

S.V

C.V. 901 903

D.V. 902, 904

CG 32 CODE RT-428-D PKG.

→ NOV 25 80 38042

EST. WGT. 3066 LBS.

STD. HRS. TIME 11 AM

PROCESSES		APPROVED BY	
() RT-428-D	(V) JYG 07-10-78		
() RC-14-A	() DCG 08-10-78		
() RT-139-P	(O) MW 08-11-78		
()	()		
TYPED BY			
emw081878			

NON-BLEEDING

EQUIPMENT	NAME: WATCHUNG® RED B	USE LBS.	N CODE	ACCT. LBS.
	Note: Do not start if press will not be available within 3 hours after making. Making Supv to review with P.R. Supv & Record: Press will be ready M / P.R. Supv Start Making M / Making Supv			
Frep 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 40		82-C	
	4 Install DV & CV Recorder & Controller Charts			
921/922 2	5 Run 10" (100 G) water into V-921 & heat to 80-100°F 6 Add in 2-3 min 7 Stir 5 min & Record: pH 10.1 (9.5-10.5) 8 Stir 20 min or longer to dissolve for S 43	125	530-A	125
922 3	9 Run 35" (722 G) water into V-922 10 Weigh in V-926 & run in M 11 Turn on agitator & steam & dump in from S 2	216	740-C	216 1107
	Lot #100% 114 333 98.65 112 771 98.81	338 780		
	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 + (+) 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 21 Record: Start 740 Total Min 15 Clarity OK HT 195°F & Rec 195°F			
Misc 4	18 Measure 65 units in V-928 for S 33 M 11 .30.87 19 Weigh in PT for S 36 M 13 .33.47	1727 1052	28-D 725-A	533 352
924/925 5	20 Run 1" (6 G) water into V-901 Note: Use CV if MTY. If CV is not available use V-904 21 When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 745 Total Min 15			

EQUIPMENT		PAGE 2 CG 32 CODE RT-428-D (V) EST. WGT. 3066 LBS.	USE LBS.	N CODE	ACCT. LBS.
6 82	22	Run 56" (1618 G) water into V-902			
	23	Weight in 525 & dump in			525
	24	Dump in & stir to smooth slurry for S 41	525	542-A	525
922 7	25	When S 21 complete, stop pump & insert V-922 foot plug			
	26	Run in 12" (247 G) water & heat to 180-195°F, CIRCULATE 15 MIN			
		THRU SPARKLER- PUMP V-922 THRU SPARKLER INTO V-904/CV			
922/CV 8	27	Pump V-922 thru Sparkler into V-904/CV See Attached Page for S 27			
901	28	When MTY blow out Sparkler into V-904/CV			
	29	Pump in	60	979-D	60
	30	Heat to 165-170°F			
CV 9		NOTE: If N-740-C sol'n (S's 20 & 21) was pumped directly from Sparkler to CV, omit (S's 31 & 32)			
901	31	Run in 1" (96 G) water into V			
	32	Pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min). Maintain 165-170°F in CV			
	33	Run in N-28-D from S 18 in 12-15 min			
	34	Stir 15 min at 165-170°F			
	35	Adi to 43" (4080 G) at 32-38°F	50 x 330	57-A	16560
	36	Run in N-725-A from S 19 AFAP (5-10 min)			
	37	Stir 20 min at 32-38°F maintaining +CR, +KI	8 x 330	57	2640
		Record: Time Start 11:30 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 (+)			
	38	Dump in 5359-750 #	244	246-E	244
	39	Dump in 5363-750	470	65-A	470
	40	Dump in from S 3 & stir 10 min 5320 12 Lot		82-C	1012
901	41	Run in V-902 & stir 2-3 min	250	728-D	250
CV 11	42	Immediately after S 41 complete, pump V-902 thru undersurface distributor into CV in 18-20 min. Let CV temp rise freely			
		Record: Start 12:40 Total Min 7			
	43	Immediately after S 42 complete, steam eject V-921/931 into CV			
	44	Stir 10 min & Record: Diazo (-), Base + (+)			
		pH 9.8 (9.0-9.8), Temp 52°F (50-60°F)			
	45	If necessary, adi to pH 9.0-9.8 Assume 50%		7-D	
		& Record: pH Assume 32%		28-D	
	46	Weigh & pour in	25	588-A	25
	47	Heat to 193-195°F in 65-75 min & Record: HT 194°F & Rec 194°F			
	48	Stir 15 min at 193-195°F Record: Start 1:42			
	49	Record: pH 9.3 (8.8-9.3)			
	50	Flood to 180-190" (+18,000 G) & stop agitator			
	51	When instructed by Processing Area halfway thru pressing, dump in, stir 5 min, stop agitation, resume pressing	10	588-A	10
		(START 10:00 AM FIN 2:30 PM OPTR 120)			

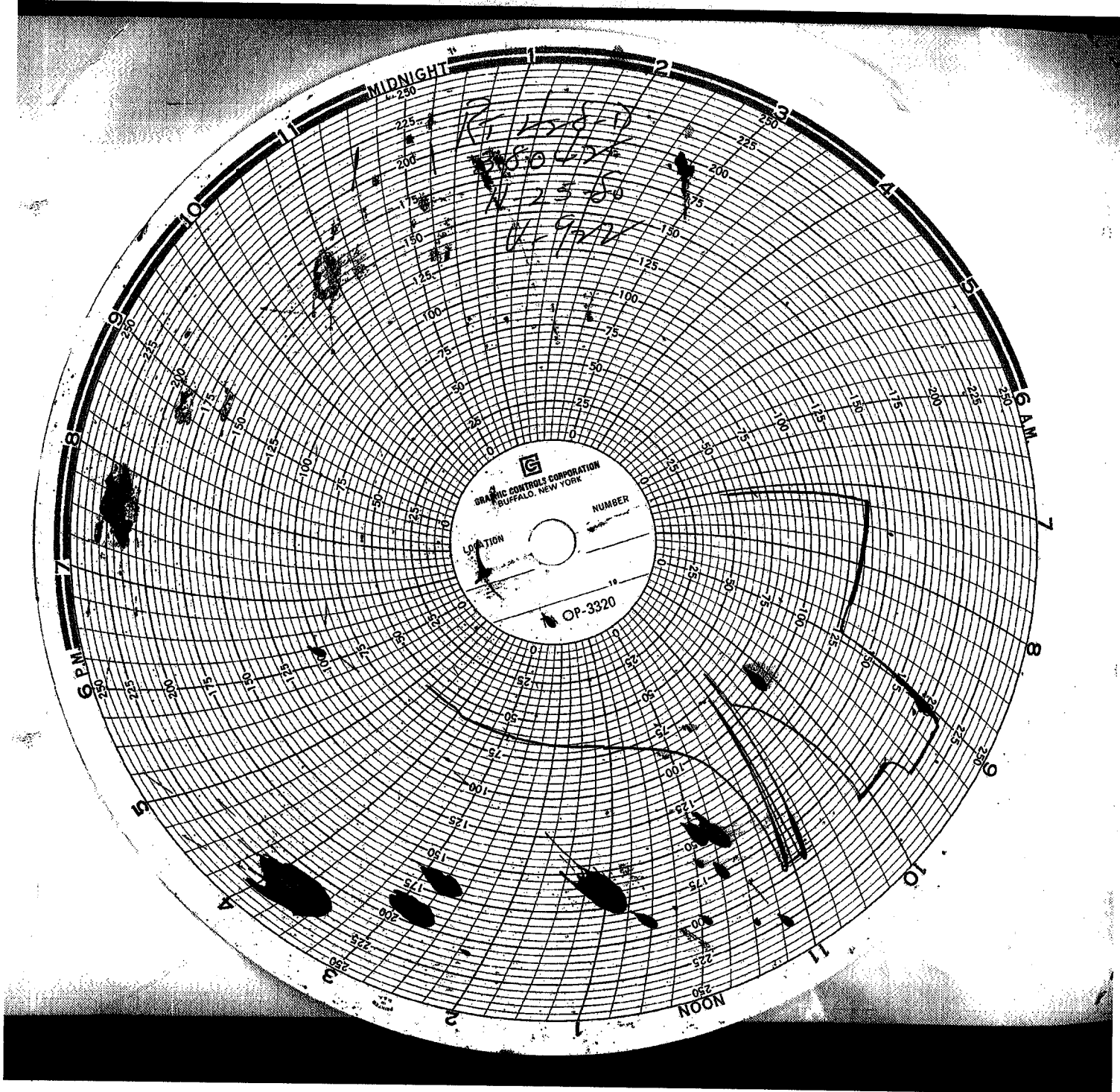
1922

~~27~~ RUN 8" (165 GAL) WATER INTO
V-922 & HEAT TO 190-195°F
CIRCULATE 15 MIN OR LONGER
THRU SPARKLER UNTIL SOLUTION
IS CLEAR. MAINTAIN 190-195°F
THRU S-~~27~~ 27

1904

~~27~~ PUMP V-922 THRU SPARKLER
INTO V-904

CONTINUE WITH S-28



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