

CG 32 CODE RT-618-D PKG.

→ OCT - 6 180 37361
EST. WGT. 2597 LBS.

STD. HRS. TIME 3P M

D.V. 904

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

PRECOAT SPARKLER
DONE

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#	15	777-A	15
	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-931 & adj to 80-100°F			
	6	Add in 1-2 min	50	530-A	50
2	7	Stir 2 min & Record: pH 9.9 (9.5-10.5)			
	8	Stir 20 min or longer for S 27			
922	9	Run 30" (620 G) water into V-922			
3	10	Weigh in V-926 & run in M 11, 49.64%	357	7-D	178
	11	Turn on agitator & steam & dump in from S 2		740-C	920
		Lot 100%			
		103 661 78.35 672			
		102 259 78.73 262			
	12	Dump in	40	113-B	40
	13	Dump in	10	777-A	10
	14	Heat to 212-214°F. Record: HT 212; 213 OF 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			
	17	Circulate 15 min or longer thru Sparkler until sol'n is clear			
		Maintain at 190-195°F for S 19 & Record: HT 192 OF			
		& Recorder 193 OF			
		Record: Start 5:00 PM, Total Min 10, Clarity 8			
		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 5:10 PM, Total Min 15			
Misc	20	Weigh in PT for S 35 M 11, 33.21%	353	725-A	295
5	21	Measure 79 units in V-928 for S 33 M 7, 31.62%	117	28-D	372
CV	22	Run 14" (1330 G) water into V-901			
6	23	Weigh in V-926 & run in M 11, 49.64%	757	7-D	450
	24	Dump in from S 3		253-C	810
		Lot 499 310			
	25	Weigh on postal scale & dump in Lot -		280-C	
	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 (T) 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 12" (247 G) water & heat to 180-190°F			
904	30	Pump V-922 thru Sparkler into V-904			
8	31	When MTY blow out Sparkler into V-904			
	32	Heat to 165-170°F (Sample to Supervisor for OK)			
	33	Run in N-28-D from S 21 in 12-15 min & stir 5 min at 165-170°F	45		
	34	Adj to 90" (2390 G) at 28-30°F & Record: Temp 28 OF, 90 "	45 x 330	57-A	14850
	35	Run in N-725-A from S 20 AFAP (5-10 min)			
	36	Stir 30 min at 28-35°F maintaining +CR, +KI for S 41		57-A	
		Record: Time Start 10:20 AM 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
	38	Adj to 33" (3130 G) at 28-32°F	33 x 330	57-A	10890
		Record: Temp 25 OF & Volume 33 "			
	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 11:25 AM, Total Min 45, Final Temp 25 OF			
	42	Stir 30 min & Record: Base + (+), Diazo - (-), pH 9.8 (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 180-182°F in 65-70 min & Record: HT 182 OF & Recorder 182 OF			
DW	45	Run 23 " (600 G) water into DV			
10V	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 180-182°F			
11		Record: Start 2:05 AM, Total Min 10			
	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 (9.0-9.4) & stop agitator			
		OPEN cap on distributors SAMPLE			
		START FINISH OPTR			
		2:00 PM 11:05 PM 320			
		11: PM 3: AM 223			
		When instructed by Processing Area half way thru pressing, Dump in, stir 5 min, & stop agitator. Resume pressing.	10	588-A	10







