

S.V. >

C.V. (901) 903

DATE PRINTED: 7/19/82

D.V. 902,904

CG 32

CODE RT-870-D

PKG ---

PROCESSES

APPROVED BY

JUL 21 1982

G2J50

2579*

() RT-870-D (H) EWK 1-11-82
COMTYP JOB NAME: 32RT870DMH
TYPED BY: JMH

(DATE)

(LOT)

(EST WGT)

STANDARD HRS. _____

TIME 3 P.M.

PREPARATION NOTES: _____

NON-BLEEDING

EQUIP MENT	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. SUPV TO REVIEW WITH P.R. SUPV & RECORD. S.K. PRESS WILL BE READY 8:00 AM 7/22/82 PR SUPV. START MAKING 8:00 AM 7/22/82 MAKING SUPV. NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V-922 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.			
PREP 1	RECORD: 1 BATCHES SINCE SPARKLER LAST CLEANED. AFTER 4 BATCHES, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15% DICALITE, FILTER AID.		777-A	
	2 OBTAIN FOR S11 2-CHLORO-4-AMINOTOLUENE-5-SULFONIC ACID.		740-C	
	3 OBTAIN FOR S27 3-HYDROXY-2-NAPHTHOIC ACID		82-C	
	4 INSTALL DV & DV RECORDER & CONTROLLER CHART			
921/ 931 2	5 RUN 11" (100G) WATER INTO V-921 & ADJ TO 80-100 DEG F 6 ADD IN 2-3 MIN DRESINATE X 7 STIR 5 MIN & RECORD PH 10.1 (9.5-10.5) 8 STIR 20 MIN OR LONGER TO DISSOLVE FOR S49	108	530-A	108
922 3	9 RUN 35" (722G) WATER INTO V-922 10 WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M 10 49.55 % 11 TURN ON AGITATOR & STEAM & DUMP IN FROM S2 2-CHLORO- LOT #100% 64.1 98.67 650 4-AMINOTOLUENE 281 445 99.30 778 5-SULFONIC ACID 12 DUMP IN ACTIVATED CARBON 13 DUMP IN FILTER AID 14 HEAT TO 212-214 DEG F WATCH FOAM!! 15 RECORD: BY + (+) IF NECESSARY ADJ TO +BY SODIUM HYDROXIDE ASSUME 50% 16 STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM! NOTE: RECORD SPARKLER PRESSURE PSI. IF NOT ZERO NOTIFY SUPERVISOR.	428 25 10	7-D 740-C 113-B 777-A 7-D	212 1086 25 10

JUL 26 1982

N32900

DUP050464645

EQUIP MENT		PAGE 2 OF 4 CG 32 CODE RT-870-D (H)	USE LBS	N-CODE	ACCT LBS
922 3 CONT 12	117	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 DEG F FOR S22 RECORD: START TOTAL MIN. 194 F & REC 194 1/2			
MISC 4	118	MEASURE 90% UNITS IN V-928 FOR S39 HYDROCHLORIC ACID M. 1 39.89%	1465	28-D	438
	119	WEIGH SODIUM NITRITE IN PT FOR S42 M. 9 33.36%	1190	725-A	397
	120	WEIGH SODIUM NITRITE IN DRUM FOR S50 M. 9 33.36%	129	725-A	43
904/CV 5	121	RUN 2" (58G) WATER INTO V-904/CV WHEN S17 IS COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F. RECORD: START 535 TOTAL MIN. 150			
922 6	123	WHEN S22 COMPLETE, SHUT OFF PUMP AND INSERT V-922 FOOT PLUG 124A RUN IN 10" (209G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904/CV 7	124B	AND PUMP V-922 THRU SPARKLER INTO V-904/CV			
902 8	125	RUN 65" (1696G) WATER INTO V-902			
	126	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M. 10 49.55%	805	7-D	399
	127	DUMP IN FROM S3 3-HYDROXY- 2-NAPHTHOIC ACID LOT 7672	994	82-C	994
	128A	ADJ TO 70-90 DEG F & STIR TO DISSOLVE			
922 9	128B	RUN IN 5" (104G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904/CV 10	129	PUMP V-922 THRU SPARKLER INTO V-904/CV WHEN MTY BLOW OUT SPARKLER INTO V-904/CV DISSOLVE ALKANOL XC IN 20G WATER AT 150-160 F FROM HOT WATER MIXER IN DRUM & POUR IN. HEAT TO 165-170 F FOR S38	32	133-B	32
932 11	133	RUN 16" (328G) WATER INTO V-932 & ADJ TO 80-100 DEG F. 134 ADD IN 6-7 MIN DRESINATE X 135 STIR 5 MIN & RECORD PH. (9.5-10.5) 136 STIR 20 MIN OR LONGER TO DISSOLVE FOR S59	378	530-A	378

EQUIP MENT		PAGE 3 OF 4 CG 32 CODE RT-870-D (H)	USE LBS	N-CODE	ACCT LBS
CV 12	✓ 37	NOTE: IF N-740-C SOL. WAS PUMPED DIRECTLY FROM SPARKLER TO CV S21, 24B, 29 OMIT S37 & 38			
	✓ 38	RUN 5" (95G) WATER INTO V-			
	✓ 39	PUMP V-904 AT 165-170 DEG F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (12-15 MIN)			
	✓ 40	RUN IN N-28-D HYDROCHLORIC ACID FROM S18 IN 12-15 MIN. MAINTAIN 165-170°F IN CV.			
	✓ 41	STIR 15 MIN AT 165-170 DEG F	70		
	✓ 42	ADJ TO 46" (4347G) AT 32-38 DEG F	54X330	57-A	23100
	✓ 43	RECORD: TEMP _____ DEG F, VOLUME _____			
	✓ 44	RUN IN N-725-A SODIUM NITRITE FROM S19 AFAP (5-10 MIN) & RINSE IN PT			
	✓ 45	NOTE: PROCESS HAS A VERY LOW N-28-D EXCESS CHECK CR VERY CAREFULLY			
	✓ 46	STIR 20 MIN AT 32-38 DEG F MAINTAINING +CR, +KI FOR S44. RECORD: TIME START _____		57-A	
	✓ 47	CR _____, KI _____ NOTE:			
	✓ 48	1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS			
	✓ 49	RECORD CR _____ (+) KI _____ (+)			
	✓ 50	HYDROCHLORIC ACID ASSUME 32%		28-D	
	✓ 51	2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS			
	✓ 52	RECORD CR _____ (+) KI _____ (+)			
	✓ 53	SODIUM NITRITE ASSUME 33%		725-A	
	✓ 54	DUMP IN CALCIUM CHLORIDE	1026	20-A	1026
	✓ 55	ADD FOR MAINTAINING 32-38 DEG F THRU S55	32X330	57-A	10560
PT 13	✓ 46	FILL PT APPROXIMATELY 1/2 FULL WITH 90-110°F WATER FROM HOT WATER MIXER			
	✓ 47	DUMP IN STRONTIUM NITRATE	68	246-B,E	68
	✓ 48	STIR 30 MIN OR LONGER WITH LIGHTNIN MIXER TO SOLUTION FOR S58			
902 14	✓ 49	WHEN S28A COMPLETE, STEAM EJECT V-921/931 FROM S8 INTO V-902.			
	✓ 50	POUR IN N-725-A SODIUM NITRITE FROM S20			
	✓ 51	ADD AMMONIUM CHLORIDE	213	165-A	213
CV 15	✓ 52	IMMEDIATELY COUPLE V-902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN. RECORD: START <u>3:10</u> TOTAL MIN <u>25</u>			
PT 16	✓ 53	DURING S52 WEIGH SODIUM HYDROXIDE IN PT			
	✓ 54	M <u>10</u> <u>49.5%</u>	283	7-D	140
	✓ 55	DILUTE TO MAXIMUM VOLUME (+/-100G) FOR S56			
CV 17	✓ 55	WHEN S52 COMPLETE, STIR 30 MIN & RECORD:			
	✓ 56	DIAZO <u>4</u> (+) BASE <u>4</u> (+)			
	✓ 57	PH <u>5.5</u> (5.0-6.0) TEMP <u>35</u> (32-38 F)			
	✓ 58	RUN SODIUM HYDROXIDE IN PT FROM S54 THRU UNDERSURFACE LINE, RINSE IN PT & STIR 15 MIN			
	✓ 59	RECORD: DIAZO <u>4</u> (-) BASE <u>4</u> (+)			
	✓ 60	PH <u>9.7</u> (9.0-9.8)			
	✓ 61	RUN IN STRONTIUM NITRATE N-246-B,E SOL'N FROM S48 & RINSE IN PT			
	✓ 62	STEAM EJECT IN V-932 FROM S36			
	✓ 63	STIR 5 MIN & RECORD: PH <u>7.6</u> (9.0-9.8)			

EQUIP MENT		PAGE 4 OF 4 CG 32 CODE RT-870-D (H)	USE LBS	N-CODE	ACCT LBS
17	✓61	IF PH BELOW 9.0 ADJ TO PH 9.0-9.8 WITH			
CONT		N-7-D ONLY. RECORD PH _____			
	✓62	SODIUM HYDROXIDE ASSUME 50%		7-D	
	✓63	POUR IN 1 OCTANOL	38	588-A	38
	✓64	HEAT TO 193-195 DEG F IN 70-75 MIN & RECORD			
		HT <u>195</u> DEG F AND REC <u>195</u> DEG F			
	✓65	STIR 60 MIN AT 193-195 DEG F.			
		RECORD: START <u>6:00</u>			
		AFTER 20 MIN S64 STIR RECORD:			
		PH <u>9.0</u> (8.8-9.3)			
		IF PH BELOW 8.8, ADJ TO PH 8.8-9.3 WITH			
		N-7-D ONLY. RECORD PH _____ ASSUME 50%		7-D	
	✓66	AFTER S64 STIR, FLOOD TO 180-190°			
		(+/-18,000G) AND STOP AGITATOR			

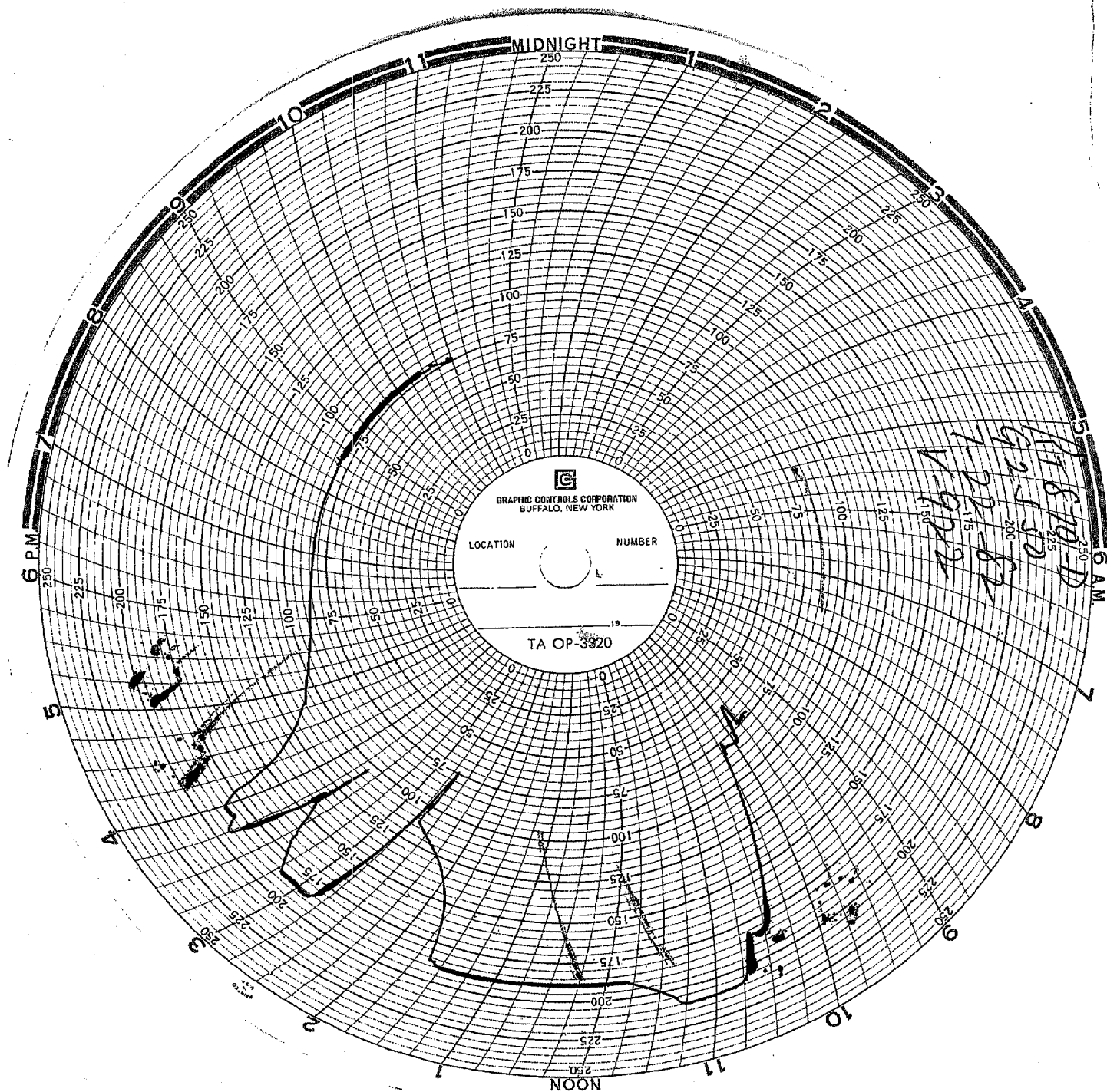
WHEN INSTRUCTED BY PROCESSING AREA HALFWAY
THRU PRESSING, DUMP IN, STIR 5 MIN & STOP
AGITATOR. RESUME PRESSING.

10

588-A

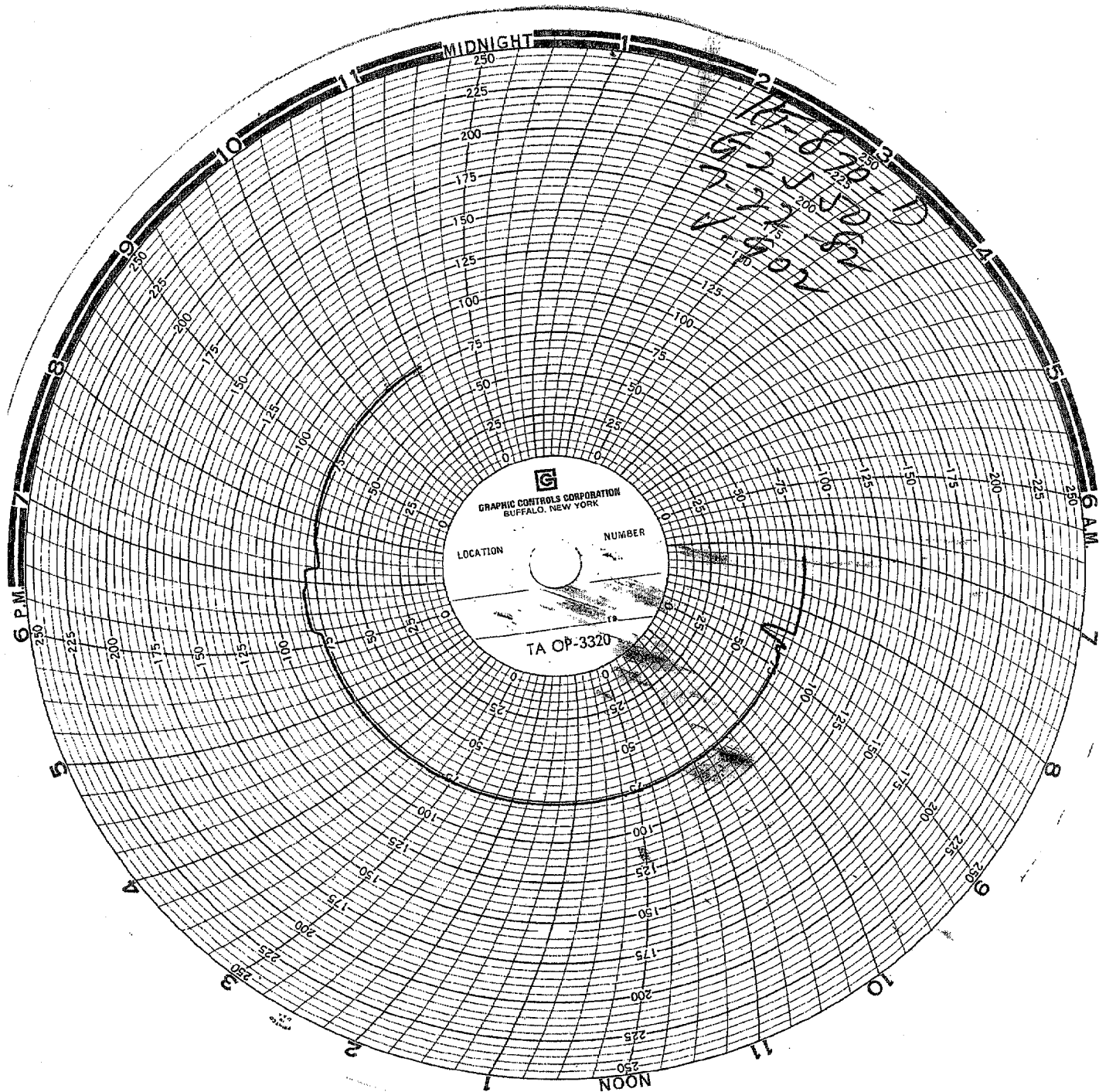
10

3 START 11:00 AM FIN 1:00 PM OPTR 1:20
11:00 AM 7:00 PM 2:23
7:00 PM 7:00 PM 7:00



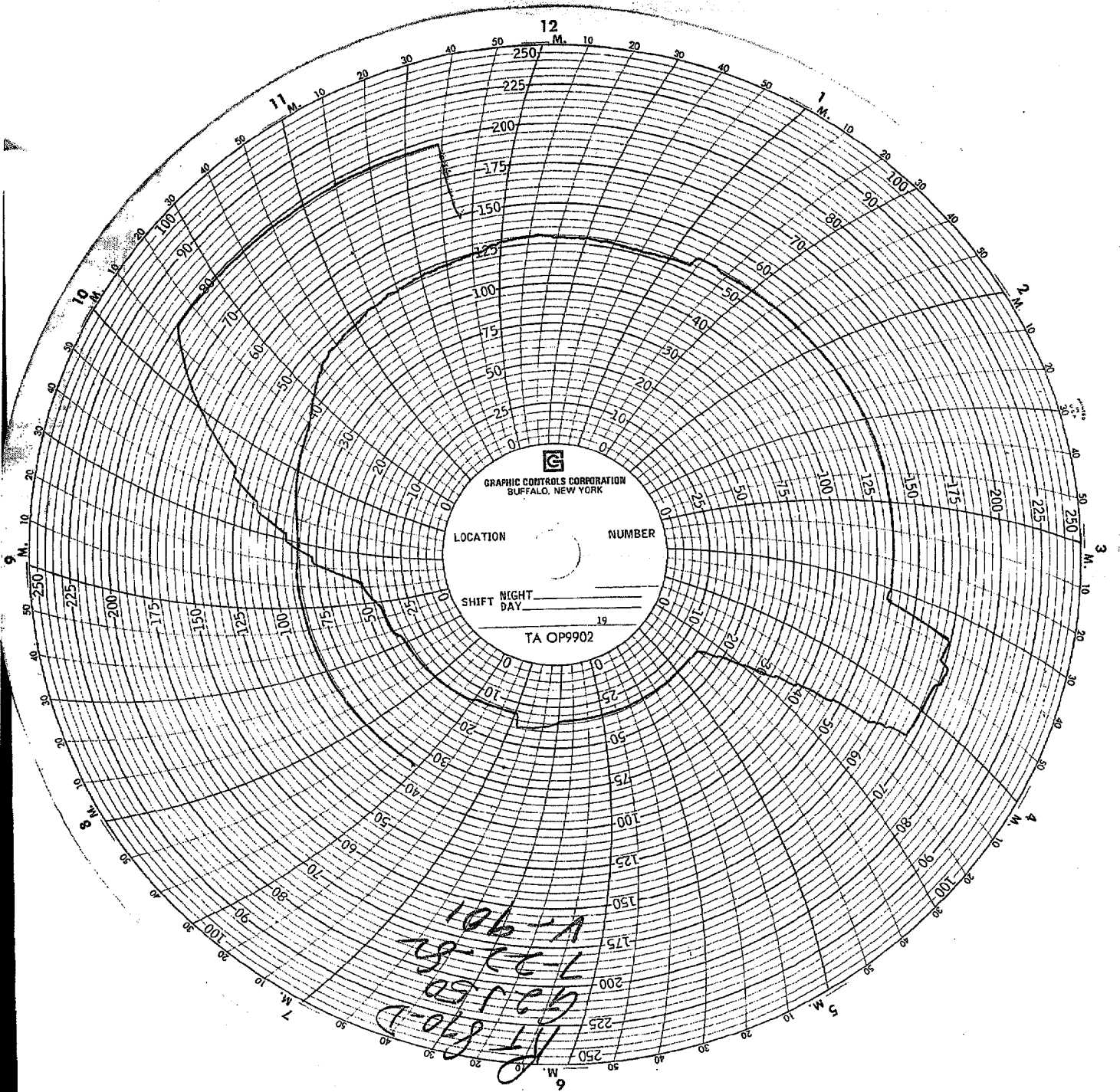
N32900.01

DUP050464649



N32900.02

DUP050464650



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