

CG 32 CODE RT-880-D PKG.

→ JUL-2 36359

EST. WGT. 1921 LBS.

STD. HRS. TIME 7A M

PUNCHED & CHECKED

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JUL - 8 1980

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JUL 2 1980

PROCESSES		APPROVED BY	
() RT-880-D	(E)	JJG 08-16-78	
()	()	AMJ 01-22-79	
()	()		
()	()		
TYPED BY			
emw020679			

NON-BLEEDING

QUIPMENT	NAME: WATCHUNG® RED B	USE LBS.	N CODE	ACCT. LBS.
	NOTE: Batch must be pressed promptly to control color. Do not start if press will not be available within 3 hrs after making. Record: Press will be ready M / P R Supv Start Making M O.K. Making Supv E.E.			
Prep 1	1 Record: batches since Sparkler last cleaned. After 5 2 batches, clean, dress Sparkler & pre-coat with 15# 3 Obtain for S 11 4 Obtain for S 27 5 Install CV & DV Recorder & Controller charts		777-A 740-C 82-C	
921/2	5 Run 8" (80 G) water into V-921 & adj to 80-100°F 6 Add in 2-3 min 7 Stir 5 min & Record: pH 9.8 (9.5-10.5) 8 Stir 20 min or longer to dissolve for S 36	80	99-A	80
922 3	9 Run 28" (578 G) water into V-922 10 Weigh in V-926 & run in M 5.5, 50.15 % 11 Turn on agitator & steam & dump in from S 2 Lot #100% 56 843 98.33 857	329	7-D 740-C	165 843
	12 Dump in 13 Dump in 14 Heat to 212-214°F 15 Record: BY + must be + If necessary, adj to +BY Assume 50% 16 Stir 30 min at 212-214°F, then shut off steam 17 Circulate 15 min or longer thru Sparkler until sol'n is clear Maintain at 190-195°F for S 24 Record: Start 12:10 P.M. Total Min 15. Clarity O.K. 18 Record: HT 192°F & Rec 195°F	25 10	113-B 777-A 7-D	25 10
Misc 4	19 Weigh in PT-1 for S 45 M 8, 33.62% 20 Weigh in drum for S 51 M 8, 33.62% 21 Weigh in drum for S 52 M 8, 33.62% 22 Measure 8474 units in V-928 for S 42 M 6, 30.85%	815 95 95 1316	725-A 725-A 725-A 28-D	274 32 32 406
904/CV 5	23 Run in 1" (G) water into V-903 NOTE: Use CV if MTY. If CV is not MTY, use V-904 24 When S 18 is complete, dump V-922 thru Sparkler, Maintain V-922 at 190-195°F Record: Start 12:55 P.M. Total Min 45			

EQUIPMENT		PAGE 2 CG 32 CODE RT-880-D (E) EST. WGT.	1921 LBS.	USE LBS.	N CODE	ACCT. LBS.
902	25	Run 48" (1257 G) water into V-902				
6	26	Weigh in V-926 & run in	M.S. 50.15%	688	7-D	345
	27	Dump in from S 3	Lot		82-C	771
			4121	750		
			4076	21		
	28	Adj to 70-90°F & stir to dissolve				
922	29	When S 24 complete, shut off pump & insert V-922 foot-plug				
7	30	Run in 12" (247 G) water & heat to 180-190°F				
CV	31	Pump V-922 thru Sparkler into CV				
8	32	When MTY blow out Sparkler into CV				
	33	Dissolve in 20 G water at 150-160°F in drum & pour in		24	133-B	24
	34	Heat V-904/CV to 165-170°F for S 40				
902	35	When S 28 complete, measure in calibrated container,		76	39-A	76
9		slurry with 46 G water in drum & pour into V-902				
	36	Steam eject in V-921/931 from S 8				
PT-2	37	Run into PT-2	M.S. 50.15%	191	7-D	96
10	38	Adj to 15" (54 G)				
	39	Stir 5 min or longer for S 57				
		NOTE: If N-740-C solution was pumped directly from Sparkler to CV at S 23 & 24, omit S 40 & 41				
CV	40	Run 1" (95 G) water into V-				
11	41	If V-904 is used, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min). Maintain 165-170°F				
		Record: Start , Total Min				
	42	Run in N-28-D from S 22 in 12-15 min				
	43	Stir 5 min				
	44	Adj to 34" (3264 G) at 32-38°F		36 x 330	57-A	11,880
		Record: Temp °F, Stick "				
	45	Run in N-725-A from S 19 AFAP (5-10 min)				
	46	Stir 10 min at 32-38°F maintaining +CR, +KI for S 54				
		Record: Time Start 5:10 P, 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		850	20-A	850
	48	Dump in		186	246-E	186
	49	Dump in		40	65-A	40
	50	Add for maintaining at 32-38°F during coupling		29 x 330	57-A	9,570
	51	Pour in N-725-A from S 20				
902	52	Pour N-725-A from S 21 into V-902				
12	53	Dump in & stir 2-3 min		156	165-A	156
CV	54	Immediately couple 902 thru undersurface distributor into CV				
13		in 18-22 min. Maintain CV at 32-38°F				
		Record: Start 7:05 P, Total Min 22				
	55	Install 5/16" orifice in undersurface addition line				
	56	When S 54 complete, stir 5 min &				
		Record: Base + (+), Diazo + (+), pH 5.0 (5.0-6.0)				

EQUIPMENT	PAGE 3 CG 32 CODE RT-880-D (E) EST. WGT.	1921 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 13 cont'd	57 Run in N-7-D from S 39 thru 5/16" orifice Record: 45 Min (40-50 min)				
	58 Stir 10 min & Record: pH 7.5 (7.0-8.5)				
	59 If pH below 7.0 adj to pH 7.0-8.5 with N-7-D only Assume 50% Record: pH			7-D	
	60 Weigh in V-926 & run in Assume 50%	80		7-D	40
	61 Stir 5 min & Record: Base + (+), Diazo - (-), pH 9.3 (9.0-9.8)				
	62 If pH below 9.0, adj to pH 9.0-9.8 with N-7-D only Assume 50% Record: pH			7-D	
	63 Measure in calibrated container & pour in	28	588-A	28	
	64 Heat to 193-195°F in 75-80 min Record: Start 9:30 PM				
	65 Record: HT 193 OF & Rec 195 OF				
	66 Stir 60 min at 193-195°F Record: Start 10:50 PM				
	67 After 20 min S 66 stir Record: pH 9.0 (8.9-9.3)				
	68 If pH below 8.8, adj to pH 8.8-9.3 with N-7-D only Assume 50% Record: pH			7-D	
	69 When S 66 complete, flood to 180-190" (±18,000 G)				
	70 Stop agitator				
	When instructed by Processing Area half-way thru pressing				
	1. Dump in	10	588-A	10	
	2. Stir 5 min				
	3. Advise Processing to resume pressing				
	START FINISH OPTR				
	10:00 AM 3:00 PM 381				
	3:00 PM 11:00 PM 101				
	11:00 PM 12:15 AM 237				



