

S.V.

C.V. 901 903

D.V. 904

MARKING INSTRUCTIONS: BATCH UNIT

CG 32 CODE RT-618-D PKG. _____

→ OCT - 6 1980 37362
EST. WGT. 2902 LBS.

STD. HRS. 10.4 TIME 11:00 M

PROCESSES		APPROVED BY	
()	RT-618-D (S)	JJG	08-15-78
()	RT-657-P (H)	AMJ	09-19-78
()	()		
()	()		
TYPED BY			
EMW092078			

NOTE - N740C, N7-D, N113-B, N772A LOST
WHE BACK PRESSURE FROM SPARKLER
BLEW OUT SOLUTION FROM V922.

NON-BLEEDING

EQUIPMENT	NAME: WATCHUNG® RED Y	USE LBS.	N CODE	ACCT. LBS.
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 24		253-C	
	4 Install DV & CV Recorder & Controller charts			
922/931 2	5 Run 10" (100 G) water into V-931 & adj to 80-100°F			
	6 Add in 1-2 min	63	530-A	63
	7 Stir 2 min & Record: pH 10.0 (9.5-10.5)			
	8 Stir 20 min or longer for S 27			
922 3	9 Run 34" (700 G) water into V-922		7-D	6.7
	10 Weigh in V-926 & run in M 11, 49.64 %	4.5	7-D	201
	11 Turn on agitator & steam & dump in from S 2		740-C	1035
	Lot 100% %		740C	346
	103 1035 98.35 1052			
	12 Dump in	17	113-B	17
	13 Dump in	50	113-B	50
	14 Heat to 212-214°F. Record: HT 2nd OF; 214 OF WATCH FOAM	10	777-A	10
	15 Record: BY (+), if necessary, adj to +BY Assume 50%	3	777A	3
	16 Stir 30 min at 212-214°F, then shut off steam WATCH FOAM		7-D	
	17 Circulate 15 min or longer thru Sparkler until sol'n is clear			
	Maintain at 190-195°F for S 19 & Record: HT 190 OF			
	& Recorder 195 OF			
	Record: Start 5:40 PM Total Min 1.5 Clarity ok			
	NOTE: Sample from hose - show to Supervisor for OK			
904 4	18 Run 1" (50 G) water into V-904			
	19 When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 5:58 PM Total Min 3.5			
Misc 5	20 Weigh in PT for S 35 M 11, 33.21 %	1000	725-A	332
	21 Measure 8514 units in V-928 for S 33 M 7, 31.62 %	1250	28-D	419
CV 6	22 Run 16" (1530 G) water into V-901			
	23 Weigh in V-926 & run in M 11, 49.64 %	1000	7-D	507
	24 Dump in from S 3 Lot	494	253-C	507
		912		912
	25 Weigh on postal scale & dump in Lot			
	26 Adjust to 70-90°F & stir to dissolve			
	27 Steam eject V-921/931 into CV			

EQUIPMENT	PAGE	CG	32	CODE	RT-618-D (S)	EST. WGT.	2902	LBS.	USE	N	ACCT.
									LBS.	CODE	LBS.
922	26				When S 19 complete, shut off pump & insert V-922 foot plug						
7	25				Run in 12" (247 G) water & heat to 180-190°F						
904	20				Pump V-922 thru Sparkler into V-904						
8	21				When MTY blow out Sparkler into V-904						
	22				Heat to 165-170°F (Sample & show to Supervisor for OK ✓)						
	23				Run in N-28-D from S 21 in 12-15 min & stir 5 min at 165-170°F						
	24				Adj to 129" (3409 G) at 28-30°F & Record: Temp 30 °F			42 x 330		57-A	1386
	25				Run in N-725-A from S 20 AFAP (5-10 min)						
	26				Stir 30 min at 28-35°F maintain +CR, +KI for S 41						
					Record: Time Start 6:25 AM, 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 (+) Temp °F						
CV	27				Dump into CV			180		65-A	180
9	28				Adj to 37" (3496 G) at 28-32°F			34 x 330		57-A	11220
					Record: Temp 30 °F Volume 37 "						
	29				Weigh in from drum			239		165-A	239
	30				Stir 2-3 min						
	31				Immediately couple DV thru undersurface distributor into CV in						
					45-60 min. Maintain CV at 28-32°F					57-A	
					Record: Start 7:15 PM Total Min 45-						
	32				Stir 30 min & Record: Base + (+), Diazo - (-),						
					Final Temp 35 °F, pH 8.9 (9.0-9.8)						
	33				If necessary, adj to pH 9.0-9.8			Assume 50%	20	7-D	10
					& Record: pH 9.4			Assume 32%		28-D	
	34				Heat to 184-186°F in 65-70 min &						
					Record: HT 184 °F & Recorder 184 °F						
DV	35				Run 24" (600 G) water into DV						
10	36				Turn on agitator & steam & dump in			1620		16-B	1620
	37				Heat to 155-160°F & stir to dissolve						
CV	38				When S 44 complete, immediately strike DV thru undersurface						
11					distributor into CV in 7-10 min. Maintain CV at 184-186°F						
					Record: Start 9:45 PM Total Min 15-						
	39				Heat CV to 198-202°F in 10-12 min						
	40				Stir 5 min at 198-202°F						
	41				Heat to 180-190" (±18,000 G)						
	42				Record: pH 9.0 (9.0-9.4) & stop agitator						
					Open Cap on Distributor						
					START FIN OPTR						
					7:00 AM 3:00 PM 3:01						
					3:00 PM 10:45 PM 237						
					When instructed by Processing Area half way thru pressing,						
					dump in & stir 5 min & stop agitator. Resume pressing			10		588-A	10







