

CV (9031) DV

CG 32 CODE RT-~~50~~-D PKG

Nov 21 80 38007

EST WGT ~~2669~~ LBS

STD/HRS TIME M

PROCESSES

() RT-761-D	(K) JIS 4-78
() RT-838-D	(J) Dec 4-78
()	() MTG 4-13-78
()	() X00 27
TYPED BY	
NSA 4-17-78	

APPROVED BY

Retyped 10-10-80 MnM

RECORD SPARKLER
Done

Use - N-7 FOR N-740
Use - FLARE CAUSE FOR N-252

		NON-BLEEDING		
EQUIPMENT	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.			
	2 After 5 batches, clean, dress Sparkler & pre-coat with 15#		777-A	
	3 Obtain for S 12 (2 chloro-4 amino Toluene 5 sulfuric acid)		740-C	
	4 Obtain for S 51 (Beta Oxy Naphthoic Acid)		253-C	
	4 Install DV & CV Recorder & Controller charts			
921/931 2	5 Run 12" (120G) water into V-931 & adj to 80-100°F			
	6 Add in 1-2 min (Sodium Dresinate)	110	99-A	110
	7 Add in 1-2 min (Sodium Dresinate)	50	530-A	50
	8 Stir 5 min & Record: pH 9.9 (9.5-10.5)			
	9 Stir 20 min or longer to dissolve for S 29			
922 3	10 Run 32" (580G) water into V-922			
	11 Weigh in V-926 & run in (Caustic Soda Sol.) M 12.49.924	433	7-D	206
	12 Turn on agitator & steam & dump in from S 2		740-C	110
	Lot #100%			
	114 1107 98.65	1132		
	13 Dump in (activate carbon)	25	113-A	25
	14 Dump in (filter aid)	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 190 F & Rec 190 F			
	19 Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 24			
	Record: Start 8:30 Total Min 30 Clarity Clean			
Misc 4	20 Measure 99 units in V-928 for S-42 M 10 31.35 (maricatic acid)	1780	28-D	593
	21 Weigh in PT for S 45 M 12.33.16	1083	725-A	359
	22 Weigh in drum for S 53 (sodium nitrate sol)	127	725-A	42
903 5	23 Run 1" G water into V-903			
	24 Note: Use CV if MTY. If CV is not MTY, use V-904			
	When S 19 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F Record: Start 3:50 Total Min 15			

S.V.

RT-838-D

C.V.

901 (903)

MAKING INSTRUCTIONS: BATCH UNIT

D.V. 902,904

CG 32 CODE RT-838-D PKG.

→ NOV 21 80 38307

EST. WGT. 2669 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

EQUIPMENT	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		740-C	1106
	Lot #100% %			
	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.			

DUP050107709

EQUIPMENT		PAGE 2 CG 32 CODE RT-761-D (J), RT-838-D (H)	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
902 9	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		
	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				

DUP050107710

EQUIPMENT	PAGE 2 CG 32 CODE RT-761-D(K) . EST. WGT.	LBS.	USE LBS.	N CODE	ACC LBS
904 6	25 Run 45" (1250 G) water into V-902 (Start after 5-41)		682	12-D	682
	26 Weigh in V-926 & run in M				
	27 Adj to 70-90°F & stir 10 min to dissolve				
	28 Slurry in 30 gal water & pour into V-902 (Trisulphoil Soap D)		100	39-A	100
	29 Steam eject in V-921/931 from S 9				
922 & 904/CV	31 When S 24 complete, stop pump & insert V-922 foot plug				
	32 Run in 12" (247 G) water & heat to 190-195°F				
	33 circulate 15 min or longer thru Sparkler until solution is clear				
	34 Pump V 922 thru Sparkler into V 904/CV				
	35 Run in 8" (165G) water into V922) & heat to 190-195°F				
	36 circulate 15 min or longer thru Sparkler until solution is clear				
	37 Pump V922 thru Sparkler into V904/CV				
	38 When V922 mtblow out Sparkler into V904/CV				
	39 Heat V-904 to 165-170°F for S 42				
	NOTE: If N-740-C solution was pumped directly from Sparkler to CV at S's 23 & 24 omit S's 40-41				
CV 8	39A DISSOLVE IN 20G WATER AT 150-160°F IN DRUM & POUR IN		30	133-B	30
	40 Run 1" (95 G) water into V-				
	41 If V 904 is used, pump V-904 at 165-170°F thru under-surface distributor into CV AFAP (12-15 min) Maintain CV at 165-170°F				
	42 Run in N-28-D from S 20 in 12-15 min				
	43 Stir 5 min				
	44 Adj to 25" (3300G) at 32-38°F (ice)		45X330	57-A	1485
	45 Run in N-725-A from S 21 AFAP (5-10 min)				
	46 Stir 30 min at 32-38°F maintaining +CR, +KI				
	Record: Time Start 7:50 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 (+)				
	47 Dump in (Calcium chloride)		1116	20-A	1116
	48 Dump in (Strontium nitrate)		244	246-D	244
	49 Dump in (Blanc Fixe)		130	65-A	130
	50 Add for maintaining 32-38°F during coupling		36X330	57-A	11,880
	51 Dump in from S-3 LOT			253-C	972
	509		72		
	304		900		
	52 Weigh on postal balance and dump in and stir 10 min		40	180-C	40
	(1Hydroxy 2Naphthoic acid)				
904 9	53 Pour N-725-D from S 22 into V 902 Pump V922 into V904				
	54 Dump in Pump V902 to V904 (ammonium chloride)		224	122-D	224
CV 10	55 Immediately couple V-902 thru undersurface distributor into CV in 38-42 min. Maintain DV at 32-38°F		400	28-D	128
	Record: Start 11:33 PM Total Min 40				
	56 Stir 30 min & record: Base + (+), Diazo - (-)				
	pH 9.1 (9.5-10.0)				
	57 If necessary, adj to pH 9.5-10.0 & Record pH 9.7 Assume 50%		40	72-D	40
	Assume 32%			28-D	
	58 Weigh in drum & pour in (Iso Octanol)		45	588-D	45
	59 Heat to 184-186°F in 70-75 min				
	60 Record: HT 195 °F & Rec 187 °F				
	61 Stir 30 min at 184-186°F				
	62 after 10 min S 61 stir, record: pH 9.0 (9.5-10.0)				
	63 If necessary, adj to pH 9.5-10.0 Assume 50%		80	72-D	80
	Record: pH 10.1 if pH above 10.0- do not adjust				

EQUIPMENT	PAGE 3 CG 32 CODE	RT-761-D(K), RT-838-D(M)		USE LBS.	N CODE	ACCT LBS.
		EST. WGT.	LBS.			
CV 10 (cont'd)	64	When S 63 complete, flood to 180-190" ($\pm$ 18000 G) & stop agitator				
	65	Open distributor Cap				
		When instructed by Process Area halfway thru pressing				
	1	Dump in		10	588-A	10
	2	Stir 5 min				
	3	Advise Processing to resume pressing				
		START	FIN	OPIR		
		12:30 P	3:00 P	126		
		3:00 PM	11:00 PM	322		
		1:00 PM	3:15 PM	201		
		Delay abt Mat'l Not Stocked.				

[illegible]



TITLE OF PROJ. OR STUDY _____ PROJ. OR STUDY NO. _____

SUBJECT _____ WORKS _____

COMPUTER _____ DATE _____ 19 _____

(554)

(A)

V902Run in 10" (249 GAL) Water in V902 & turn on ✓
agitator & steam ejector

(B) Weigh & run in 224# N122D ✓

(C) WEIGH IN DRUM & SIPHON IN 128# 100% ✓
(400# AS IS N28-D)

→ (D) RUN INTO V-904 AFTER S53 is completed





