S.V. C.V. 901 903 D.V. 902,904

CG 32 CODE RT-761-D PKG 49

1/5/82 A2H61
( DATE ) (LOT NUMBER)

PROCESSES APPROVED BY
( ) RT-761-D ~~PH~~ ~~JJG 1-22-81~~
(I) ALTERNATE( )
( ) ~~XQB 27~~ ( )
TYPED BY: JLC

EST. WT. ~~2610~~ 2737# LBS. STANDARD HRS. TIME 7 AM

PREPARATION NOTES:

| 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 SUPERVISOR TO REVIEW WITH P.R. SUPV. & RECORD: | | | |
| | | PRESS WILL BE READY _____M____/_____PR SUP | | | |
| | | START MAKING _____M_____/_____MAKG SUPV | | | |
| PREP 1 | 1 | RECORD: _____BATCHES SINCE SPARKLER LAST CLEANED. AFTER 5 BATCHES, CLEAN, DRESS SPARKLER & PRECOAT WITH 15# | _____ | 777-A | _____ |
| | 2 | OBTAIN FOR S 12 | | 740-C | |
| | 3 | OBTAIN FOR S 27 | | 82-C | |
| | 4 | INSTALL DV & CV RECORDER & CONTROLLER CHART | | | |
| 921/ 931 2 | 5 | RUN 16" (160G) WATER INTO V_____& ADJ TO 80-100 DEG 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 29 | | | |
| | | NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V 922 | | | |
| 922 3 | 10 | RUN 32" (680 G) WATER INTO V 922 | | | |
| | 11 | WEIGH INTO V-926 & RUN IN M_____,_____% | _____ | 7-D | 216 |
| | 12 | TURN ON AGITATOR & STEAM & DUMP IN FROM S 21 | | 740-C | 1107 |
| | | LOT #100% % | | | |
| | | _____ _____ _____ | _____ | | |
| | | _____ _____ _____ | _____ | | |
| | | _____ _____ _____ | _____ | | |
| | 13 | DUMP IN | 25 | 113-A | 25 |
| | 14 | DUMP IN | 10 | 777-A | 10 |
| | 15 | HEAT TO 212-214 DEG F WATCH FOAM | | | |

| EQUIPMENT | | PAGE 2 OF 4 CG 32 CODE RT-761-D (H) | USE LBS | N-CODE | ACCT LBS |
|---|---|---|---|---|---|
| 922 3 CON'D | 16 | RECORD: BY_____MUST BE +, ADJ IF NEEDED ASSUME 50% | _____ | 7-D | _____ |
| | 17 | STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM<br>NOTE: RECORD: SPARKLER PRESSURE _____PSI<br>IF NOT ZERO, NOTIFY SUPERVISOR | | | |
| | 18 | RECORD: HT_____F & REC_____F | | | |
| | 19 | CIRCULATE 15 MIN OR LONGER AT 190-195 DEG F THRU SPARKLER UNTIL SOL'N IS CLEAR.<br>MAINTAIN AT 190-195 DEG F FOR S 24<br>RECORD: START_____, TOTAL MIN_____<br>CLARITY_____ | | | |
| MISC 4 | 20 | MEASURE_____UNITS IN V 928 FOR S 42 (MURIATIC ACID)M_____,_____% | _____ | 28-D | 533 |
| | 21 | WEIGH IN FT FOR S 45 M_____,_____% | _____ | 725-D | 359 |
| | 22 | WEIGH IN DRUM FOR S 53 (SODIUM NITRATE SOL) | | 725-D | 42 |
| 904/CV 5 | 23 | RUN 1" _____G WATER INTO V_____<br>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 DEG F<br>RECORD: START_____, TOTAL MIN_____ | | | |
| 902 6 | 25 | RUN 56" (1566 G) WATER INTO V 902 | | | |
| | 26 | WEIGH IN V 926 & RUN IN M_____,_____% | _____ | 7-D | 682 |
| | 27 | ADJ TO 70-90 DEG F & STIR 10 MIN TO DISSOLVE | | | |
| | 28 | SLURRY IN 30 GAL WATER & POUR INTO V 902<br>TRISULPHOIL SOAP D) | 100 | 39-A | 100 |
| | 29 | STEAM EJECT IN V 921/931 FROM S 9 | | | |
| 922 & 904/CV 7 | 31 | WHEN S 24 COMPLETE, SHUT OFF PUMP & INSERT FOOT PLUG IN V 922 | | | |
| | 32 | RUN IN 10" (207 G) WATER & HEAT TO 190-195 DEG 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 5" (103 G) WATER INTO V 922 & HEAT TO 190-195 DEG F | | | |
| | 36 | CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR. | | | |
| | 37 | PUMP V 922 THRU SPARKLER INTO V 904/CV | | | |
| | 38 | WHEN V 922 MT BLOW OUT SPARKLER INTO V904/CV | | | |
| | 39 | HEAT V 904 TO 165-170 DEG F FOR S 42<br>NOTE: IF N-740-C SOLUTION WAS PUMPED DIRECTLY FROM SPARKLER TO CV AT S'S 23 & 24 OMIT S'S 40-41 | | | |

N.V. C.V. 901,903 D.V. 902,904

CG 32 CODE RT-761-D PKG ___

PROCESSES
( ) RT-761-D (J)
( ) RT-838-D (I)
( ) ( )
TYPED BY: JLC

APPROVED BY
JJG 6/10/81

( DATE ) (LOT NUMBER)

ESTIMATED WGT ~~2790~~ ~~2449~~ 2737* LBS. STANDARD HRS. TIME _____M

PREPARATION NOTES: _____

| 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____/_____PR SUP START MAKING _____M_____/_____MAKG SUPV | | | |
| PREP 1 | 1 | RECORD: _____BATCHES SINCE SPARKLER LAST CLEANED. AFTER 5 BATCHES, CLEAN, DRESS SPARKLER & PRECOAT WITH 15# | _____ | 777-A | _____ |
| | 2 | OBTAIN FOR S 12 | | 740-C | |
| | 3 | OBTAIN FOR S 27 | | 82-C | |
| | 4 | INSTALL DV & CV RECORDER & CONTROLLER CHART | | | |
| | 4A | CLOSE OVERFLOW OUTLET VALVE FOR DISTRIBUTOR LINE AT REAR OF VAT | | | |
| 921/ ~~931~~ 2 | ~~5~~ | RUN 16" (160G) WATER INTO V 921 & ADJ TO ~~20-100~~ DEG F | | | |
| | ~~6~~ | ~~ADD IN~~ 2-3 MIN | 115 | 99-A | 115 |
| | ~~7~~ | ~~ADD IN~~ 1-2 MIN | 52 | 530-A | 52 |
| | ~~8~~ | ~~STIR~~ 5 MIN & RECORD: PH 10.2 (9.5-10.5) | | | |
| | ~~9~~ | STIR 20 MIN OR LONGER TO DISSOLVE FOR S 30 NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V 922 | | | |
| 922 ~~3~~ | ~~10~~ | RUN 35" (722 G) WATER INTO V 922 | 449 | 7-D | 226 |
| | ~~11~~ | ~~WEIGH~~ INTO V-926 & RUN IN M_____, 50.36% | | 740-C | 1157 |
| | ~~12~~ | TURN ON AGITATOR & STEAM & DUMP IN FROM S 2 | | | |
| | | LOT #100% % | | | |
| | | 237 639 98.30 | 650 | JAN 6, 1982 | |
| | | 231 321 98.90 | 325 | | |
| | | 251 197 98.77 | 199 | | |
| | ~~13~~ | DUMP IN | 25 | 113-A | 25 |
| | ~~14~~ | DUMP IN | 10 | 777-A | 10 |
| | ~~15~~ | HEAT TO 212-214 DEG F WATCH FOAM | | | |
| | ~~16~~ | RECORD: BY ___ MUST BE +, ADJ IF NEEDED ASSUME 50% | _____ | 7-D | _____ |

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| | | | | | |
|---|---|---|---|---|---|
| 922 3 CONT | 14 | STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM | | | |
| | 15 | NOTE: RECORD: SPARKLER PRESSURE 0 PSI IF NOT ZERO, NOTIFY SUPERVISOR | | | |
| | 16 | RECORD: HT 212 F & REC 112 F | | | |
| | 17 | CIRCULATE 15 MIN OR LONGER AT 190-195 DEG F THRU SPARKLER UNTIL SOL'N IS CLEAR. | | | |
| | 18 | MAINTAIN AT 190-195 DEG F FOR S 24 RECORD: START 2247, TOTAL MIN 15, CLARITY C | | | |
| MISC 4 | 20 | MEASURE 20 UNITS IN V 928 FOR S 39 (MURIATIC ACID) M 28.8% | 1928 | 28-D | 557 |
| | 21 | WEIGH IN PT FOR S 42 M 33.2% | 1256 | 725-D | 419 |
| | 22 | WEIGH IN DRUM FOR S 48 (SODIUM NITRITE SOL) | 126 | 725-D | 42 |
| ~~904~~/CV 5 | 23 | RUN 1* ____G WATER INTO V 701 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 DEG F RECORD: START 2320, TOTAL MIN 35 | | | |
| 902 6 | 25 | RUN 56* (1566 G) WATER INTO V 902 | | | |
| | 26 | WEIGH IN V 926 & RUN IN M 50.3% | 1459 | 7-D | 735 |
| | 27 | DUMP IN FROM S3 LOT 7301 6371 | 1000 56 | 82-C | 1056 |
| | 27A | WEIGH ON POSTAL SCALE & ADD LOT 10331 | 18 | 180-C | 18 |
| | 28 | ADJ TO 70-90 DEG F & STIR 10 MIN TO DISSOLVE | | | |
| | 29 | SLURRY IN 30 GAL WATER & POUR INTO V 902 TRISULFHOIL SOAP D) | 105 | 39-A | 105 |
| | 30 | STEAM EJECT IN V 921/[redacted] FROM S 9 | | | |
| 922 & ~~904~~/CV 7 | 31 | WHEN S 24 COMPLETE, SHUT OFF PUMP & INSERT FOOT PLUG IN V 922 | | | |
| | 32 | RUN IN 12" (247G) 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 [redacted] | [redacted] | [redacted] | [redacted] |
| | 36 | HEAT V [redacted]/CV TO 165-170 DEG F FOR S 39 NOTE IF N-740-C SOL'N WAS PUMPED DIRECT FRM SPARKLR TO CV AT S'S23 & 24 OMIT S'S37 & 38 | | | |
| CV 8 | 37 | ~~RUN IN 1* (95 G) WATER INTO V____~~ | | | |
| | 38 | ~~IF V 904 IS USED, PUMP V904 AT 165-170 F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (12-15 MIN) MAINTAIN CV AT 165-170 DEG F~~ | | | |
| | 39 | RUN IN N-28-D FROM S20 IN 12-15 MIN | | | |
| | 40 | STIR 5 MIN | | | |
| | 42 | ADD TO 43" (4080 G) AT 32-38 DEG F (ICE) | 50 (330 | 57-A | 16500 |
| | 43 | RUN IN N-725-A FROM S 21 AFAP (5-10 MIN) | | | |
| | 44 | STIR 30 MIN AT 32-38 DEG F MAINTAINING +CR, +KI RECORD: TIME START 5:10 PM | | | |
| | | CR +___(+) KI +___(+) | | | |

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| EQUIP MENT | | PAGE 3 OF 3 CG 32 CODE RT-761-D (J) | USE LBS | N-CODE | ACCT LBS |
|---|---|---|---|---|---|
| CV 8 CONT | | NOTE: | | | |
| | | (1) IF CR-,KI-, ADD 20% "AS IS" INCREMENTS ASSUME 32% RECORD: CR_____(+), KI_____(+) | | 28-D | |
| | | (2) IF CR+,KI-, ADD 20% "AS IS" INCREMENTS ASSUME 33% RECORD: CR_____(+), KI_____(+) | | 725-A | |
| | 44 | DUMP IN (CALCIUM CHLORIDE) | 1166 | 20-A | 1166 |
| | 46 | DUMP IN (STRONTIUM NITRATE) | 255 | 246-D | 255 |
| | 48 | DUMP IN (BLANC FIXE) | 135 | 65-A | 135 |
| | 47 | ADD FOR MAINTAINING 32-38 DEG F DURING COUPLING | 10 36 X330 | 57-A | 3300 |
| 902 9 | 48 | POUR N-725-D FROM S 22 INTO V 902 | | | |
| | 49 | DUMP IN (AMMONIUM CHLORIDE) | 189 | 165-A | 189 |
| CV 10 | 50 | IMMEDIATELY COUPLE V 902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN. MAINTAIN DV AT 32-38 DEG F (OPEN VALVE 1-1/4 TURNS) | | | |
| | | RECORD: START 556PM TOTAL MIN 24 | | | |
| | 51 | STIR 30 MIN & RCRD: BASE +___(+), DIAZO ___(-), PH 10.2 (10.0-10.5) | | | |
| | 52 | IF NECESSARY, ADJ TO PH (10.0-10.5) & RECORD: PH_____ ASSUME 50% | | 7-D | |
| | | ASSUME 32% | | 28-D | |
| | 53 | WEIGH IN DRUM & POUR IN (ISO OCTANOL) | 45 | 500-D | 45 |
| | 54 | HEAT TO 174-176 DEG F IN 70-75 MIN | | | |
| | 55 | RECORD: HT_____F & REC 175 F (AT SOF, OPEN WATER SPRAYS 1 1/4 TURNS) | | | |
| | 56 | STIR 30 MIN AT 174-176 DEG F | | | |
| | 57 | AFTR 10 MIN S56 STIR RCRD: PH 9.5 (9.5-10.0) | | | |
| | 58 | IF NECESSARY, ADJ TO PH 9.5-10.0 ASSUME 50% RCRD PH_____ IF PH ABOVE 10.0 DO NOT ADJUST | | 7-D | |
| | 59 | WHEN S 56 COMPLETE, FLOOD TO 180-190° (+,- 18,000 G) & STOP AGITATOR & TURN OFF WATER SPRAYS | | | |
| | 60 | OPEN WATER VALVE AT OVERFLOW FOR DISTRBUTR AND BACK FLUSH THRU CHECK VALVE AND DISTRIBUTOR FOR 2 MINUTES. SHUT OFF WATER. | | | |
| | 61 | OPEN OVERFLOW OUTLET VALVE FOR DISTRIBUTOR REAR OF VAT. | | | |
| | | WHEN INSTRUCTED BY PROCESSING AREA HALFWAY THRU PRESSING | | | |
| | | (1) DUMP IN | 10 | 500-A | 10 |
| | | (2) STIR 5 MIN | | | |
| | | (3) ADVISE PROCESSING TO RESUME PRESSING | | | |

| START | FIN | OPTR |
|---|---|---|
| 2:00 P 3:00 P.M. | 3:0 P 9:45 P.M. | 391 |

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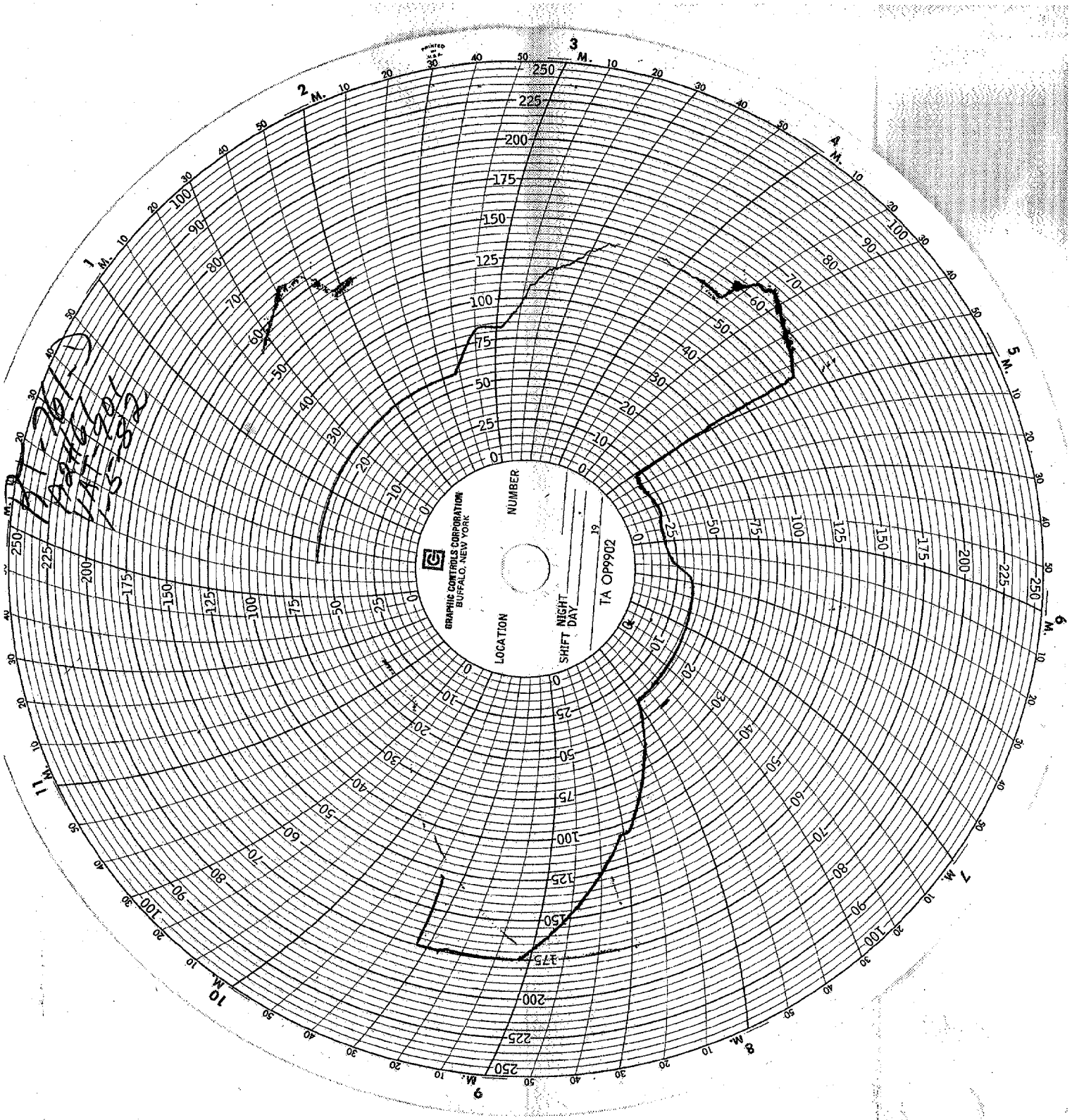
| EQUIPMENT | | PAGE 3 OF 4 CG 32 CODE RT-761-D (H) | USE LBS | N-CODE | ACCT LBS |
|---|---|---|---|---|---|
| CV 8 | 40 | RUN 1* (95 G) WATER INTO V_____ | | | |
| | 41 | IF V 904 IS USED, PUMP V 904 AT 165-170 DEG F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (12-15 MIN) MAINTAIN CV AT 165-170 DEG F | | | |
| | 42 | RUN IN N-28-D FROM S 20 IN 12-15 MIN | | | |
| | 43 | STIR 5 MIN | | | |
| | 44 | ADJ TO 43* (4080 G) AT 32-38 DEG F (ICE) | 45X330 | 57-A | _____ |
| | 45 | RUN IN N-725-A FROM S 21 AFAP (5-10 MIN) | | | |
| | 46 | STIR 30 MIN AT 32-38 DEG F MAINTAINING +CR, +KI<br>RECORD: TIME START_____CR_____(+)<br>KI_____(+) | | | |
| | | NOTE:<br>(1) IF CR-,KI-, ADD 20# *AS IS* INCREMENTS ASSUME 32%<br>RECORD: CR_____(+), KI_____(+) | _____ | 28-D | _____ |
| | | (2) IF CR+,KI-, ADD 20# *AS IS* INCREMENTS ASSUME 33%<br>RECORD: CR_____(+), KI_____(+) | _____ | 725-A | _____ |
| | 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 DEG F DURING COUPLING | 30X330 | 57-A | _____ |
| | 51 | DUMP IN FROM S 3 LOT<br>_____<br>_____<br>_____<br>_____ | _____<br>_____<br>_____<br>_____ | 253-C | 972 |
| | 52 | WEIGH ON POSTAL BALANCE AND DUMP IN AND STIR 10 MIN (1-HYDROXY-2-NAPTHOIC ACID) | 40 | 180-C | 40 |
| 902 9 | 53 | POUR N-725-D FROM S 22 INTO V 902 | | | |
| | 54 | DUMP IN (AMMONIUM CHLORIDE) | 189 | 165-A | 189 |
| CV 10 | 55 | IMMEDIATELY COUPLE V 902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 38-42 MIN. MAINTAIN DV AT 32-38 DEG F (OPEN VALVE 1-1/4 TURNS)<br>RECORD: START_____,TOTAL MIN_____ | | | |
| | 56 | STIR 30 MIN &<br>RECORD: BASE_____(+), DIAZO_____(-)<br>PH_____(9.5-10.0) | | | |
| | 57 | IF NECESSARY, ADJ TO PH 9.5-10.0 &<br>RECORD: PH_____ ASSUME 50% | _____ | 7-D | _____ |
| | | ASSUME 32% | _____ | 28-D | _____ |
| | 58 | WEIGH IN DRUM & POUR IN (ISO OCTANOL) | 45 | 588-D | 45 |
| | 59 | HEAT TO 184-186 DEG F IN 70-75 MIN | | | |
| | 60 | RECORD: HT_____F & REC_____F | | | |
| | 61 | STIR 30 MIN AT 184-186 DEG F | | | |
| | 62 | AFTER 10 MIN S 61 STIR,<br>RECORD: PH_____(9.5-10.0) | | | |

| EQUIP MENT | | [redacted] | USE | N CODE | ACCT LBS |
|---|---|---|---|---|---|
| | | PAGE 4 [redacted] CODE RT-761-D [redacted] | | | |
| CV 10 CONT'D | [redacted] | [redacted] ASSUME 50% [redacted] 10.0 DO NOT ADJUST | | [redacted] | |
| | 64 | [redacted] COMPLETE FLOOD TO 180-190° (+,- 18000 G) & STOP AGITATO[redacted] | | | |
| | 65 | [redacted] WHEN INSTRUCTED BY PROCESS AREA HALFWAY THRU PRESSING (1) DUMP IN [redacted] 5 MIN [redacted] (3) ADVISE PROCESSING TO RETURN PRESSING | | | |

| START | FINISH | OPTR |
|---|---|---|
| | | |
| | | |
| | | |
| | | |

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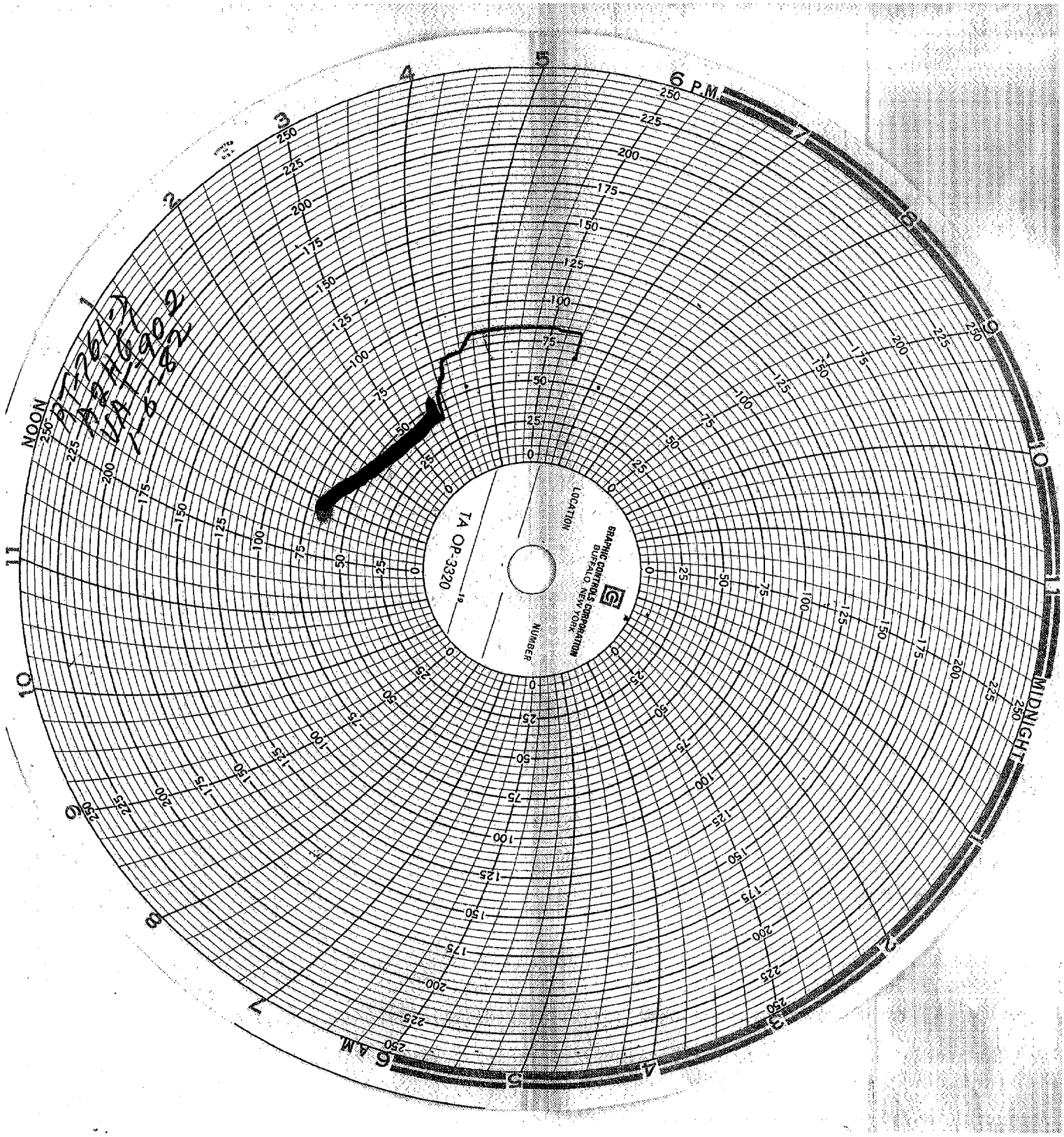


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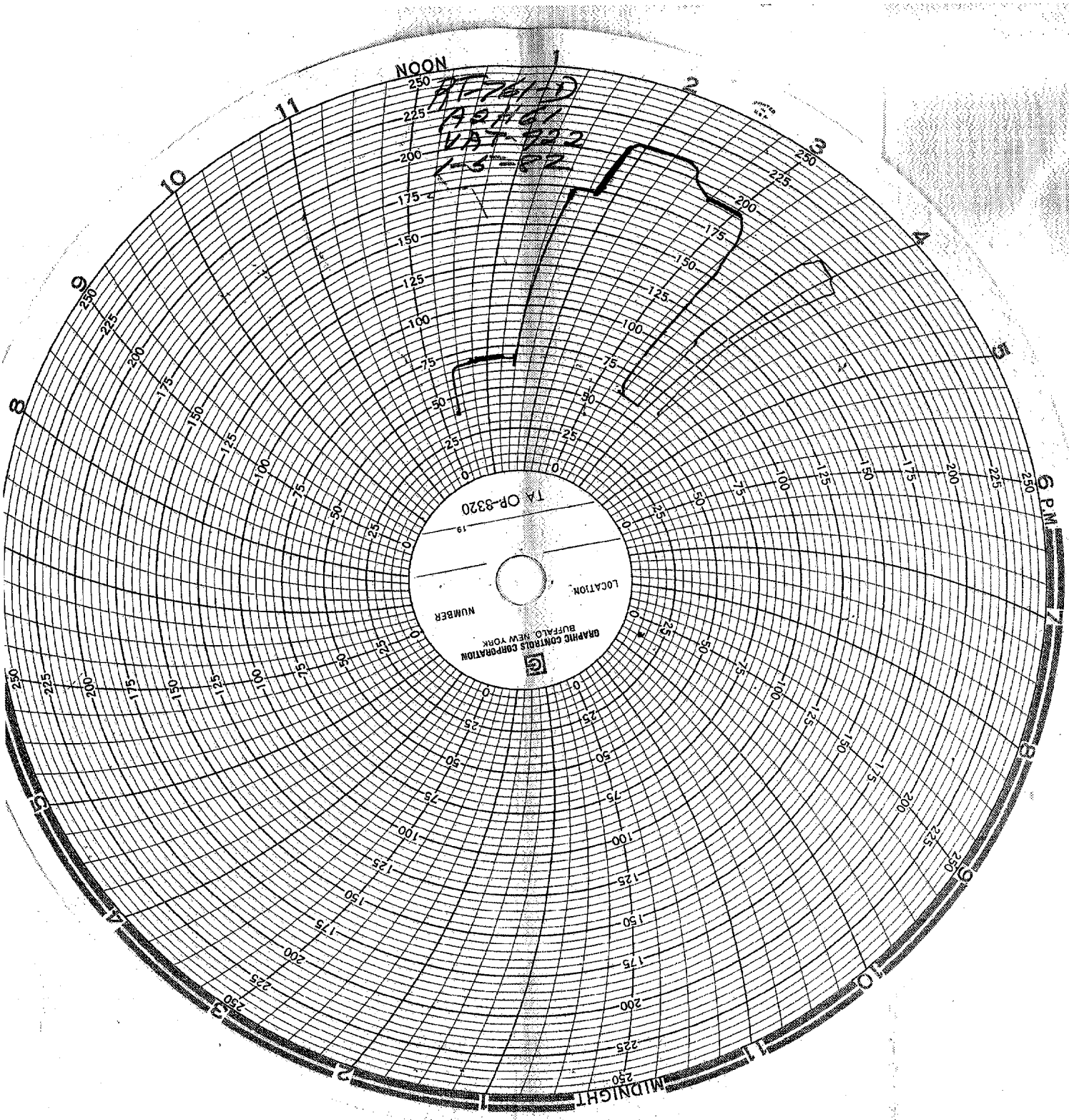


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