

CG 32 CODE RT-618-D PKG _____

PROCESSES

APPROVED BY

MAY 0-81-31120
(DATE) (LOT NUMBER)

() RT-618-D (S)

JJG 3-18-81

() ALTERNATE ()

() ()

TYPED BY: JMH

ESTIMATED WGT 2902 LBS. STANDARD HRS. _____ TIME _____ M

PREPARATION NOTES: _____

EQUIP MENT	NAME: WATCHUNG RED Y	USE LBS	N-CODE	ACCT LBS
PREP				
1	RECORD: _____ BATCHES SINCE SPARKLER LAST CLEANED. AFTER 5 BATCHES, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15#		777-A	
2	OBTAIN FOR S11		740-C	
3	OBTAIN FOR S24		253-C	
4	INSTALL DV & CV RECORDER & CONTROLLER CHART NOTE: NOTIFY PRESS ROOM AND ROPE OFF AREA UNDER V-922			
931	5 RUN 10" (100G) WATER INTO V- <u>931</u> & ADJ TO 80-100 DEG F	63	530-A	63
2	6 ADD IN 1-2 MIN			
	7 STIR 2 MIN & RECORD: PH <u>10.2</u> (9.5-10.5)			
	8 STIR 20 MIN OR LONGER FOR S27			
922	9 RUN 31" (700G) WATER INTO V-922			
3	10 WEIGH IN V-926 & RUN IN M <u>7</u> , <u>48.79</u> %	412	7-D	201
	11 TURN ON AGITATOR & STEAM & DUMP IN FROM S2		740-C	1035
	LOT 100% % <u>786</u> <u>1035</u> <u>79.40</u>	1041		
	12 DUMP IN	50	113-B	50
	13 DUMP IN	10	777-A	10
	14 HEAT TO 212-214 DEG F, RECORD HT <u>212</u> F, <u>214</u> DEG F WATCH FOAM			
	15 RECORD BY <u>+</u> (+), IF NECESSARY ADJ TO +BY ASSUME 50%		7-D	
	16 STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM			
	NOTE: RECORD: SPARKLER PRESSURE <u>0</u> PSI IF NOT ZERO, NOTIFY SUPERVISOR			
	17 CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 F FOR S19 & RECORD: HT <u>190</u> DEG F AND RECORDER <u>195</u> DEG F			
	RECORD: START <u>12:30 PM</u> , TOTAL MIN <u>15</u> CLARITY <u>clear</u> . NOTE: SAMPLE FROM HOSE - SHOW TO SUPERVISOR FOR O.K.			

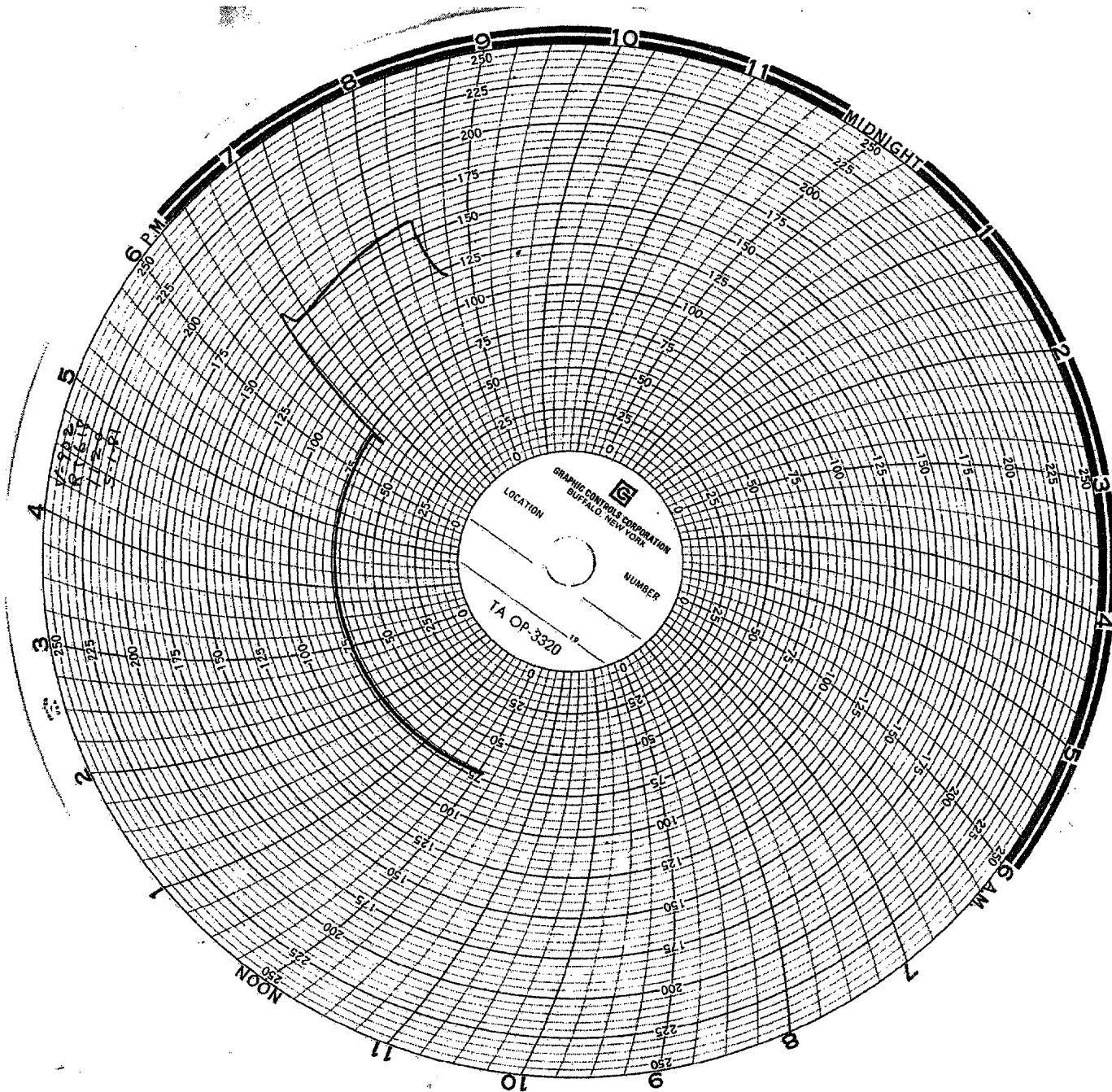
V.M.I.

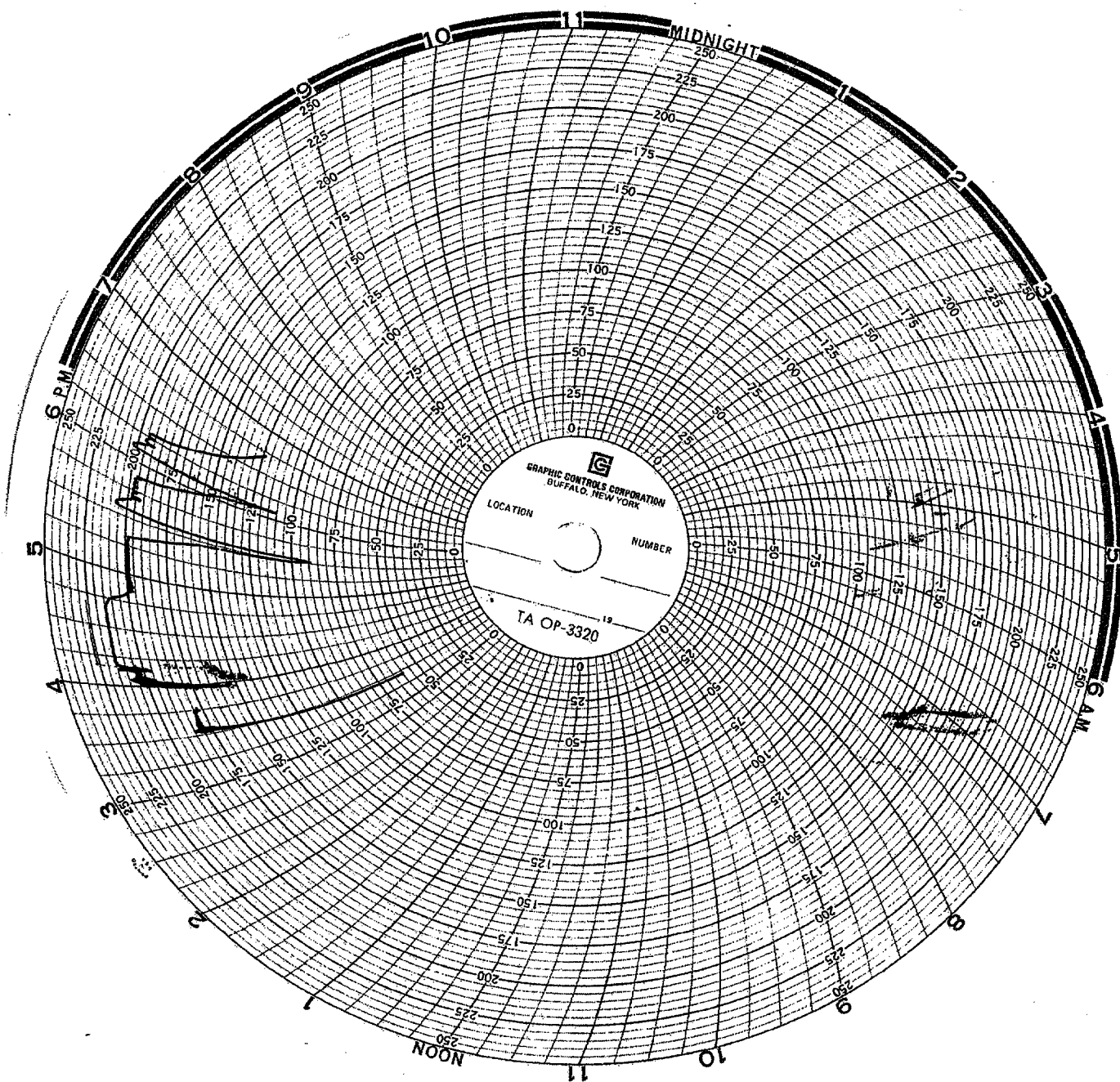
MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 2 OF 3 CG 32 CODE RJ-618-D (S)	USE LBS	N-CODE	ACCT LBS
904 4	18 19	RUN 1" (50G) WATER INTO V-904 WHEN S17 COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F RECORD: START <u>12:45 PM</u> , TOTAL MIN <u>35</u>			
MISC 5	20 21	WEIGH IN PT FOR S35 M <u>6</u> , <u>33.68</u> % MEASURE <u>84 1/2</u> UNITS IN V-928 FOR S33 M <u>2</u> , <u>32.00</u> %	<u>986</u> <u>1209</u>	725-A 28-D	332 419
CV 6	22 23 24 25 26 27	RUN 16" (1530G) WATER INTO V- <u>903</u> WEIGH IN V-926 & RUN IN M <u>7</u> , <u>48.79</u> % DUMP IN FROM S3 LOT <u>536</u> <u>534</u> WEIGH ON POSTAL SCALE & DUMP IN LOT ADJ TO 70-90 DEG F & STIR TO DISSOLVE STEAM EJECT V-921/931 INTO CV	<u>1039</u> <u>12</u> <u>900</u> 7 1000	7-D 253-C	507 912
922 7	28 29A	WHEN S19 COMPLETE, SHUT OFF PUMP & INSERT V-922 FOOT PLUG RUN IN 10" (207G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER.			
904 8	30B	PUMP V-922 THRU SPARKLER INTO V-904			
922 9	30A	RUN IN 5" (103G) WATER INTO V-922 & HEAT TO 190-195 F. CIRCULATE 15 MIN THRU SPARKLER			
904 10	30B 31 32 33 34 35 36	PUMP V-922 THRU SPARKLER INTO V-904 WHEN MTY BLOW OUT SPARKLER INTO V-904 HEAT TO 165-170 F (SMPL TO SUPVR FOR O.K.) RUN IN N-28-D FROM S21 IN 12-15 MIN & STIR 5 MIN AT 165-170 DEG F ADJ TO 129" (3409G) AT 28-30 DEG F AND RECORD: TEMP <u>29</u> DEG F, <u>29</u> " RUN IN N-725-A FROM S20 AFAP (5-10 MIN) STIR 30 MIN AT 28-35 DEG F MAINTAINING +CR, +KI FOR S41 AND RECORD: TIME START <u>4:37 PM</u> , CR <u>+</u> (+), KI <u>+</u> (+) NOTE (1) IF CR-, KI-, ADD 20# AS IS IN- CREMENTS ASSUME 32% RECORD: CR <u>+</u> (+), KI <u>+</u> (+) (2) IF CR+, KI-, ADD 20# AS IS INCREMENTS RECORD: CR <u>+</u> (+), KI <u>+</u> (+) ASSUME 33%	<u>42</u> 40X330	57-A 28-A 725-A	<u>13860</u>

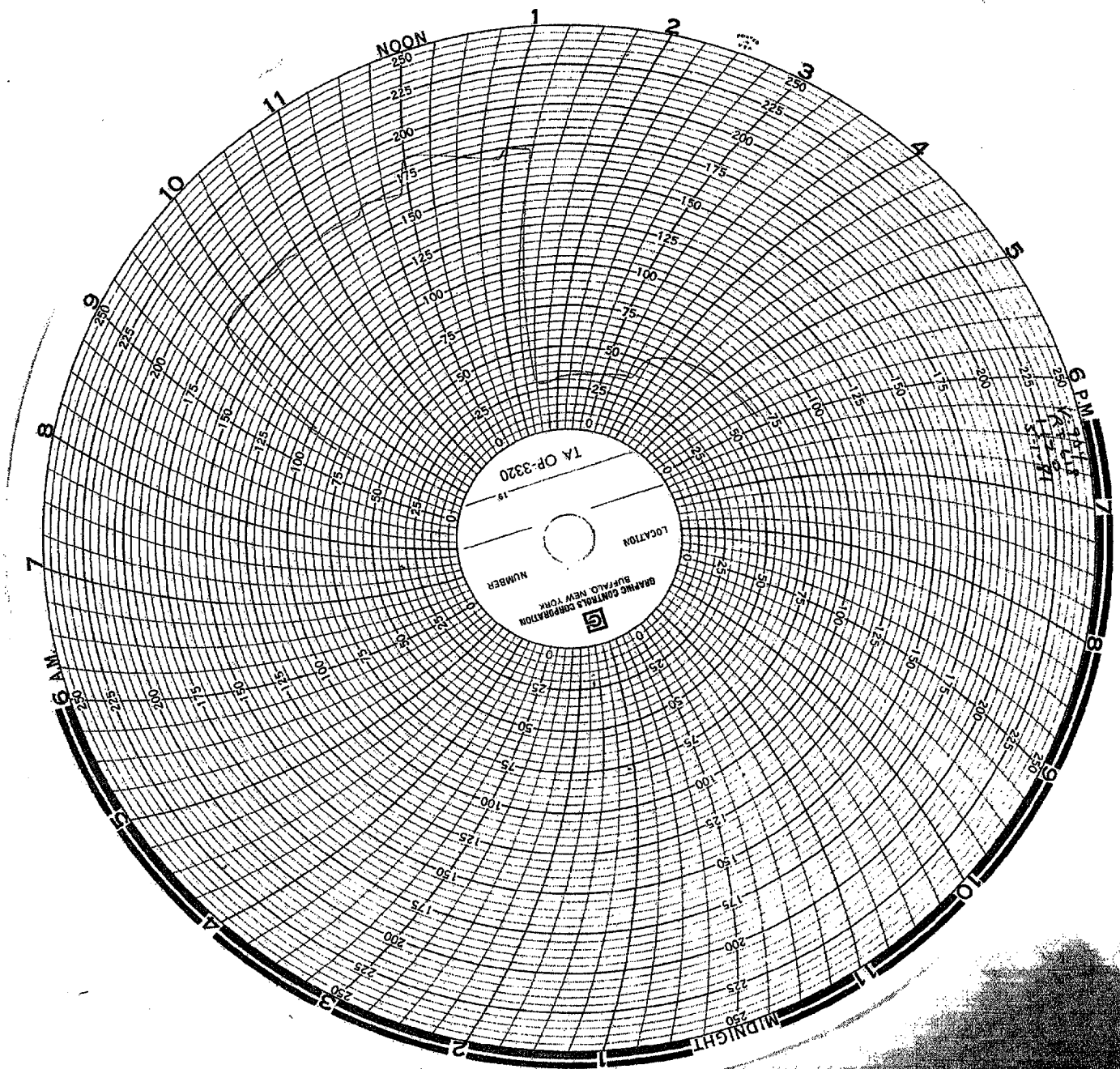
MAKING INSTRUCTIONS: BATCH UNIT

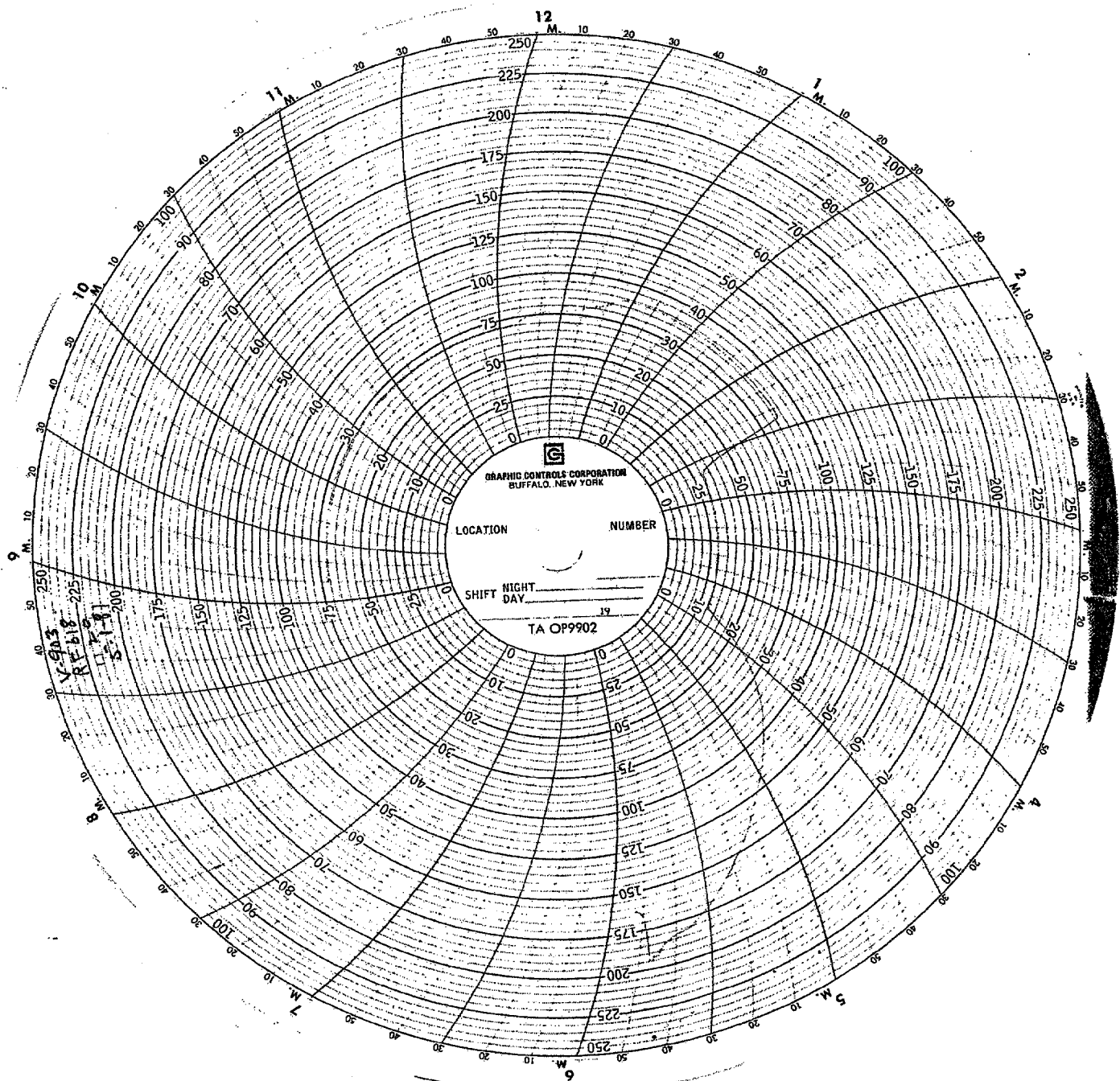
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