

CG 32 CODE RT-698-D PKG.

→ MAY-0-81 E 1176

EST. WGT. 2755 LBS.

STD. HRS. TIME M

PROCESSES

() RT-698-D	()	JYG 06-01-77
()	()	DCG 06-02-77
()	()	MTW 06-06-77
()	()	
TYPED BY		
emw061677		

APPROVED BY

RUN 15" WATER INTO V-904. PUMP WATER FROM
V-904 THRU DISTRIBUTOR. IF WATER DOES
NOT COME OUT OF ALL DISTRIBUTOR HOSES
WITH FULL FORCE, NOTIFY SUPERVISOR

NON-BLEEDING

EQUIPMENT	NAME: WATCHUNG® RED B	USE LBS.	N CODE	ACCT. LBS.
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 41		82-C	
	4 Install DV & CV Recorder & Controller Charts			
932 2	5 Run 20" (415 G) water into V-932 & heat to 80-100°F		89A	400
	6 Add in 8-9 min	400	89A	400
	7 Stir 5 min & Record: pH 9.8 (9.5-10.5)			
	8 Stir 20 min or longer to dissolve for S 49			
	Notify Press Room Before roping off area under V 932			
922 3	9 Run 32" (661 G) water into V-922			
	10 Weigh in V-926 & run in M 8 , 49.83%	442	7-D	220
	11 Turn on agitator & steam & dump in from S 2		740-C	1127
	Lot #100%	%		
	179 1127 99.9 1128			
	12 Dump in	25	113-A	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 10 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 19			
	Record: Start 8.4050 Total Min 00 Clarity			
	HT 194 °F & Rec 195°F			
904 4	18 Run 2" (58 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 9.00 Total Min 35			
902 5	20 Run 56" (1566 G) water into V-902			
	21 Dump in & stir to smooth slurry for S 43	533	542A	533
Misc 6	22 Measure 99 Units in V-928 for S 35 M 2 32.0 %	1677	28-D	543
	23 Weigh in PT for S 38 M 7 , 32.9%	1231	725-A	402
	24 Weigh in drum for S 44 M , %	71	725-A	30
922 7	25 When S 19 complete, stop pump & insert V-922 foot plug			
	26 Run in 15" (349 G) water & heat to 190-195°F - CIRCULATE 15 MIN THRU SPARKLER - PUMP V 922 THRU SPARKLER INTO V 904			

MAY 20 1981

DATE PRINTED: 4/13/81 ¹⁷

S.V.

APR 30 1981

C.V. 901 903

D.V. 902,904

CG 32 CODE RT-698-D PKG ---

MAY -0-81- 31176

PROCESSES

APPROVED BY

() RT-698-D (I)

() ALTERNATE ()

(DATE)

(LOT NUMBER)

() ()

TYPED BY: JMH

ESTIMATED WGT 2449 LBS.

STANDARD HRS. _____

TIME _____ M

PREPARATION NOTES: _____

EQUIP MENT		NAME: WATCHUNG RED B	USE LBS	N-CODE	ACCT LBS
PREP	1	IF NECESSARY, CLEAN, DRESS SPARKLER & PRE-			
	1	COAT WITH 15#		777-A	
	2	OBTAIN FOR S11		740-C	
	3	OBTAIN FOR S36		82-C	
	4	INSTALL DV & CV RECORDER & CONTROLLER CHART			
		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			
932	5	RUN 19" (391G) WATER INTO V-932 & HEAT TO			
	2	130-140 DEG F			
	6	ADD IN 8-9 MIN	420	99-A	420
	7	STIR 5 MIN & RECORD: PH _____ (9.5-10.5)			
	8	STIR 20 MIN OR LONGER TO DISSOLVE FOR S39			
		NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF			
		AREA AROUND V-922			
922	9	RUN 35" (708G) WATER INTO V-922			
	3	WEIGH IN V-926 & RUN IN M _____ %		7-D	196
	10	TURN ON AGITATOR & STEAM & DUMP IN FROM S2		740-C	1006
	11	LOT #100% %			

	12	DUMP IN	25	113-A	25
	13	DUMP IN	10	777-A	10
	14	HEAT TO 212-214 DEG F WATCH FOAM!!!!			
	15	RECORD: BY _____ (+) IF NECESSARY ADJ TO			
		+BY ASSUME 50%		7-D	
	16	STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF			
		STEAM. WATCH FOAM. RECORD: SPARKLER PRES-			
		SURE _____ PSI IF NOT ZERO NOTIFY SUPVR.			
	17	CIRCULATE 15 MIN OR LONGER THRU SPARKLER			
		UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 F			
		FOR S21. RECORD: START _____ TOTAL MIN _____			
		CLARITY _____, HT _____ F & REC _____ F			

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EQUIP MENT		PAGE 2 OF 3 CG 32 CODE RT-698-D (I)	USE LBS	N-CODE	ACCT. LBS
CV 4	18 19	RUN 6" (569G) WATER INTO V- MEASURE _____ UNITS IN V-928 FOR S31A M _____ %		28-D	485
904 5	20 21	RUN 2" (58G) WATER INTO V-904 WHEN S17 COMPLETE, PUMP IN V-922 THRU SPARKLER. MAINTAIN V-922 AT 190-195 DEG F RECORD: START _____ TOTAL MIN _____			
902 6	22 23	RUN 56" (1566G) WATER INTO V-902 DUMP IN & STIR TO SMOOTH SLURRY FOR S37	476	542-A	476
MISC 7	24	WEIGH IN PT FOR S33 M _____ %		725-A	328
922 8	25 26A	WHEN S21 COMPLETE, STOP PUMP & INSERT V-922 FOOT PLUG RUN IN 10" (200G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904 9	26B	PUMP V-922 THRU SPARKLER INTO V-904			
922 10	27A	RUN IN 5" (100G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904 11	27B 28 29 30	PUMP V-922 THRU SPARKLER INTO V-904 WHEN MTY BLOW OUT SPARKLER INTO V-904 POUR IN HEAT TO 165-170 DEG F FOR S31	60	979-D	60
CV 12	31 31A 32 33 34 35 36	WHEN S30 COMPLETE, PUMP V-904 AT 165-170 F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (12-15 MIN). MAINTAIN 165-170 DEG F RUN IN N-28-D FROM S19 IN 12-15 MIN AND STIR 15 MIN AT 165-170 DEG F. ADJ TO 36" (3168G) AT 32-38 F USING MANO RECORD: MANO _____ " STICK _____ " RUN IN N-725-A FROM S24 AFAP (5-10 MIN) STIR 30 MIN AT 32-38 DEG F MAINTAINING +KI M _____ % RECORD: KI _____ (+) DUMP IN FROM S3 & STIR 10 MIN LOT	50X330	57-A 725-A 82-C	 900

EQUIPMENT	PAGE	CG	CODE	RT-698-D (K)	EST. WGT.	2775	LBS.	USE	N	ACCT
								LBS.	CODE	LBS.
PT	27			Weight in PT	M 8	4953%		405	7-D	202
8	28			Dilute to maximum volume ±100G for S 47						
904	29			RUN IN 9" (177G) WATER INTO V-922 - HEAT TO 190-195°F - CIRCULATE 15 MIN IN						
9	30			Pump V-922 thru Sparkler into V-904						SPARK
	31			When MTY blow out Sparkler into V-904						
	32			Pour in				70	979-A	70
	33			Heat to 165-170°F for S 34						
CV	34			Run in 1" (95 G) water into V-901						
10	35			When S 32 complete, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min). Maintain 165-170°F in CV						
	36			Record: Start 11:50 PM Total Min 18						
	37			Run in N-28-D from S 22 in 12-15 min						
	38			Stir 15 min at 165-170°F						
	39			Adj to 43" (4080 G) at 32-38°F			60	50 x 330	57-A	
	40			Record: Temp 29 °F Volume 70 "						19800
	41			Run in N-725-A from S 23 AFAP (5-10 min)						
	42			Stir 30 min at 32-38°F maintaining +CR, +KI for S 40						
	43			Record: Time Start 1:20 PM CR + (+) KI + (+)						
	44			NOTE: (1) if CR-KI- add 20# "As Is" increments Assume 32%					28-D	
	45			Record: CR (+), KI (+)						
	46			NOTE: (2) if CR+KI- add 20# "As Is" increments Assume 33%					725-A	
	47			Record: CR (+), KI (+)						
	48			Dump in from S 3 & stir 10 min	Lot				82-C	
	49				6186		1000			1010
	50				6179		10			
	51			Dump in WEIGH ON POSTAL BALANCE & DUMP IN			20	360	20	
	52			Add for maintaining 30-35°F thru S 45						
902	53			Pour N-725-A from S 24 into V-902						
11	54			Dump in			257	165-A	257	
CV	55			Immediately after S 44 complete, pump V-902 thru undersurface distributor into CV in 18-22 min. Maintain 32-38°F in CV					57-A	
12	56			Record: Start 2:15 PM Total Min 25						
	57			Stir 30 min & Record: pH 4.5 (5.0-6.0) Temp 50 °F (40-50°F)						
	58			Run in PT from S 28 thru undersurface line & stir 15 min						
	59			Record: pH 9.6 (9.0-9.8) & if pH is below 9.0						
	60			Adj to pH 9.0-9.8					7-D	
	61			& Record: pH 9.6, Diazo - (-), Base + (+) Assume 32%					28-D	
	62			Steam eject V-932 from S 8 into CV						
	63			Pour in			30	588-A	30	
	64			Heat to 173-175°F in 55-65 min & Record: HT 174 °F & Rec 175 °F						
	65			During S 52 heating dump in						
902	66			During S 52 heating, run 10" (268 G) water into V-902						
13	67			Turn on agitator & steam & dump in			257	16-B	257	
	68			Heat to 155-160°F & stir to dissolve						

EQUIPMENT	PAGE	CG	32	CODE	RT-698-D (K)	EST. WGT.	2775	LBS.	USE LBS.	N ₂ CODE	ACCT LBS.
CV 14	57	When S 52 complete, strike V-902 at 155-160°F thru under- surface distributor into CV in 2-3 min									
		Record: Start <u>5:15 PM</u> Total Min <u>3</u>									
	58	Heat CV to 193-195°F in 10-15 min									
	59	Stir 60 min at 193-195°F Record: Start <u>5:35 PM</u>									
	60	After 20 min S 48 stir Record: pH <u>8.85</u> (8.8-9.3) & if necessary, adj to pH 8.8-9.3 Assume 50% 7-D									
		& Record: pH Assume 32% 28-D									
	61	After S <u>59</u> stir flood to 180-190" (±18000 G) & stop agitator When instructed by Processing Area half way thru pressing, dump in, stir 5 min & stop agitator. Resume pressing 10 588-A 10									
		START FIN OPTR									
		<u>7:00 P.M.</u> <u>3:00 P.M.</u> <u>37</u>									
		<u>3:00 PM</u> <u>6:45 PM</u> <u>201</u>									

EQUIP MENT		PAGE 3 OF 3 CG 32 CODE RT-698-D (I)	USE LBS	N-CODE	ACCT LBS
902 13	37	POUR INTO V-902	226	122-D	226
CV 14	38	IMMEDIATELY AFTER S37 COMPLETE, PUMP V-902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN.			
		RECORD: START _____ TOTAL MIN _____			
	39	STIR 30 MIN & RECORD: DIAZO _____ (-), BASE _____ (+) PH _____ (9.0-9.8) TEMP _____ DEG F (40-50 DEG F)			
	40	IF NECESSARY, ADJ TO PH 9.0-9.8 ASSUME 50% & RECORD: PH _____ M _____ %		7-D 28-D	
	41	STEAM EJECT V-932 INTO CV			
	42	POUR IN	30	588-A	30
	43	HEAT TO 193-195 DEG F IN 65-75 MIN AND RECORD: HT _____ DEG F & REC _____ DEG F			
902 15	44	DURING S43 HEATING, RUN 11" (273G) WATER INTO V-902			
	45	TURN ON AGITATOR & STEAM & DUMP IN	230	16-B	230
	46	HEAT TO 155-160 DEG F & STIR TO DISSOLVE			
CV 16	47	WHEN S43 COMPLETE, STRIKE V-902 AT 155-160F THRU UNDERSURFACE DISTRIBUTOR INTO CV AT 193-195 F IN 2-3 MIN RECORD: START _____ TOTAL MIN _____			
	48	STIR 60 MIN AT 193-195 F RECORD START _____			
	49	AFTER 20 MIN S48 STIR RECORD PH _____ (8.8-9.3) IF NECESSARY, ADJ TO PH 8.8-9.3 ASSUME 50% AND RECORD: PH _____ M _____ %		7-D 28-D	
	50	AFTER S48 STIR FLOOD TO 180-190" (+/-18000G) AND STOP AGITATOR			
		START FIN OPTR			

		WHEN INSTRUCTED BY PROCESSING AREA HALF WAY THRU PRESSING, (1) DUMP IN (2) STIR 5 MIN (3) ADVISE PROCESSING TO RESUME PRESSING	10	588-A	10









