

S.V.

C.V. 901, 903

D.V. 902, 904

DATE PRINTED: 7/19/82

CG 32 CODE RT-870-D PKG ---

PROCESSES APPROVED BY

JUL 23/1982

G2J51

2579*

() RT-870-D (H) EWK 1-11-82

(DATE)

(LOT)

(EST WGT)

COMTYP JOB NAME: 32RT870DMH

TYPED BY: JMH

STANDARD HRS.

TIME 7 A.M.

PREPARATION NOTES:

PRE COAT SPARKLER

NON-BLEEDING

EQUIP MENT	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. SUPV TO REVIEW WITH P.R. SUPV & RECORD: PRESS WILL BE READY M / PR SUPV. START MAKING M / MAKING SUPV. NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V-922 NOTE: RUN 15" WATER INTO V-904. PUMP WATER FROM V-904 THRU DISTRIBUTOR. IF WATER DOES NOT COME OUT OF ALL DISTRIBUTOR HOLES WITH FULL FORCE, NOTIFY SUPERVISOR.			
PREP 1	RECORD: 0 BATCHES SINCE SPARKLER LAST CLEANED. AFTER 4 BATCHES, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15% DICALITE, FILTER AID.	2 15 28	979 777-A 117 740-C 82-C	2 15 12
	2 OBTAIN FOR S11 2-CHLORO-4-AMINOTOLUENE-5-SULFONIC ACID.			
	3 OBTAIN FOR S27 3-HYDROXY-2-NAPHTHOIC ACID			
	4 INSTALL DV & DV RECORDER & CONTROLLER CHART			
921/ 931 2	5 RUN 11" (100G) WATER INTO V-921 & ADJ TO 80-100 DEG F			
	6 ADD IN 2-3 MIN DRESINATE X	108	530-A	108
	7 STIR 5 MIN & RECORD PH 10.1 (9.5-10.5)			
	8 STIR 20 MIN OR LONGER TO DISSOLVE FOR S49			
922 3	9 RUN 35" (722G) WATER INTO V-922			
	10 WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M 10 49.55 %	428	7-D 740-C	212 1086
	11 TURN ON AGITATOR & STEAM & DUMP IN FROM S2			
	2-CHLORO- LOT #100%			
	4-AMINOTOLUENE 284 98.57	120		
	5-SULFONIC 281 96.8 99.30	975		
	ACID			
	12 DUMP IN ACTIVATED CARBON	25	113-B	25
	13 DUMP IN FILTER AID	10	777-A	10
	14 HEAT TO 212-214 DEG F WATCH FOAM!!			
	15 RECORD: BY (+) IF NECESSARY ADJ TO +BY SODIUM HYDROXIDE ASSUME 50%		7-D	
	16 STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM! NOTE: RECORD SPARKLER PRESSURE 10 PSI. IF NOT ZERO NOTIFY SUPERVISOR.			

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EQUIP MENT		PAGE 2 OF 4 CG 32 CODE RT-870-D (H)	USE LBS	N-CODE	ACCT LBS
922	✓	CIRCULATE 15 MIN OR LONGER THRU SPARKLER			
3	✓	UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195			
CONT		DEG F FOR S22 RECORD: START <u>11:30 PM</u>			
		TOTAL MIN <u>25</u> CLARITY <u>0.5</u>			
		HT <u>194</u> F & REC <u>194</u> F			
MISC	118	MEASURE <u>904</u> UNITS IN V-928 FOR S39			
4	✓	HYDROCHLORIC ACID M <u>1</u> <u>29.89</u> %	<u>1465</u>	28-D	438
	119	WEIGH SODIUM NITRITE IN PT FOR S42			
		M <u>9</u> <u>33.36</u> %	<u>1190</u>	725-A	397
	120	WEIGH SODIUM NITRITE IN DRUM FOR S50			
		M <u>9</u> <u>33.36</u> %	<u>129</u>	725-A	43
904/CV	121	RUN 2" (58G) WATER INTO V-904/CV			
5	✓	WHEN S17 IS COMPLETE, PUMP IN V-922 THRU			
		SPARKLER, MAINTAIN V-922 AT 190-195 DEG F.			
		RECORD: START <u>11:55 PM</u> TOTAL MIN <u>60</u>			
922	✓	WHEN S22 COMPLETE, SHUT OFF PUMP AND INSERT			
6		V-922 FOOT PLUG			
	✓	124A RUN IN 10" (209G) WATER & HEAT TO 190-195 F			
		CIRCULATE 15 MIN THRU SPARKLER			
904/CV	124B	AND PUMP V-922 THRU SPARKLER INTO V-904/CV			
7					
902	125	RUN 65" (1696G) WATER INTO V-902			
8	✓	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN			
		M <u>10</u> <u>49.55</u> %	<u>805</u>	7-D	399
	127	DUMP IN FROM S3			
		LOT <u>7669</u>	<u>994</u>	82-C	994
		3-HYDROXY-			
		2-NAPHTHOIC ACID			
	128A	ADJ TO 70-90 DEG F & STIR TO DISSOLVE			
922	✓	128B RUN IN 5" (104G) WATER & HEAT TO 190-195 F			
9		CIRCULATE 15 MIN THRU SPARKLER			
904/CV	129	PUMP V-922 THRU SPARKLER INTO V-904/CV			
10	✓	WHEN MTY BLOW OUT SPARKLER INTO V-904/CV			
	✓	131 DISSOLVE ALKANOL XC IN 20G WATER AT 150-160			
		F FROM HOT WATER MIXER IN DRUM & POUR IN.	32	133-B	32
	✓	132 HEAT TO 165-170 F FOR S38			
932	✓	133 RUN 16" (328G) WATER INTO V-932 & ADJ TO			
11		80-100 DEG F			
	✓	134 ADD IN 6-7 MIN DRESINATE X	378	530-A	378
	✓	135 STIR 5 MIN & RECORD PH <u>10.3</u> (9.5-10.5)			
	✓	136 STIR 20 MIN OR LONGER TO DISSOLVE FOR S59			

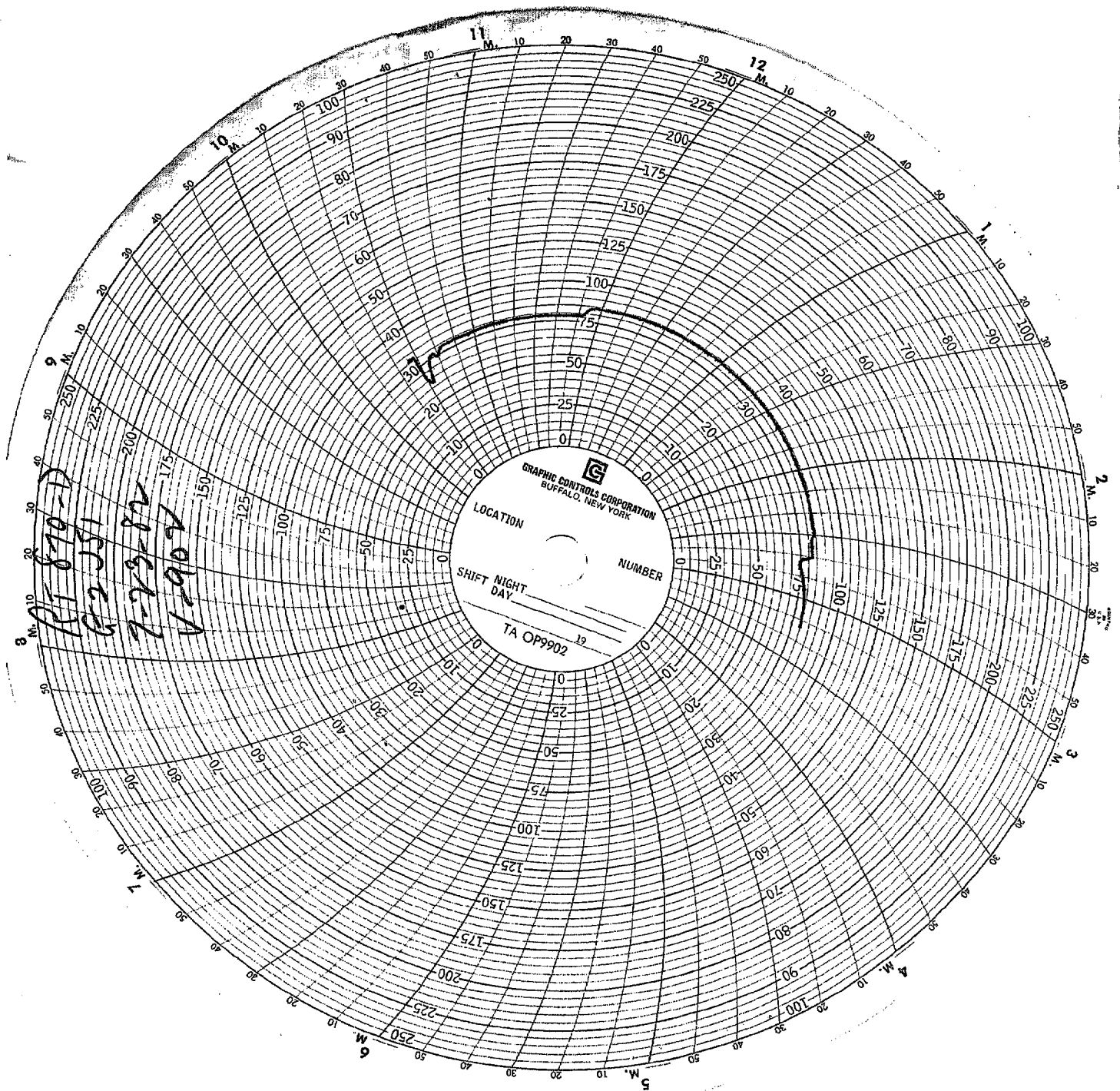
EQUIP MENT		PAGE 3 OF 4 CG 32 CODE RT-870-D (H)	USE LBS	N-CODE	ACCT LBS
CV 12	✓37	NOTE: IF N-740-C SOL. WAS PUMPED DIRECTLY FROM SPARKLER TO CV S21, 24B, 29 OMIT S37 & 38			
	✓38	RUN 1" (95G) WATER INTO V-			
	✓39	PUMP V-904 AT 165-170 DEG F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (2-15 MIN)			
	✓40	RUN IN N-28-D HYDROCHLORIC ACID FROM S18 IN 12-15 MIN. MAINTAIN 165-170°F IN CV.			
	✓41	STIR 15 MIN AT 165-170 DEG F			
	✓42	ADJ TO 46" (4347G) AT 32-38 DEG F	60	57-A	19800
	✓43	RECORD: TEMP 30 DEG F, VOLUME 46			
	✓44	RUN IN N-725-A SODIUM NITRITE FROM S19 AFAP (5-10 MIN) & RINSE IN PT			
	✓45	NOTE: PROCESS HAS A VERY LOW N-28-D EXCESS CHECK CR VERY CAREFULLY			
	✓46	STIR 20 MIN AT 32-38 DEG F MAINTAINING +CR, +KI FOR S44. RECORD: TIME START 3:30		57-A	
	✓47	CR +, KI + NOTE:			
	✓48	1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS			
	✓49	RECORD CR (+) KI (+)			
	✓50	HYDROCHLORIC ACID ASSUME 32%		28-D	
	✓51	2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS			
	✓52	RECORD CR (+) KI (+)			
	✓53	SODIUM NITRITE ASSUME 33%		725-A	
	✓54	DUMP IN CALCIUM CHLORIDE	1026	20-A	1026
	✓55	ADD FOR MAINTAINING 32-38 DEG F THRU S55	40	57-A	13200
PT 13	✓56	FILL PT APPROXIMATELY 1/2 FULL WITH 90-110°F WATER FROM HOT WATER MIXER			
DRUM	✓57	DUMP IN STRONTIUM NITRATE	68	246-B,E	68
	✓58	STIR 30 MIN OR LONGER WITH LIGHTNIN MIXER TO SOLUTION FOR S58			
902 14	✓59	WHEN S28A COMPLETE, STEAM EJECT V-921/931 FROM S8 INTO V-902			
	✓60	POUR IN N-725-A SODIUM NITRITE FROM S20			
	✓61	ADD AMMONIUM CHLORIDE	213	165-A	213
CV 15	✓62	IMMEDIATELY COUPLE V-902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN. RECORD: START 5:10 AM TOTAL MIN 25			
PT 16	✓63	DURING S52 WEIGH SODIUM HYDROXIDE IN PT			
	✓64	M 70 49.55% 783		7-D	140
	✓65	DILUTE TO MAXIMUM VOLUME (+/-100G) FOR S56			
CV 17	✓66	WHEN S52 COMPLETE, STIR 30 MIN & RECORD:			
	✓67	DIAZO 7 (+) BASE 7 (+)			
	✓68	PH 5.5 (5.0-6.0) TEMP 38 (32-38 F)			
	✓69	RUN SODIUM HYDROXIDE IN PT FROM S54 THRU UNDERSURFACE LINE, RINSE IN PT & STIR 15 MIN			
	✓70	RECORD: DIAZO - (-) BASE + (+)			
	✓71	PH 9.8 (9.0-9.8)			
	✓72	RUN IN STRONTIUM NITRATE N-246-B,E SOL'N FROM S48 & RINSE IN PT			
	✓73	STEAM EJECT IN V-932 FROM S36			
	✓74	STIR 5 MIN & RECORD: PH 9.6 (9.0-9.8)			

EQUIP MENT		PAGE 4 OF 4 CG 32 CODE RT-B70-D (H)	USE LBS	N-CODE	ACCT LBS
17	161	IF PH BELOW 9.0 ADJ TO PH 9.0-9.8 WITH			
CONT		N-7-D ONLY. RECORD PH _____			
		SODIUM HYDROXIDE ASSUME 50%		7-D	
	162	POUR IN 1 OCTANOL	38	588-A	38
	163	HEAT TO 193-195 DEG F IN 70-75 MIN & RECORD			
		HT <u>194</u> DEG F AND REC <u>195</u> DEG F			
	164	STIR 60 MIN AT 193-195 DEG F.			
		RECORD: START <u>8:00 AM</u>			
	165	AFTER 20 MIN S64 STIR RECORD:			
		PH <u>9.3</u> (8.8-9.3)			
		IF PH BELOW 8.8, ADJ TO PH 8.8-9.3 WITH			
		N-7-D ONLY. RECORD PH _____ ASSUME 50%		7-D	
	166	AFTER S64 STIR, FLOOD TO 180-190°			
		(+/-18,000G) AND STOP AGITATOR			

WHEN INSTRUCTED BY PROCESSING AREA HALFWAY
THRU PRESSING, DUMP IN, STIR 5 MIN & STOP
AGITATOR. RESUME PRESSING.

10 588-A 10

8:30 PM START 11:15 PM FIN 12:00 OPTR
11:15 PM 7:00 AM 7:23
7:00 AM 7:23 AM 320



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