MAKING INSTRUCTIONS: BATCH UNIT

S.V. RT-261-D C.V. 901, 903 D.V. 902, 904

CG 32 CODE [redacted] PKG. 37993

→ Nov 20 80

EST. WGT. 2669 [redacted] LBS.

STD. HRS. 9.3 TIME _____ M

PROCESSES		APPROVED BY
( ) RT-880-D	(D)	JJG 08-16-78
( )	( )	AMJ 01-22-79
( )	( )	
( )	( )	
TYPED BY		
emw012979		

2 JG

use Flake caustic

NOV 20 1980

NON-BLEEDING

EQUIPMENT		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 / Making Supv			
Prep 1	1	Record: batches since Sparkler last cleaned. After 5 batches, clean, dress Sparkler & pre-coat with 15#		777-A	
	2	Obtain for S 11		740-C	
	3	Obtain for S 27		82-C	
	4	Install DV & CV recorder & Controller charts			
921/~~901~~ 2	5	Run 10" (100 G) water into V-921 & adj to 80-100°F			
	6	Add in 2-3 min	110 ~~100~~	99-A	~~100~~ 110
	7	Stir 5 min & Record: pH 10.0 (9.5-10.5)	50	530A	50
	8	Stir 20 min or longer to dissolve for S 36			
922 3	9	Run 35" (722 G) water into V-922		1721-D	
	10	Weigh in V-926 & run in M , %	216	~~7-D~~	216
	11	Turn on agitator & steam & dump in from S 2		740-C	1107
		Lot #100% % 114 1107 98.65	1122		
	12	Dump in	25	113-B	25
	13	Dump in	10	777-A	10
	14	Heat to 212-214°F WATCH FOAM			
	15	Record: BY + Must be + (Adj if Necessary) 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 24 Record: Start 12:30 PM Total Min 15 Clarity O.K.			
	18	Record: HT 192 °F & Rec 195 °F			
Misc 4	19	Weigh in PT-1 for S 45 M 12 , 33.16 %	1083	725-A	359
	20	Weigh in drum for S 51 M 12 , 33.16 %	126	725-A	42
	21	Weigh in drum for S 52 M 12 , 33.16 %	126	725-A	42
	22	Measure 99 units in V-928 for S 42 M 10 , 31.35 %	1200	28-D	533
904/CV 5	23	Run 1" (G) water into V-901 NOTE: Use CV if MTY, if CV is not MTY use V-904			
	24	When S 18 is complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 12:45 P Tot Min 10			

N35125

EQUIPMENT		PAGE 2 CG 32 CODE RT-880-D (D) EST. WGT: 2516 LBS.	USE LBS.	N CODE	ACCT. LBS.
902	25	Run 60" (1566 G) water into V-902		N-721	
6	26	Weigh in V-926 & run in M , %	453	7-D	453
	27	Dump in from S 3 Lot		82-C	987
		(DO NOT USE N82 Lot 5330 or 5308) 5350	987		
	28	Weigh on Postal Scale & Dump in	25	180C	25
	29	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 15" (309 G) water & heat to 180-190°F			
/CV	31	Pump V-922 thru Sparkler into V-/CV			
8	32	When MT blow out Sparkler into V-/CV			
	33	Dissolve in 20 G water at 150-160°F in drum & pour in	31	133-B	31
	34	Heat /CV to 165-170°F for S 40			
902	35	When S 28 complete, measure in calibrated container,	100	39-A	100
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 , %	126	N-721 7-D	126
10	38	Adj to 19" (68 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's 23 & 24, omit S'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 A.F.A.P. (10-15 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 43" (4080 G) at 32-38°F	46 x 330	57-A	14850
		Record: Temp 29 °F Stick 46 "			
	45	Run in N-725-A from S 19 A.F.A.P. (5-10 min)			
	46	Stir 20 min at 32-38°F maintaining +CR, +KI for S 54		57-A	
		Record: Time Start 2:35 PM 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	1116	20-A	1116
	48	Dump in	244	246-E	244
	49	Dump in	130	65-A	130
	50	Add for maintaining at 32-38°F during coupling 25	36 x 330	57-A	8250
	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	218	165-A	218
CV	54	Immediately couple 902 thru undersurface distributor into CV			
13		in 18-22 min. Maintain CV at 32-38°F			
		Record: Start 3:15 PM Total Min 20			
	55	Install 5/16" orifice in undersurface addition line			
	56	When S 54 complete, stir 30 min &			
		Record: Base — (+), Diazo + (+), pH 4.9 (5.0-6.0)			

EQUIPMENT		PAGE 3 CG 32 CODE RT-880-D (D) EST. WGT. 2516 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: 50 Min (40-50 min)			
	58	Stir 10 min & Record: pH 6.2 (7.0-8.5)			
	59	If pH below 7.0 adj to pH 7.0-8.5 with N-7-D only Assume 50%	40	72-D	40
		Record: pH 7.1			
	60	Weigh in V-926 & run in Assume 50%	53 106	72-D	53
	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%		7-D	
		& Record: pH			
	63	Measure in calibrated container & pour in	35	588-A	35
	64	Heat to 193-195°F in 75-80 min Start 5:05 PM			
	65	Record: HT 194 °F & Rec 195 °F			
	66	Stir 60 min at 193-195°F Record: Start 6:15 PM			
	67	After 20 min S 66 stir Record: pH 8.3 (8.8-9.3)			
	68	If pH 8.8, adj to pH 8.8-9.3 with N-7-D only Assume 50%	60	72-D	60
		Record: pH 9.3			
	69	When S 66 complete, flood to 180-190" (±18,000 G)			
	70	Stop agitator			
		When instructed by Processing Area halfway thru Pressing			
		1. Dump in	10	588-A	10
		2. Stir 5 min			
		3. Advise Processing to resume Pressing			
		START FINISH OPTR			
		7:00AM 3:00PM 30½-381			
		3:00PM 7:25PM 381			

6:05 PM

K 13880 REV.

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EQUIPMENT		PAGE___ CG___ CODE_____ EST. WGT._____ LBS.	USE LBS.	N CODE	ACCT. LBS.
V922	31	RUN IN 10" (206 G) WATER INTO V922 & HEAT TO 190-195°F. CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR. MAINTAIN 190-195°F DURING S-31.			
V904	32	PUMP V922 THRU SPARKLER INTO V-904			
V922	32A	RUN 8" (165 GAL) WATER INTO V922 & HEAT TO 190-195°F CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR. MAINTAIN 190-195F THRU S-32A			
V904	32B	PUMP V-922 THRU SPARKLER INTO V-904			
		CONTINUE WITH S-33			

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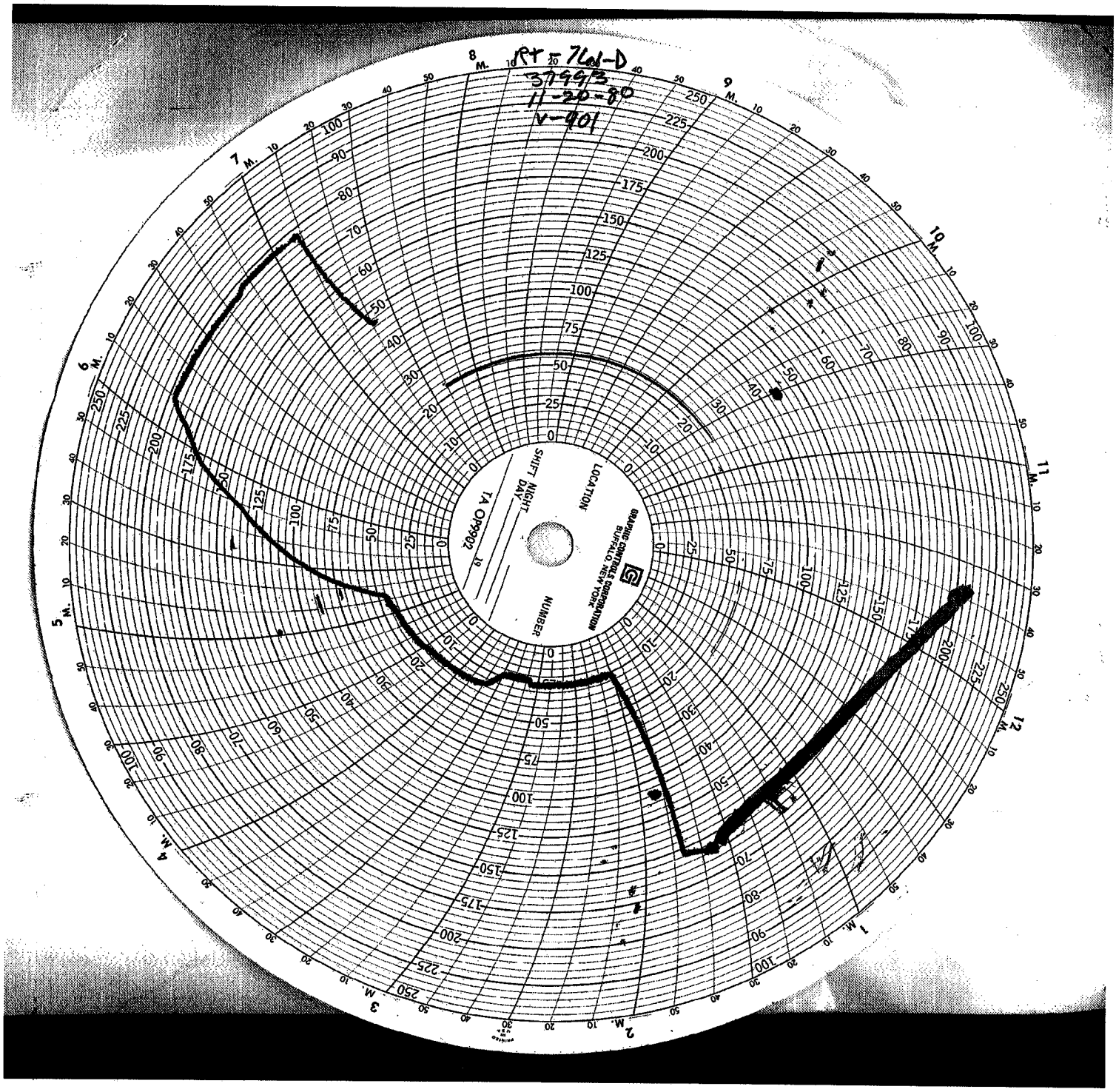

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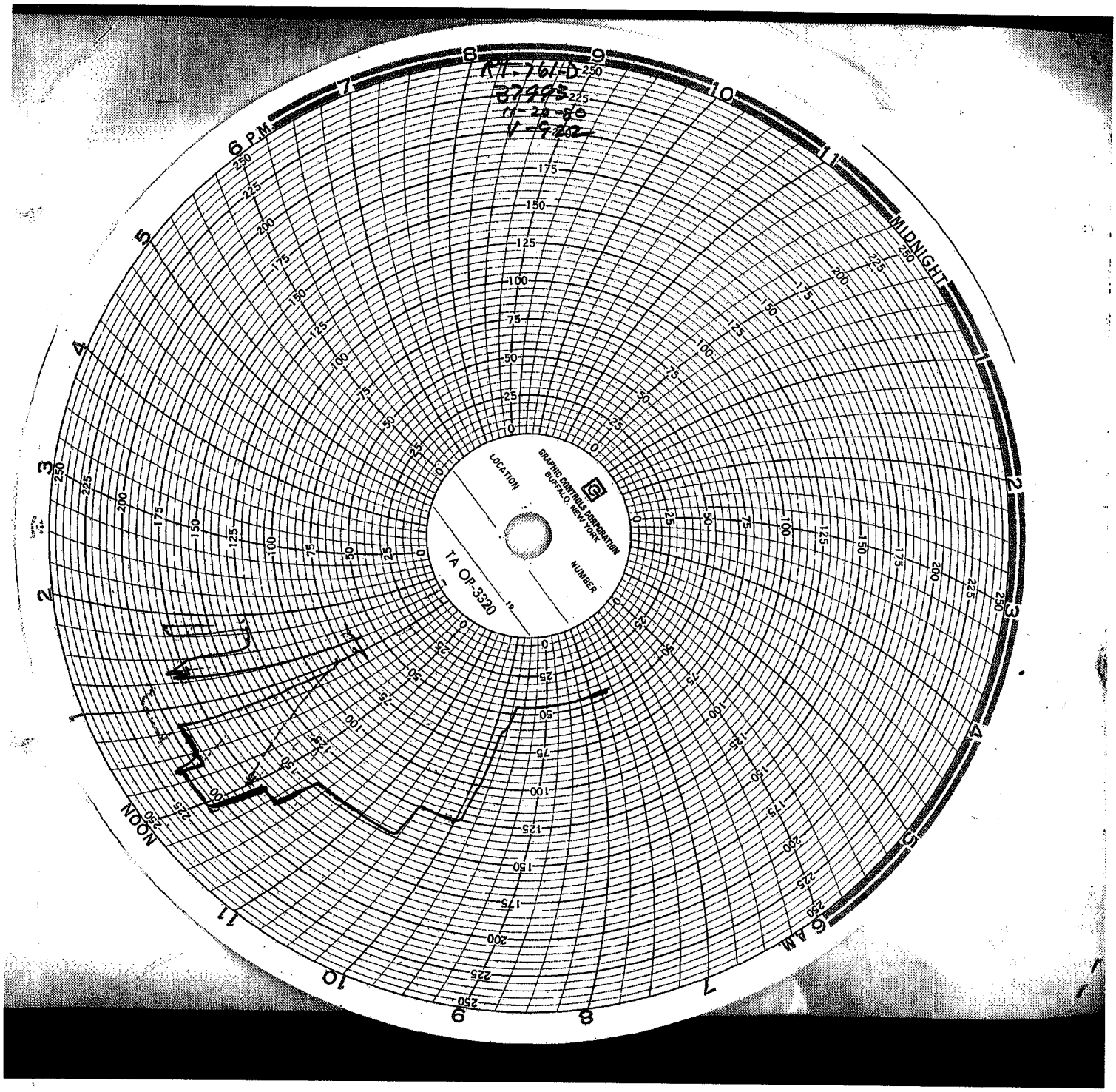

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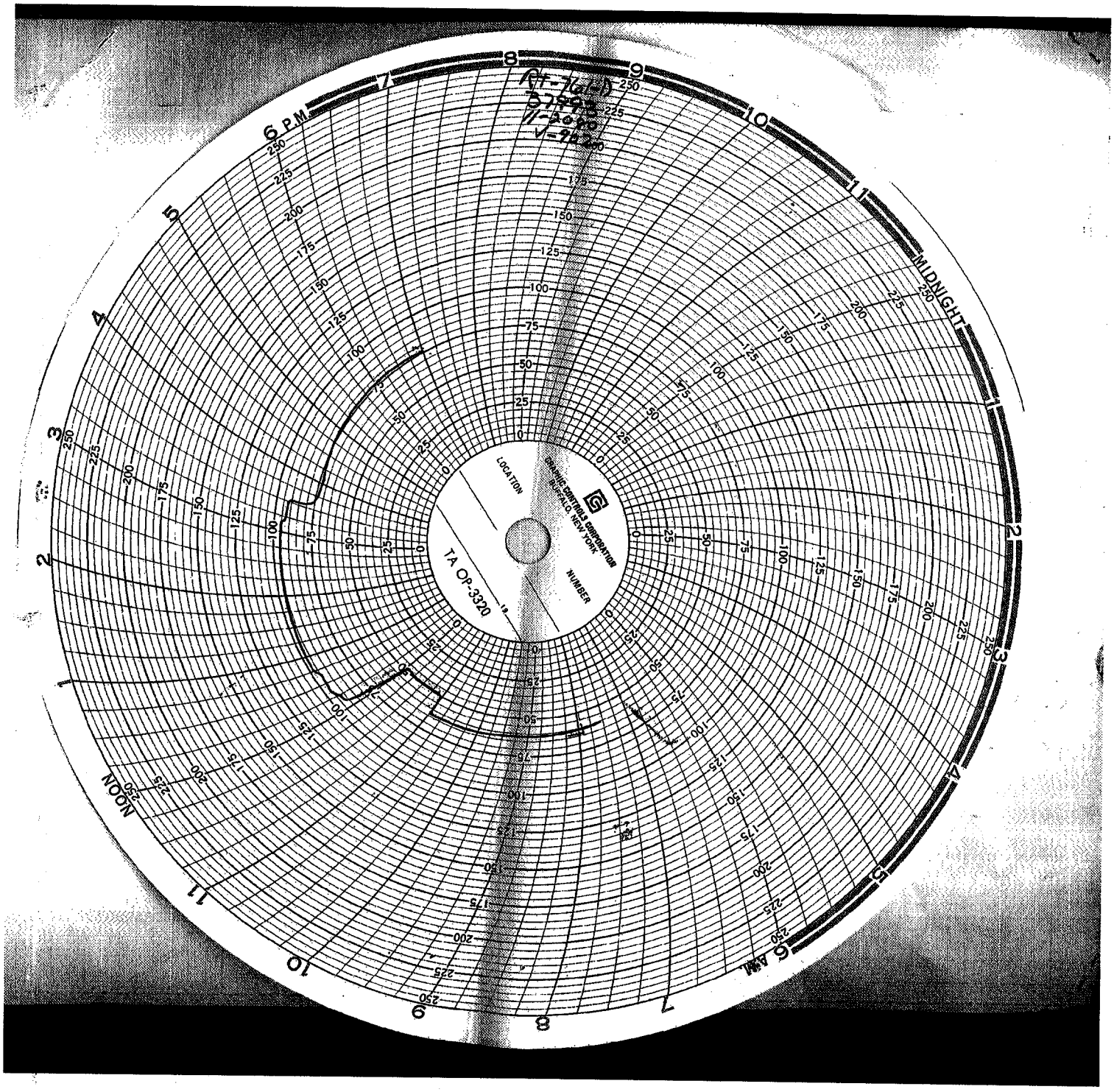

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