

CG 32 CODE RT-618-D PKG.

→ DEC 10 80 38226

EST. WGT. 2597 LBS.

STD. HRS. TIME M

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

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	5 Run 10" (100 G) water into V-921 & adj to 80-100°F			
2	6 Add in 1-2 min	50	530-A	50
	7 Stir 2 min & Record: pH 10.1 (9.5-10.5)			
	8 Stir 20 min or longer for S 27			
922	9 Run 28" (620 G) water into V-922			
3	10 Weigh in V-926 & run in M 13.48.77 % 365		7-D	178
	11 Turn on agitator & steam & dump in from S 2		740-C	920
	Lot 116 100% 78.7 99.19 288			
	118 63.3 98.87 640			
	12 Dump in	40	113-B	40
	13 Dump in	10	777-A	10
	14 Heat to 212-214°F. Record: HT ; °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 - P.S.T.			
	17 Circulate 15 min or longer thru Sparkler until sol'n is clear Maintain at 190-195°F for S 19 & Record: HT 194°F & Recorder 194°F			
	Record: Start 2 hr Total Min 60, Clarity o/c If not zero, notify Supervisor			
	NOTE: Sample from hose — show to Supervisor for OK			
904	18 Run 1" (50 G) water into V-904			
4	19 When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F			
	Record: Start 2 hr Total Min 16			
Misc	20 Weigh in RT for S 35 M 13.33.47 % 881		725-A	295
5	21 Measure 80 units in V-928 for S 33 M 12.30.56 % 1217		28-D	372
CV	22 Run 14" (1330 G) water into V-901			
6	23 Weigh in V-926 & run in M 13.48.77 % 923		7-D	450
	24 Dump in from S 3 Lot 810		253-C	805 810
	25 Weigh on postal scale & dump in Lot -			
	26 Adj to 70-90°F & stir to dissolve			
	27 Steam eject V-921/931 into CV			

EQUIPMENT		PAGE 2 CG 32 CODE RT-618-D (I) 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 100-100 190-195°F Circulate 15 min thru Sparkler. Pump V-922 thru Sparkler into V-904				
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				
	34	Adj to 90" (2390 G) at 28-30°F & Record: Temp °F.	40 x 330	57-A	14526	
	35	Run in N-725-A from S 20 A.F.A.P (5-10 min)				
	36	Stir 20 min at 28-35°F maintaining + CR, + KI for S 41			57-A	
		Record: Time Start 9:40, 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		150	65-A	150
9	38	Adj to 33" (3130 G) at 28-32°F	33 x 330	57-A	10890	
		Record: Temp 28°F & Volume 35"				
	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 5:00, Total Min 50, Final Temp 25°F				
	42	Stir 30 min & Record: Base 4 (+), Diazo - (-), pH 9.3 (9.0-9.8)				
	43	If necessary, adj to pH 9.0-9.8 Assume 50%			7-D	
		& Record: pH Assume 32%			28-D	
	44	Heat to 174-176°F in 65-70 min & Record: HT °F & Recorder °F				
DV	45	Run 1" (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 distributor into CV in 7-10 min. Maintain CV at 174-176°F				
11		Record: Start 8:00 PM, Total Min 20				
	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 (9.0-9.4) & stop agitator				
		SAMPLE				
		START 7:15	FINISH 8:45 PM	OPTR 120		
				237		
		When instructed by Processing Area half way thru pressing, Dump in, stir 5 min, & stop agitator. Resume pressing.	10	588-A	10	

S-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 190-195°F

S-30B / Pump V-922 thru Sparkler into
V-904

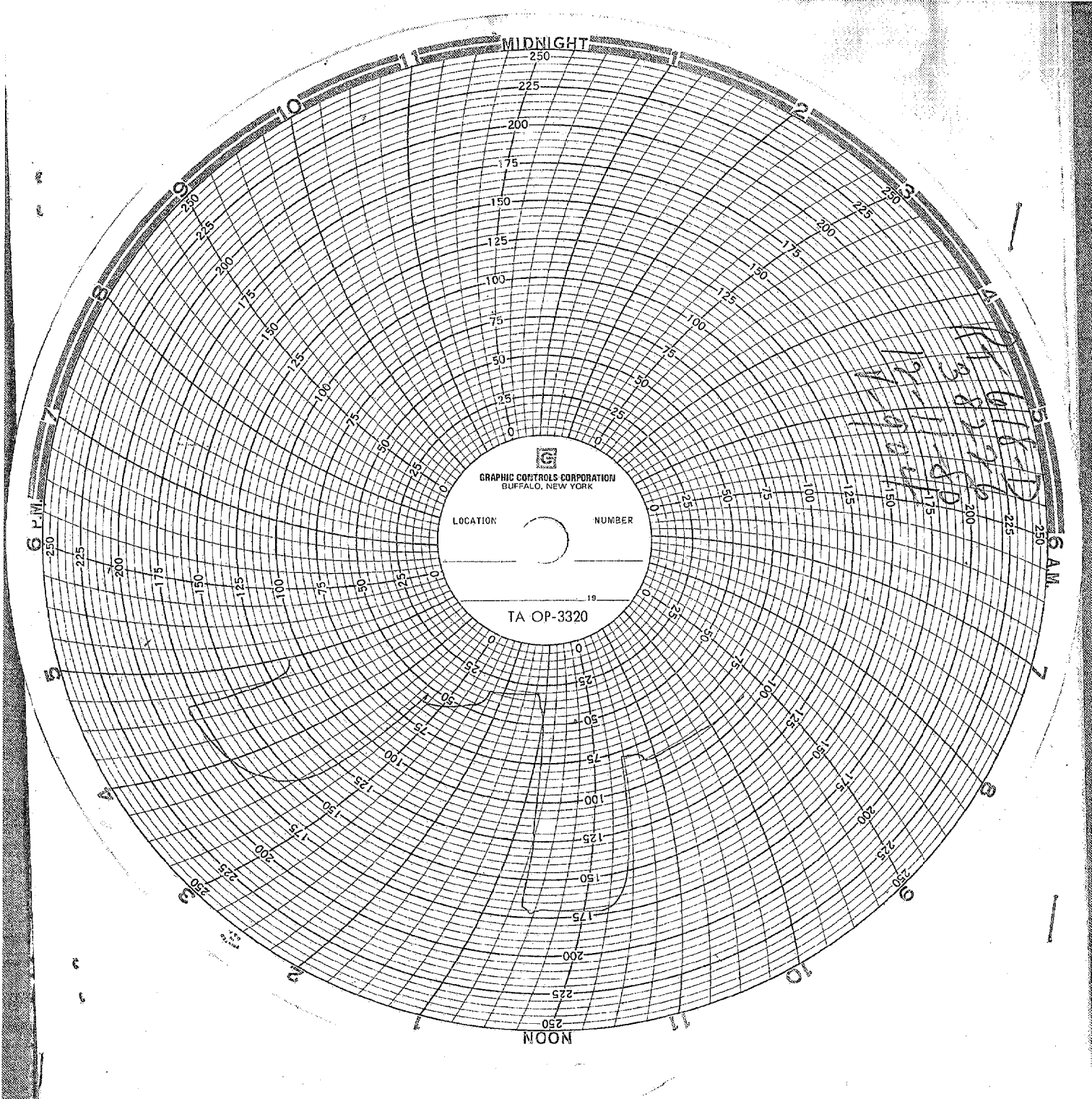
Continue with S-3

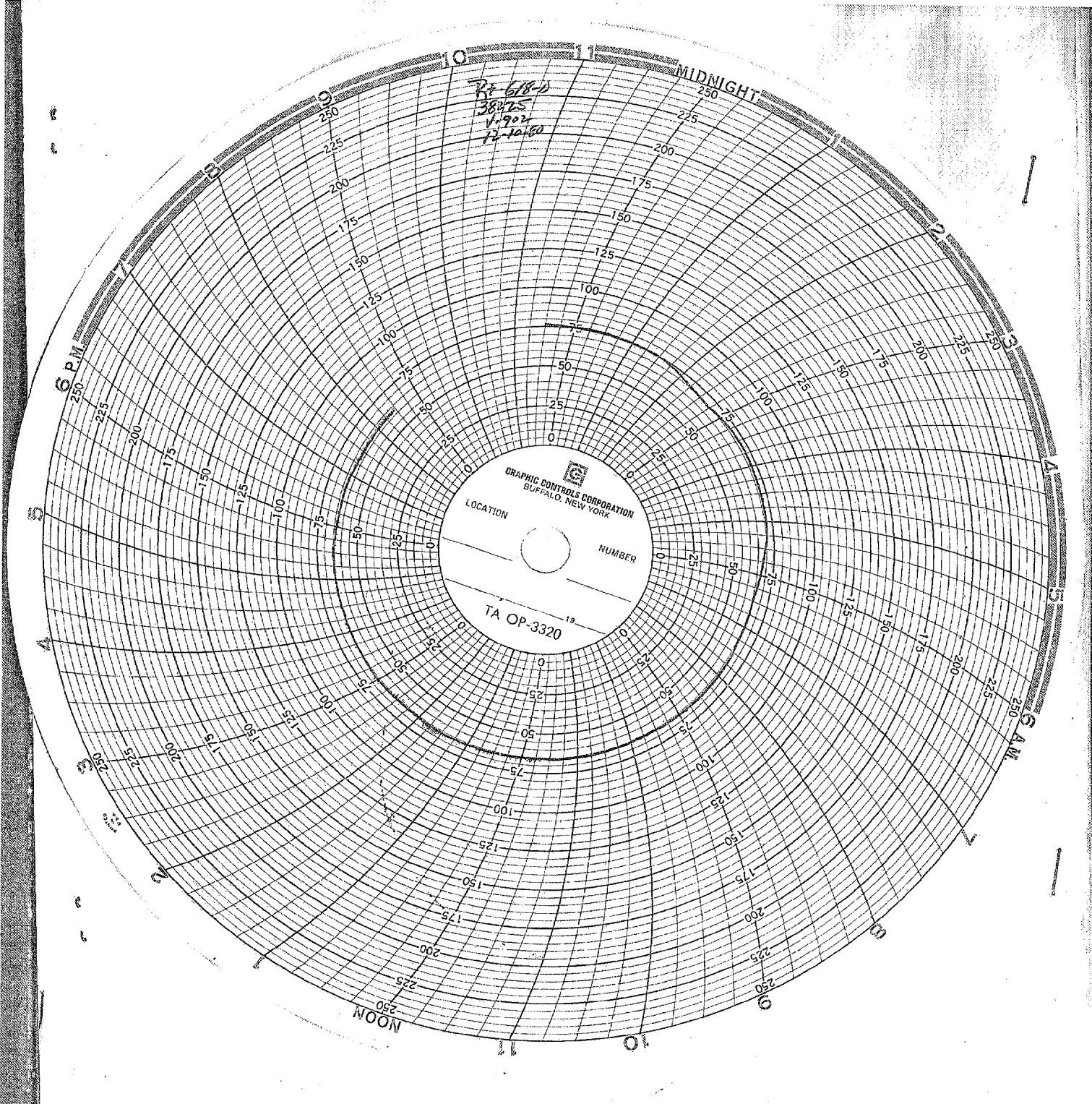
FORM A

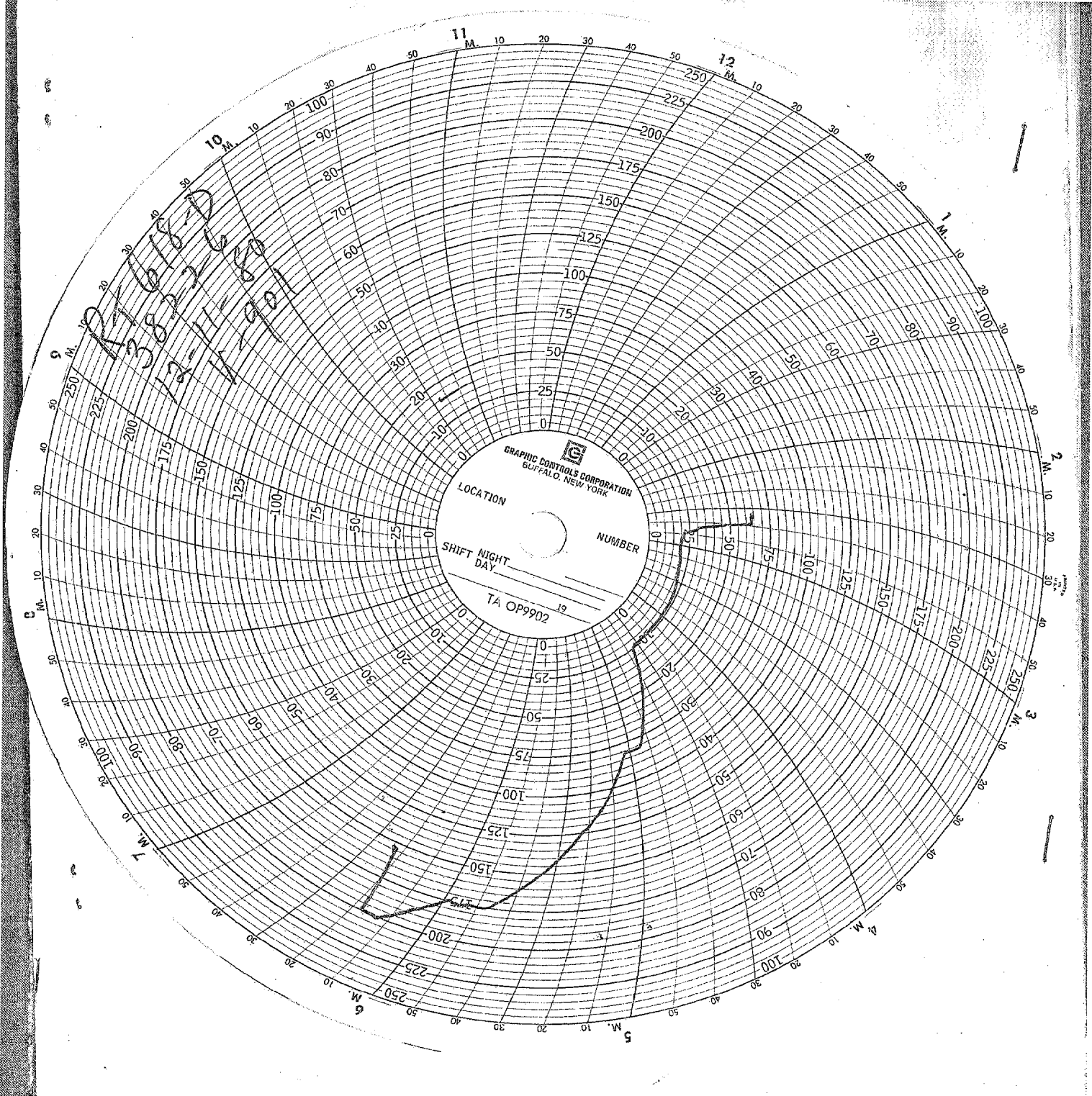
CODE _____ LOT _____ VATS _____ EQUIP. _____
DATE _____ OPER _____ SUPERVISOR _____

1. Used all stumps, leave 1 stump identified.
2. Clean shovel.
3. Chute washed & top replaced.
4. Water hose coiled.
5. Steam ejector turned off after finished in vat.
6. Scale left clean.
7. Added ice to vat only when volume reaches agitator.
8. Floor cleaned around vats used.
9. Hoses coiled or on rack on diazo press.
10. Hoses not crossing walkway after finished.
11. Pump shut off after removing hose from intake.
12. Ice blower shut off after using.
13. All spills in area worked clean.
14. Door on instruments closed.
15. All empty drums removed from area & discarded.
16. Corrosive containers properly covered.
17. Top of vats cleaned of color, paper cups, strings, etc.
18. Vat door after finished - hatches on abbe's.
19. All tools cleaned & placed in rack or proper place.
20. Ice house clean - tools on racks.
21. Revolvator cleaned - platform & pit.

ATTACH TO MAKE CARD







DUP050106483