

EST. WGT. 2470 LBS.

STD. HRS. 9.5 TIME _____ M

PROCESSES		APPROVED BY	
() RT-867-D	()	JJG	6/18/75
()	()	DCG	6/25/75
()	()	MW	6/26/75
()	()		
TYPED BY			
emw 072275			

NON-BLEEDING

JIPMENT	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. Making Supv to review with P.R. Supv & Record: Press will be ready M PR Supv <u>RTJ</u> Start Making M Making Supv <u>EC</u>			
REP 1	1 If necessary, clean, dress Sparkler & precoat with 15#		777-A	
	2 Obtain for S 7		740-C	
	3 Obtain for S 24		82-C	
	4 Install DV & CV Recorder & Controller charts			
22	5 Run 35" (722 G) water into V-922			
	6 Weigh in V-926 & run in M 8, 49.83%	454	7-D	226
	7 Turn on agitator & steam & pump in from S 2		740-C	1157
	Lot 100% 199 134 99.2 135	1000		
	8 Dump in	25	113-A	25
	9 Dump in	10	777-A	10
	10 Heat to 212-214°F			
	11 Record: BY +, must be + Assume 50%		7-D	
	12 Stir 30 min at 212-214°F, then shut off steam Watch Foam			
	13 Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 18			
	Record: Start 4:50 PM Total Min 20 Clarity 0°C			
	14 Record: HT 195°F & Rec 195°F			
V 3	15 Run 6" (569 G) water into V-901			
	16 Measure 97 1/2 units in V-928 & run in F 85% in drum M 2, 32.00%	1744	28-D	558
04 4	17 Run 2" (58 G) into V-904			
	18 When S 13 complete, pump in V-922 thru Sparkler			
	Maintain V-922 at 190-195°F			
	Record: Start 5:15 PM Total min 35			
11 cc	19 Weigh in PT for S 33 M 7, 32.93%	1139	725-A	375
	20 Weigh in drum for S 38 M 7, 32.93%	100	725-A	33
	21 Weigh in drum for S 39 M 7, 32.93%	100	725-A	33

(JH)

DATE PRINTED: 5/07/81

S.V.

MAY 11 1981

C.V. 901, 903

D.V. 902, 904

CG 32 CODE RT-867-D PKG ---

PROCESSES

APPROVED BY

MAY -0-81-31397

() RT-867-D (D)

JJG-4/1/81

(DATE) (LOT NUMBER)

() ALTERNATE ()

() ()

TYPED BY: JMH

ESTIMATED WGT 2470 LBS.

STANDARD HRS. ---

TIME --- M

PREPARATION NOTES: ---

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. MAKING SUPVR TO REVIEW WITH P.R. SUPV & RECORD: PRESS WILL BE READY --- M --- PR SUPVR START MAKING --- M --- MAKING SUPV ---			
	NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V-922			
PREP 1	1 IF NECESSARY, CLEAN, DRESS SPARKLER & PRE- COAT WITH 15#		777-A	
	2 OBTAIN FOR S7		740-C	
	3 OBTAIN FOR S24		82-C	
	4 INSTALL DV & CV RECORDER & CONTROLLER CHART			
922 2	5 RUN 35: (722G) WATER INTO V-922			
	6 WEIGH IN V-926 & RUN IN M --- %		7-D	206
	7 TURN ON AGITATOR & STEAM & PUMP IN FROM S2 LOT 100% %		740-C	1054
	8 DUMP IN	25	113-A	25
	9 DUMP IN	10	777-A	10
	10 HEAT TO 212-214 DEG F WATCH FOAM			
	11 RECORD: BY ---, MUST BE + ASSUME 50%		7-D	
	12 STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM			
	RECORD: SPARKLER PRESSURE --- PSI. IF NOT ZERO, NOTIFY SUPERVISOR			
	13 CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 F			
	FOR S18 RECORD: START --- TOTAL MIN --- CLARITY ---			
	14 RECORD: HT --- DEG F & REC --- DEG F			

DUP050098246

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 2 OF 3 CG 32 CODE RT-867-D (D)	USE LBS	N-CODE	ACCT LBS
CV	15	RUN 6" (569G) WATER INTO V-			
3	16	MEASURE _____ UNITS IN V-928 & RUN IN M _____ %		28-D	508
904	117	RUN 2" (58G) INTO V-904			
4	118	WHEN S13 COMPLETE, PUMP IN V-922 THRU SPARKLER MAINTAIN V-922 AT 190-195 DEG F RECORD: START _____ TOTAL MIN _____			
MISC	119	WEIGH IN PT FOR S33 M _____ %		725-A	342
5	120	WEIGH IN DRUM FOR S38 M _____ %		725-A	30
	121	WEIGH IN DRUM FOR S39 M _____ %		725-A	30
DV	122	RUN 56" (1566G) WATER INTO V-			
6	123	WEIGH IN V-926 & RUN IN M _____ %		7-D	495
	124	DUMP IN FROM S3 LOT		82-C	964
	125	ADJ TO 70-90 DEG F & STIR 10 MIN OR LONGER TO DISSOLVE FOR S39			
922	126	WHEN S18 COMPLETE, STOP PUMP & INSERT V-922 FOOT PLUG			
7	127A	RUN IN 10" (209G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904	127B	PUMP THRU SPARKLER INTO V-904			
8					
922	128A	RUN IN 5" (104G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
9					
904	128B	PUMP V-922 THRU SPARKLER INTO V-904			
10	129	WHEN MT BLOW OUT SPARKLER INTO V-904			
	130	HEAT TO 165-170 DEG F			
CV	131	WHEN S30 COMPLETE, PUMP V-904 AT 165-170 F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (12-15 MIN) RECORD: START _____ TOTAL MIN _____			
11	132	ADJ TO 43" (4080G) AT 32-38 DEG F	46X330	57-A	
	133	RUN IN N-725-A FROM S19 AFAP (5-10 MIN) & STIR 20 MIN AT 32-38 F MAINTAINING +KI M _____ %		57-A	
	134	RECORD: KI _____ (+)		725-A	
	135	DUMP IN	714	20-A	714
	136	DUMP IN	50	65-A	50
	137	ADJ TO 90" (8532G) & ADD TO MAINTAIN CV AT 32-38 DEG F	30X330	57-A	
	138	POUR IN N-725-A FROM S20			

V-901

INSTRUMENT	PAGE 2	CG 32	CODE RT-867-D (D)	EST. WGT.	2250	LBS.	USE LBS.	N CODE	ACCT. LBS.
	22	Run 56" (1566 G) water into V-	902						
	23	Weigh in V-926 & run in		M	8	4983	% 1090	7-D	543
	24	Dump in from S 3				Lot		82-C	1058
						6186	1000		
						6179	58		
	25	Adj to 70-90°F & stir 10 min or longer to dissolve for S 39							
2	26	When S-18 complete, stop pump & insert V-922 foot plug							
7	27	Run in 15" (309 G) water & heat to 190-195°F, CIRCULATE 15 MIN THRU SPARKLER							
14	28	Run in 10" (205 G) WATER IN V-922 & HEAT TO 190-195°F - CIRCULATE 15 MIN THRU SPARKLER							
8	29	Pump V-922 thru Sparkler into V-904							
	30	When MT blow out Sparkler into V-904							
	31	Heat to 165-170°F							
9	31	When S 30 complete, pump V-904 at 165-170°F thru under-surface distributor into CV AFAP (12-15 min)							
		Record: Start 8:00 PM Total Min 20				70			
	32	Adj to 43" (4080 G) at 32-38°F					X 330	57-A	23100
	33	Run in N-725-A from S 19 AFAP (5-10 min) and						57-A	
	34	Stir 30 min at 32-38°F maintaining +K1 M						725-A	
	35	Record: K1 + (+)							
	36	Dump in					784	20-A	784
	37	Dump in					55	65-A	55
	38	Adj to 90" (8532 G) & add to maintain CV at 32-38°F					33X 330	57-A	10890
	39	Pour in N-725-A from S 20							
	40	Pour N-725-A from S 21 into DV							
	41	Weigh in from drum					261	122-D	261
V	41	Immediately couple DV thru undersurface distributor into							
11	42	CV in 18-22 min. Maintain CV - 32-38°F						52-A	
		Record: Start 4:45 PM Total min. 2.5							
	43	Stir 30 min							
	44	Record: Base + (+), Diazo - (-), pH 9.2 (9.0-9.8)							
	45	Adj to pH 9.0-9.2 Record: pH						7-D	
								28-D	
	46	Run ±70 G water into PT							
12	47	Dump in					200	16-B	200
	48	Heat to 155-160°F & stir to dissolve for S 48							
V	49	When S 47 complete, run PT into CV							
13	50	Measure in calibrated container & pour in					35	588-A	35
	51	Heat to 193-195°F in 75-80 min							
	52	Record: HT 195 °F & Rec 195 °F							
	53	Stir 60 min at 193-195°F							
	54	After 20 min S 52 stir Record: pH 8.5 (8.2-8.6)							
	55	When S 52 complete, flood to 180-190" (±18,000 G) & stop							
		agitator							
		START 3:30 PM							
		11:00 PM							
		FIN 11:00 PM							
		4:00 PM							
		OPT 4:00 PM							
		237							





