

V.

C.V. 901 903

D.V. 902, 904

CP 32 CODE RT-870-D PKG. _____

DEC - 3 00 38162

EST. WGT. 1726 LBS.

STD. HRS. _____ TIME _____ M

PROCESSES		APPROVED BY	
()	RT-870-D (E)	JJG	06-21-77
()	()	DCG	06-23-77
()	()	MTW	06-24-77
()	()		
TYPED BY			
emw062977			

CLEAN UP
AS YOU GO ALONG

LEAVE ONE STUMP ONLY

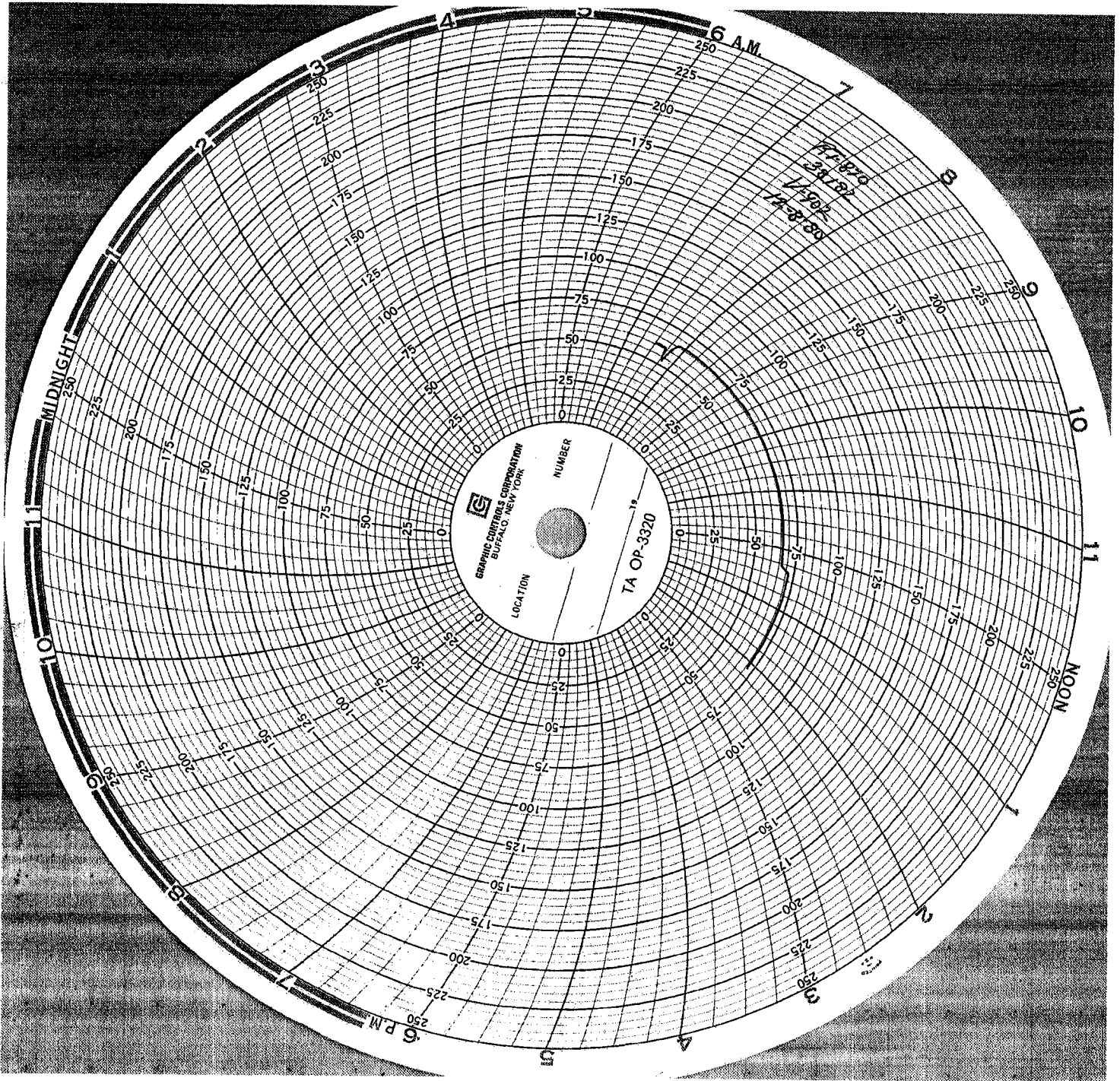
NON-BLEEDING

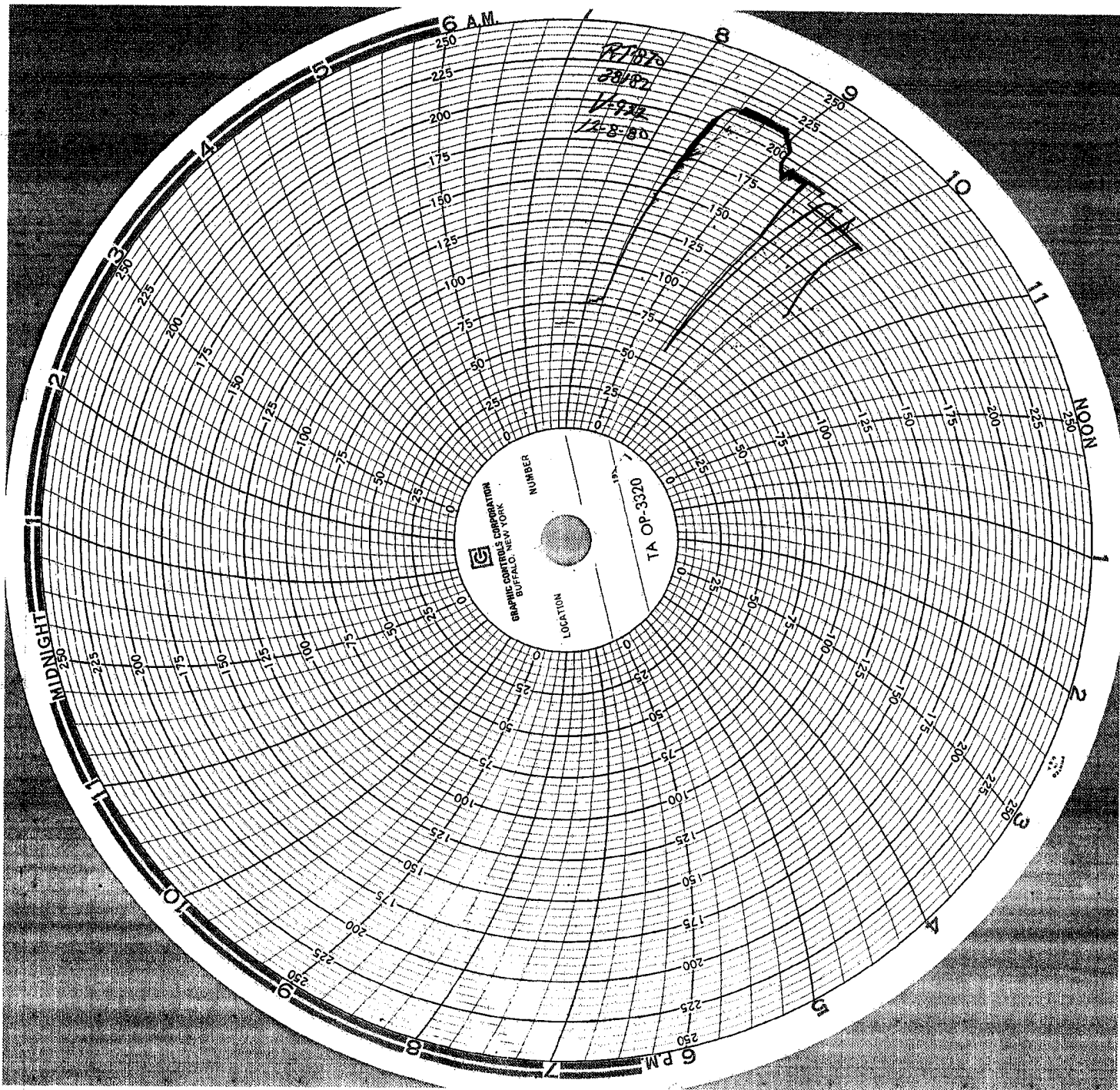
SHIPMENT	NAME: WATCHUNG® RED B	USE LBS.	N CODE	ACCT LBS.
	NOTE: Do not start if press will not be available within 3 hrs after making. Supv to review with P.R. Supv & Record:			
	A. Press will be ready M / P.R. Supv			
	B. Start Making M / Making Supv			
Prep 1	1. If necessary, clean, dress Sparkler & pre-coat with 15#		777-A	
	2. Obtain for S 11		740-C	
	3. Obtain for S 25		82-C	
	4. Install DV & CV Recorder & Controller Charts			
921-922 2	5. Run 10" (100 G) water into V- 921 & adj to 80-100°F			
	6. Add in 2-3 min	75	530-A	75
	7. Stir 5 min & Record: pH 10.0 (9.5-10.5)			
	8. Stir 20 min or longer to dissolve for S 49			
922 3	9. Run 24" (50.2G) water into V-922			
	10. Weigh in V-926 & run in M 13 . 48.77%	308	7-D	150
	11. Turn on agitator & steam & dump in from S 2	776	740-C	766
	Lot #100% %			
	109 766 98.67			
	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 7 (+), 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 22			
	Record: Start 900A Total Min 15 Clarity OK			
	HT 195°F & Rec 200°F			
disc 4	18. Measure 80% units in V-928 For S 39 M 12 . 30.56%	1211	28-D	370
	19. Weigh in PT for S 42 M 13 . 33.47%	837	725-A	280
	20. Weigh in drum for S 50 M 13 . 33.47%	90	725-A	30
CV 5	21. Run 2" (58 G) water into V- 901			
	22. When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 9:50A Total Min 15			

N35076

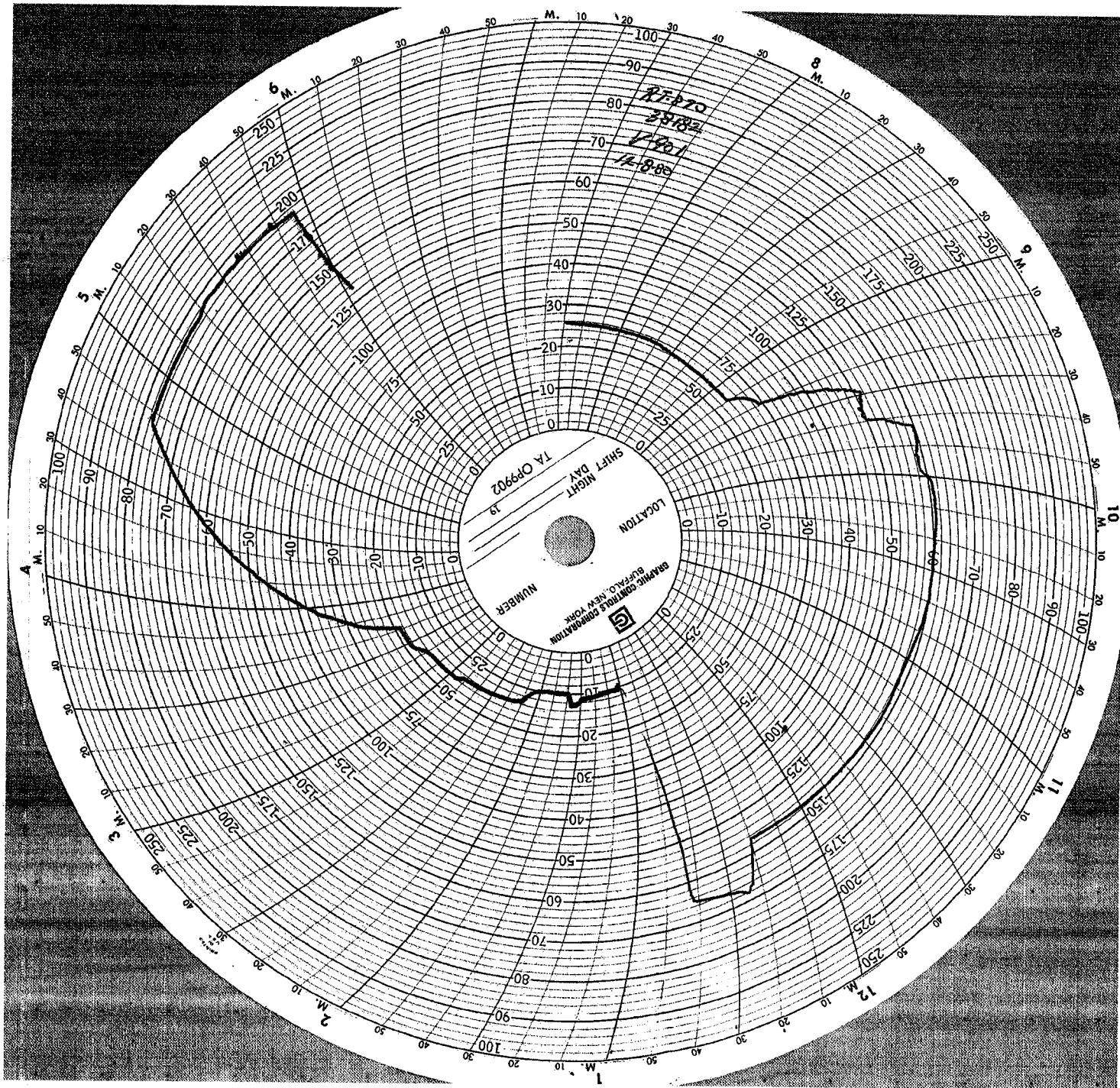
DUP050107529

EQUIPMENT	PAGE 3 CG 32 CODE RT-870-D (E) EST. WGT. 2530 LBS.	USE LBS.	N CODE	AC LI
CV 15	55 When S 52 complete, stir 30 min & Record: Diazo + (+), Base + (+), pH 5.6 (5.0-6.0), Temp 36 °F (32-38°F)			
	56 Run in PT from S 54 thru undersurface line & stir 15 min			
	57 Record: Diazo - (-), Base + (+), pH 9.7 (9.0-9.8)			
	58 Run in N-246-E sol'n from S 48			
	59 Steam eject in V-932 from S 36			
	60 Stir 5 min & Record: pH 9.7 (9.0-9.8)			
	61 If pH below 9.0 adj to pH 9.0-9.8 with N-7-D only Assume 50% & Record: pH		7-D	
	62 Pour in	28	588-A	2
	63 Heat to 193-195°F in 70-75 min & Record: HT 193°F & Rec 195°F			
	64 Stir 60 min at 193-195°F Record: Start 450 P			
	65 After 20 min S 64 stir, Record: pH 9.0 (8.8-9.3) & if below pH 8.8, adj to pH 8.8-9.3 with N-7-D only Assume 50% Record: pH		7-D	
	66 After S 64 stir, flood to 180-190" (±18000 G) & stop agitator			
	START FIN OPTR			
	700 A 600 P 209			
	When instructed by Processing Area half way thru pressing, dump in, stir 5 min & stop agitator. Resume pressing.	10	588-A	1





DUP050107532



DUP050107533

MD-3-A

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE AT-70 LOT 38182

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PQ
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	<u>14</u>	<u>1921</u>	<u>4</u>	
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TOTAL NET WT. 1921 PKG. N-CODE 1923

PROD. SPVR. C/O DATE 12/10/1 WHSE. OPER. 272

D.T

145.+
135.+
135.+
133.+
142.+
150.+
142.+
134.+
141.+
144.+
131.+
134.+
126.+
129.+
1921.T

37
901

CG 32 CODE RT-870-D PKG. _____

→ DEC -8 00 38182

EST. WGT. 1926 ~~2030~~ LBS. *992*

INSTRUCT MAKING AREA TO ADD 10#
N-588-A HALFWAY THRU PRESSING

PROCESSING INSTRUCTIONS: BATCH UNIT

PROCESSES RT-870-D (E)	APPROVED BY JJG 06-21-77 DCG 06-23-77
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TYPED BY
emw063077

MAKING NOTES

REMARKS

NAME: WATCHUNG® RED B

NON-BLEEDING

INSTRUCTIONS

- PRESSING -

RECORD

VAT		201			PRESSLOAD	1ST	2ND	3RD	4TH	5TH
DATE		12-8			STARTED	8:00 PM				
TIME		6:00 P			CAKES USED	60				
RELEASED BY					WATER ON	3500				
PRESS	95			37	HRS. WASHED	5				
NO. OF CAKES	74			60	OHMS	3550				
PRESS	Without	AGITATION			HRS. WASHED					
WASH TO	3000	OHMS with 35-75°F water			OHMS					
TEST AFTER	4	HOURS			HRS. WASHED					
LOAD	on 10 cars				OHMS					
PRESS IMMEDIATELY	CODE				CAKE CONDITION					
CLEAN MAGNETIC SEPARATOR AFTER PRESSING					NO. CARS LOADED	574				
CLEANED BY: 99	TIME CLEANED: 1:30 PM				EXPLAIN LOSSES					

SAMPLES
DELIVER TO

SAMPLED BY

RELEASED BY

- DRYING -

Dry 12 hours at 220°F
Then Dry 12 hours at 200°F
Cool to 130°F

LUMP: - OK - WET - SALTS - CONTAMINATED

ADDITIONAL DRYING HOURS REQUIRED

SAMPLES
DELIVER TO

NO. CARS PULLED
SAMPLED BY

No. Drums: 12
LUMP WGT. 1923
RELEASED BY

- GRINDING -

MILL #2 HSP 1/8" RP SCREEN 3350 RPM
MAX. TEMP. 150°F

SCREEN RPM
MAX. TEMP. °F

EXPLAIN LOSSES

SAMPLE WITHOUT MIXING
SAMPLES 2 ENV
DELIVER TO C T L

DATE MIXED
SAMPLED BY

RELEASED BY

RT 870
LN 38182

0.00

195.00

14.00

193.00

14.00

194.00

14.00

194.00

14.00

193.00

14.00

187.00

14.00

186.00

14.00

193.00

14.00

195.00

14.00

166.00

14.00

24.00

14.00

818.00

NET BROS BEAT
IN DRYER

38182

18.18

1.19

0.14

19.23