u>15</u> RUN IN N-28-D FROM S22 IN 12-15 MIN STIR 15 MIN AT 165-170 DEG F. ADJ TO 43" (4080G) AT 32-38 DEG F RECORD: TEMP <u>33</u> F, VOLUME <u>46</u> RUN IN N-725-A FROM S23 AFAP (5-10 MIN) STIR 30 MIN AT 32-38 DEG F MAINTAINING +DR, +KI FOR S40 RECORD: TIME START <u>4 PM</u> CR <u>+</u> (+) KI <u>+</u> (+) NOTE: (1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS RECORD: CR <u>+</u> (+) KI <u>+</u> (+) ASSUME 32% (2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS RECORD: CR <u>+</u> (+) KI <u>+</u> (+) ASSUME 33% DUMP IN FROM S3 & STIR 10 MIN LOT	50X330	57-A 28-D 725-A 82-C	<u>18480</u> 1031

5432
5599
5459

76d
250
31

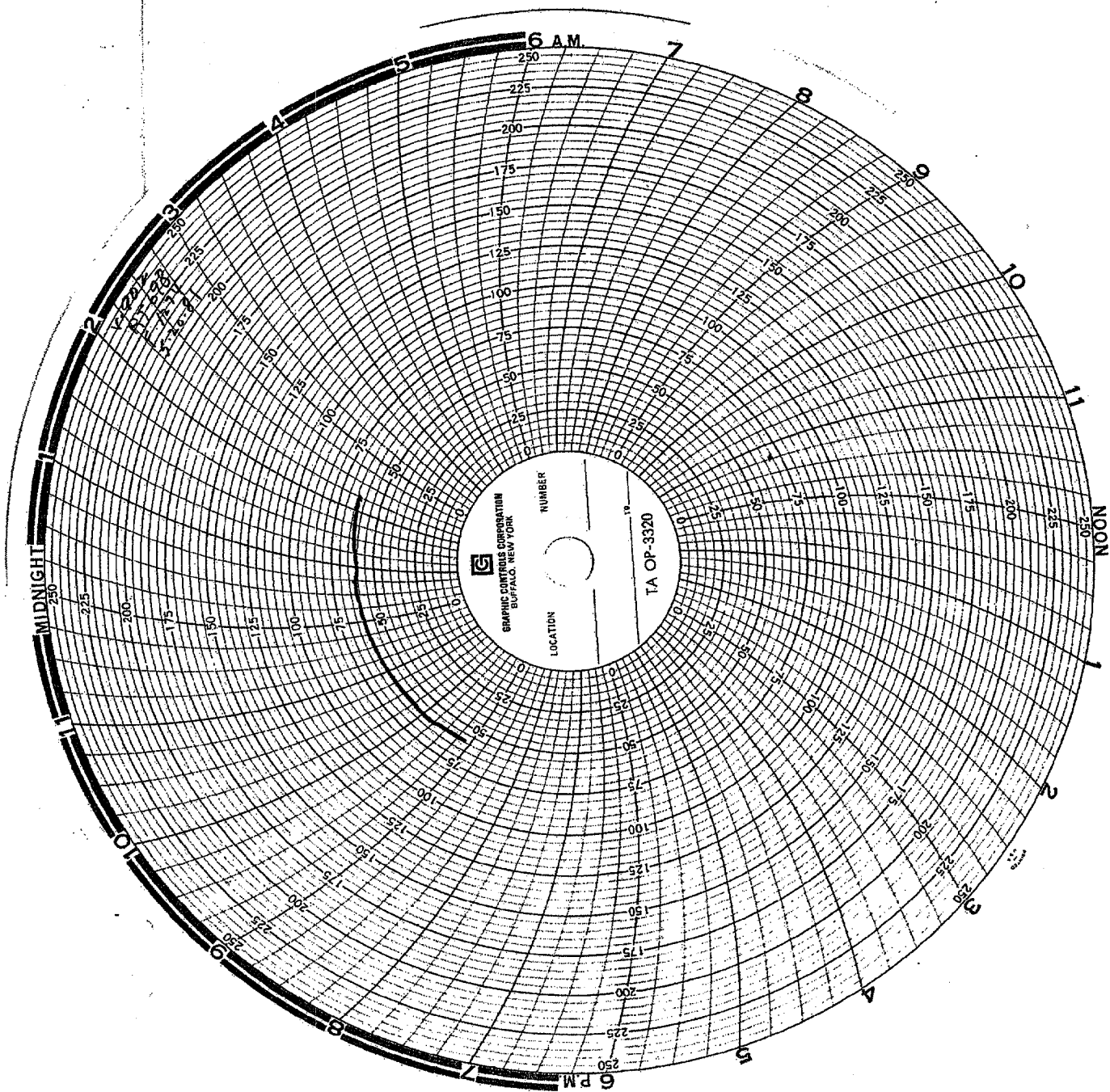
EQUIPMENT	PAGE 2	CG 32	CODE	RT-698-D (K)	EST. WGT.	2775	LBS.	USE	N	ACCT
								LBS.	CODE	LBS.
PT.	27	Weigh in PT			M		%		7-D	202
8	28	Dilute to maximum volume ±100G for S 47								
904	29	RUN IN 9" (177G) WATER INTO V-922-HEAT TO 190-195F - CIRCULATE 15 MIN IN								
9	29	Pump V-922 thru Sparkler into V-904								SPARKL
	30	When MTY blow out Sparkler into V-904								
	31	Pour in						70	979-A	70
	32	Heat to 165-170°F for S 34								
CV	33	Run in 1" (95 G) water into V-								
10	34	When S 32 complete, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min). Maintain 165-170°F in CV								
		Record: Start			Total Min					
	35	Run in N-28-D from S 22 in 12-15 min								
	36	Stir 15 min at 165-170°F								
	37	Adj to 43" (4080 G) at 32-38°F						50 x 330	57-A	
		Record: Temp			°F	Volume				
	38	Run in N-725-A from S 23 AFAP (5-10 min)								
	39	Stir 30 min at 32-38°F maintaining +CR, +KI for S 40								
		Record: Time Start			CR	(+)	KI	(+)		
		NOTE: (1) if CR-KI- add 20# "As Is" increments Assume 32%							28-D	
		Record: CR			(+)		KI	(+)		
		NOTE: (2) if CR+KI- add 20# "As Is" increments Assume 33%							725-A	
		Record: CR			(+)		KI	(+)		
	40	Dump in from S 3 & stir 10 min			Lot				82-C	
	41	Dump in WEIGH ON POSTAL BALANCE & DUMP IN						20	36C	20
	42	Add for maintaining 30-38°F thru S 40								
902	43	Pour N-725-A from S 24 into V-902								
11	44	Dump in						257	165-A	257
2V	45	Immediately after S 44 complete, pump V-902 thru undersurface distributor into CV in 18-22 min. Maintain 32-38°F in CV							57-A	
12		Record: Start			Total Min					
	46	Stir 30 min & Record: pH (5.0-6.0) Temp °F (40-50°F)								
	47	Run in PT from S 28 thru undersurface line & stir 15 min								
	48	Record: pH (9.0-9.8) & if pH is below 9.0								
	49	Adj to pH 9.0-9.8 Assume 50%							7-D	
		& Record: pH, Diazo (-), Base (+) Assume 32%							28-D	
	50	Steam eject V-932 from S 8 into CV								
	51	Pour in						30	588-A	30
	52	Heat to 173-175°F in 55-65 min & Record: HT °F & Rec °F								
	53	During S 52 heating dump in								
902	54	During S 52 heating, run 10" (268 G) water into V-902								
13	55	Turn on agitator & steam & dump in						257	16-B	257
	56	Heat to 155-160°F & stir to dissolve								

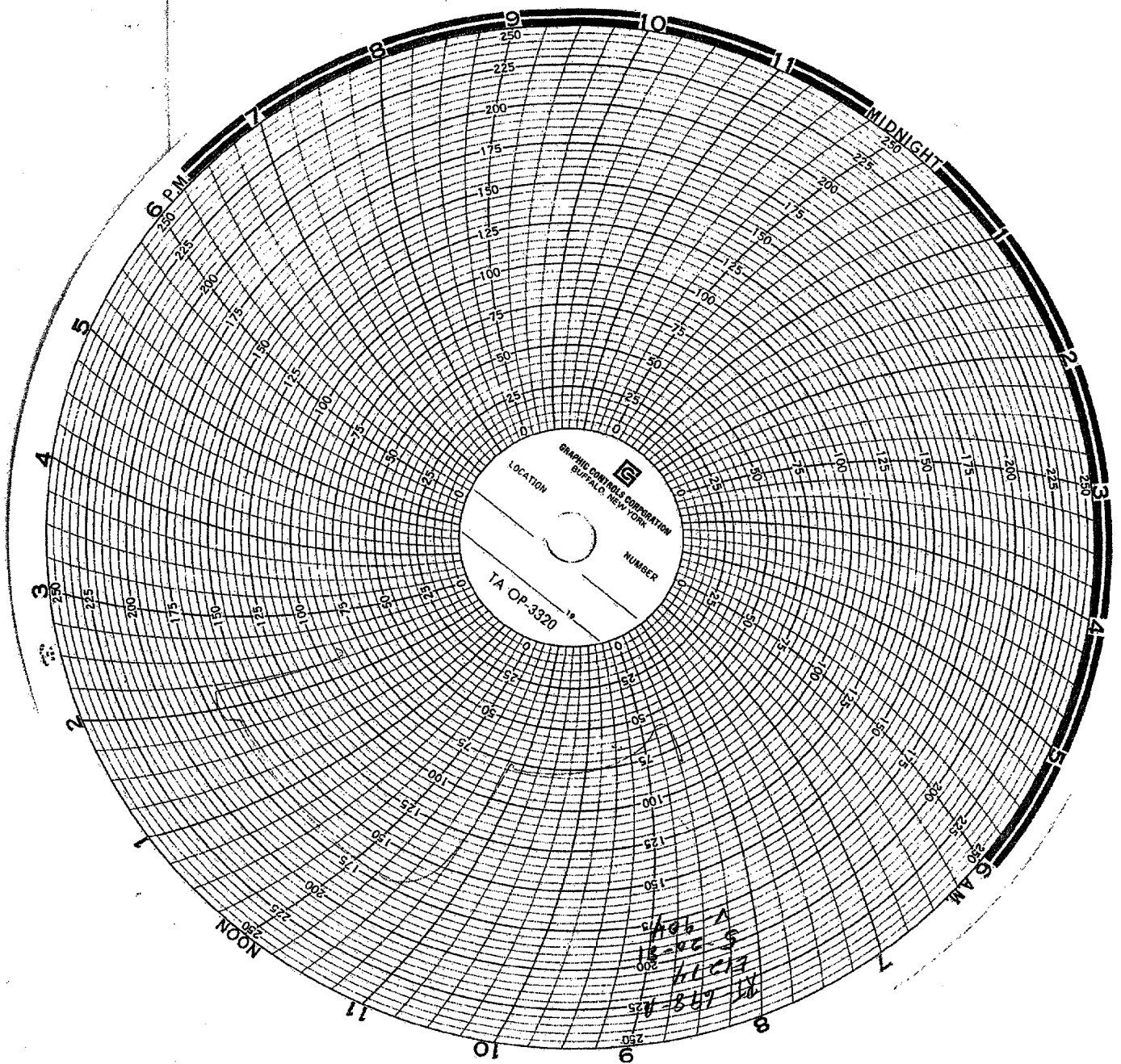
EQUIP MENT		PAGE 3 OF 3 CG 32 CODE RT-698-D (M)	USE LBS	N-CODE	ACCT. LBS
902 12	41 42	POUR H-725 A FROM S24 INTO V-902 DUMP IN	253	122-D	253
CV 13	43 44 45 46 47 48	IMMEDIATELY AFTER S42 COMPLETE, PUMP V-902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN. MAINTAIN 32-50 F IN CV. RECORD: START <u>5PM</u> TOTAL MIN <u>20</u> STIR 15 MIN & RECORD: PH <u>9.6</u> (9.0-9.8) TEMP <u>50</u> DEG F (40-50 DEG F) AND IF PH IS BELOW 9.0 ADJ TO PH 9.0-9.8 ASSUME 50% & RECORD PH <u> </u> DIAZO <u> </u> (-) ASSUME 32% BASE <u>+</u> (+) STEAM EJECT V-932 FROM S8 INTO CV POUR IN HEAT TO 173-175 DEG F IN 55-65 MIN AND RECORD: HT <u>175</u> DEG F & REC <u>175</u> DEG F DURING S47 HEATING DUMP IN	30	57-A 7-D 28-D 588-A	30
902 14	49 50 51	DURING S47 HEATING, RUN 10" (268G) WATER INTO V-902 TURN ON AGITATOR & STEAM & DUMP IN HEAT TO 155-160 DEG F & STIR TO DISSOLVE	239	16-B	239
CV 15	52 53 54 55 56 57	WHEN S52 COMPLETE, STRIKE V-902 AT 155-160F THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 2 - 3 MIN RECORD: START <u>7PM</u> TOTAL MIN <u>3</u> HEAT CV TO 193-195 DEG F IN 10-15 MIN. STIR 60 MIN AT 193-195 F. RECORD START <u>720</u> AFTR 20 MIN S48 STIR RECORD PH <u>8.8</u> (8.8-9.3) IF NECESSARY, ADJ TO PH 8.8-9.3 ASSUME 50% AND RECORD: PH <u> </u> ASSUME 32% AFTR S59 STIR FLOOD TO 180-190" (+/-18000G) AND STOP AGITATOR WHEN INSTRUCTED BY PROCESSING AREA HALF WAY THRU PRESSING, DUMP IN, STIR 5 MIN & STOP AGITATOR. RESUME PRESSING.	10	7-D 28-D 588-A	10
		START <u>7:00 AM</u> <u>10:00 PM</u> <u>3 PM</u>	FIN <u>12:00 PM</u> <u>3:00 PM</u> <u>843</u>	OPTR <u> </u> <u> </u> <u>282</u>	

EQUIPMENT		PAGE 3 CG 32 CODE RT-698-D (K) EST. WGT. 2775 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 14	57	When S 52 complete, strike V-902 at 155-160°F thru under-surface distributor into CV in 2-3 min			
		Record: Start Total Min			
	58	Heat CV to 193-195°F in 10-15 min			
	59	Stir 60 min at 193-195°F Record: Start			
	60	After 20 min S 48 stir Record: pH (8.8-9.3) & if necessary, adj to pH 8.8-9.3 Assume 50%		7-D	
		& Record: pH Assume 32%		28-D	
	61	After S 59 stir flood to 180-190" (±18000 G) & stop agitator			
		When instructed by Processing Area half way thru pressing, dump in, stir 5 min & stop agitator. Resume pressing	10	588-A	10
		START FIN OPTR			

EQUIP MENT		PAGE 3 OF 3 CG 32 CODE RT-698-D (I)	USE LBS	N-CODE	ACCT LBS
902 13	37	POUR INTO V-902	226	122-D	226
CV 14	38	IMMEDIATELY AFTER S37 COMPLETE, PUMP V-902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN. RECORD: START _____ TOTAL MIN _____			
	39	STIR 30 MIN & RECORD: DIAZO _____ (-), BASE _____ (+) PH _____ (9.0-9.8) TEMP _____ DEG F (40-50 DEG F)			
	40	IF NECESSARY, ADJ TO PH 9.0-9.8 ASSUME 50% & RECORD: PH _____ M _____ %		7-D 28-D	
	41	STEAM EJECT V-932 INTO CV			
	42	POUR IN	30	588-A	30
	43	HEAT TO 193-195 DEG F IN 65-75 MIN AND RECORD: HT _____ DEG F & REC _____ DEG F			
902 15	44	DURING S43 HEATING, RUN 11" (273G) WATER INTO V-902			
	45	TURN ON AGITATOR & STEAM & DUMP IN	230	16-B	230
	46	HEAT TO 155-160 DEG F & STIR TO DISSOLVE			
CV 16	47	WHEN S43 COMPLETE, STRIKE V-902 AT 155-160F THRU UNDERSURFACE DISTRIBUTOR INTO CV AT 193-195 F IN 2-3 MIN RECORD: START _____ TOTAL MIN _____			
	48	STIR 60 MIN AT 193-195 F RECORD START _____			
	49	AFTER 20 MIN S48 STIR RECORD PH _____ (8.8-9.3) IF NECESSARY, ADJ TO PH 8.8-9.3 ASSUME 50% AND RECORD: PH _____ M _____ %		7-D 28-D	
	50	AFTER S48 STIR FLOOD TO 180-190" (+/-18000G) AND STOP AGITATOR			
		START FIN OPTR			

		WHEN INSTRUCTED BY PROCESSING AREA HALF WAY THRU PRESSING, (1) DUMP IN (2) STIR 5 MIN (3) ADVISE PROCESSING TO RESUME PRESSING	10	588-A	10





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18-02-5
41017
24-847 18

