S.V. C.V. 901, 903 D.V. 904

CG.32 CODE RT-618-D PKG ____

PROCESSES ( )RT-618-D (S) ( )ALTERNATE ( ) ( ) ( )

APPROVED BY JJG 3-18-81

MAY 21 1981 (DATE) E1591 (LOT NUMBER)

2 Jo

TYPED BY: JMH

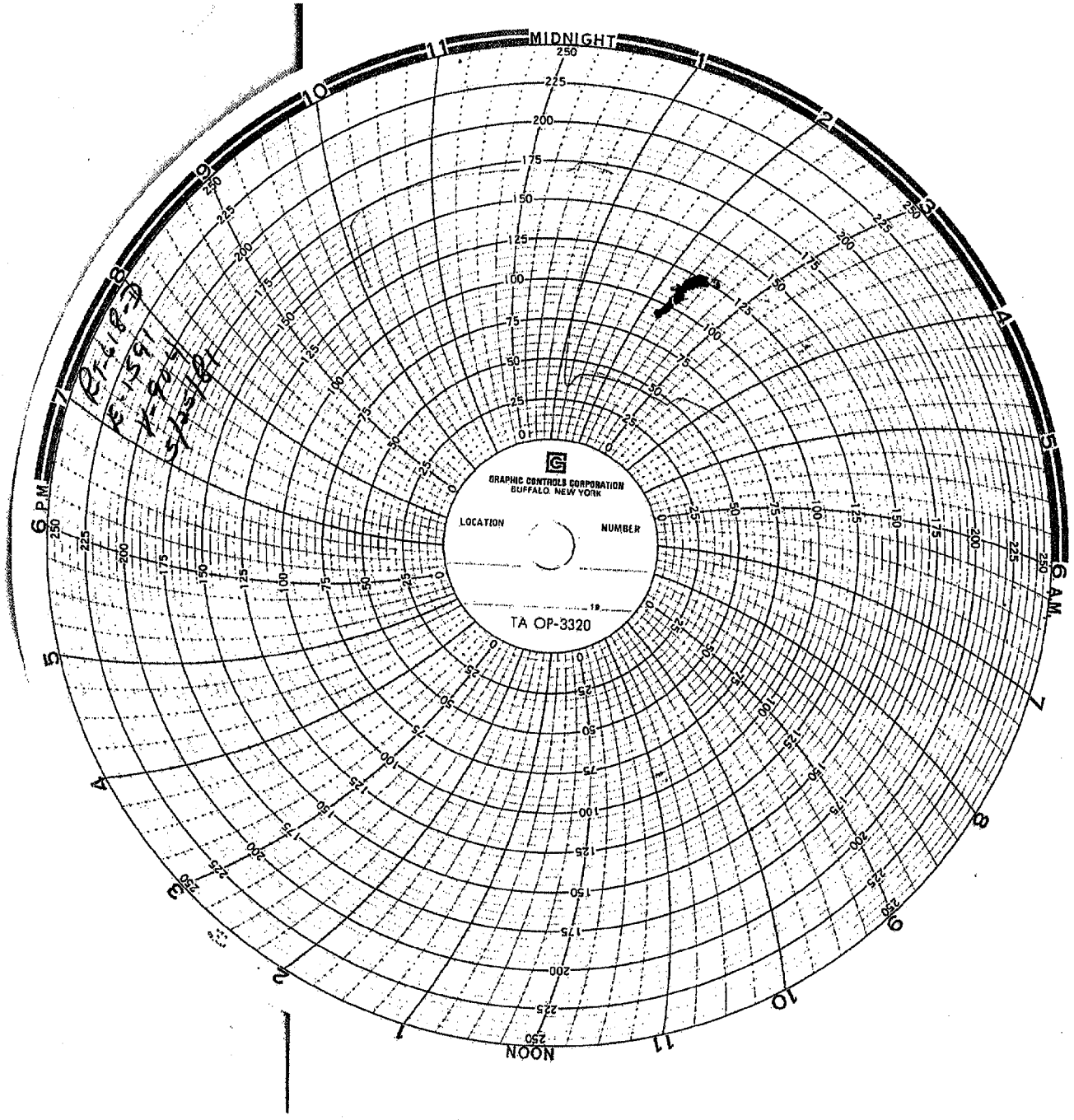
ESTIMATED WGT 2902 LBS. STANDARD HRS. _____ TIME _____M

PREPARATION NOTES: _____

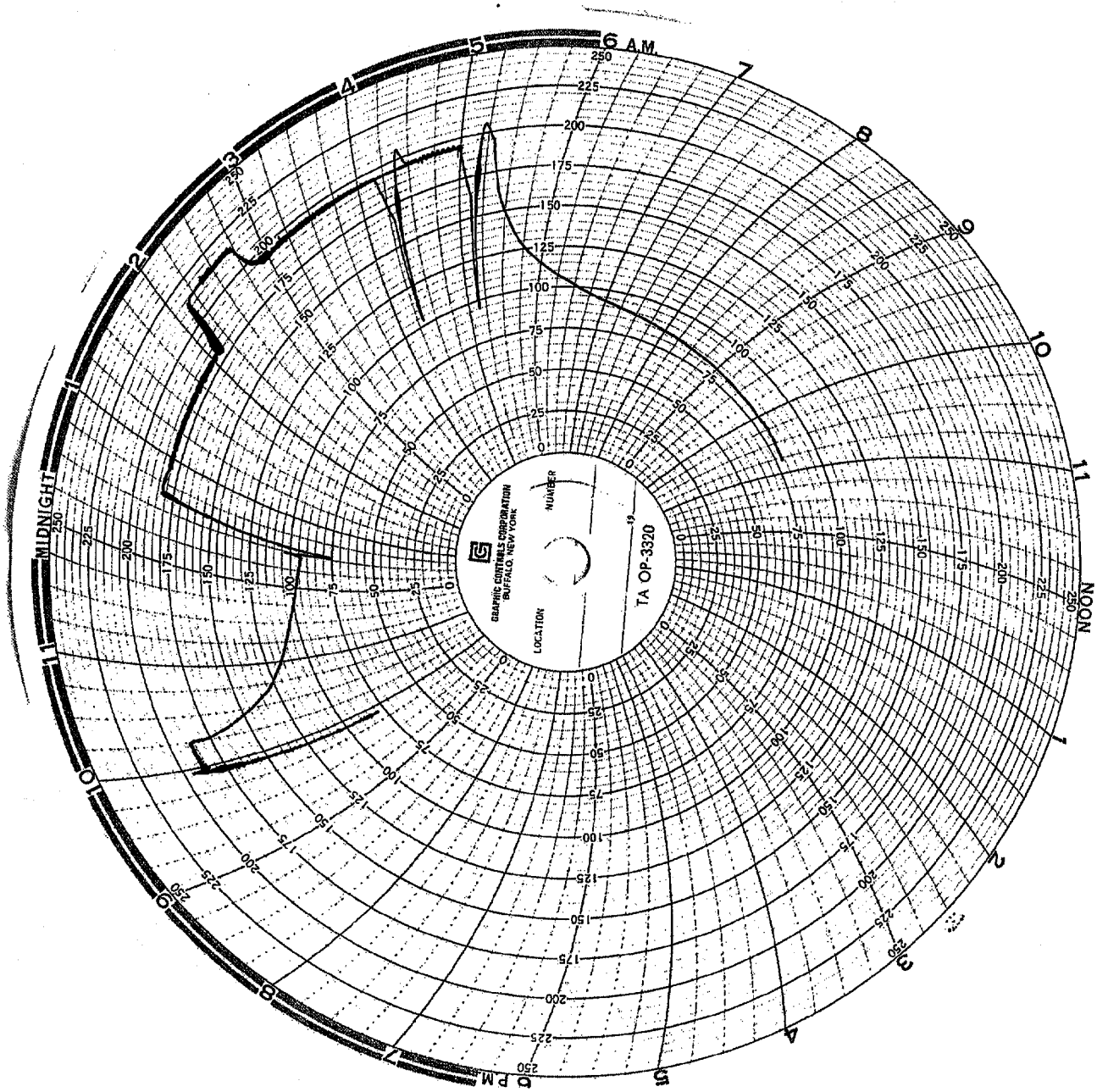
EQUIPMENT		NAME: WATCHUNG RED Y	USE LBS	N-CODE	ACCT LBS
PREP 1	1	RECORD: 1 BATCHES SINCE SPARKLER LAST CLEANED. AFTER 5 BATCHES, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15#	15	777-A	15
	2	OBTAIN FOR S11		740-C	
	3	OBTAIN FOR S24		253-C	
	4	INSTALL DV & CV RECORDER & CONTROLLER CHART			
		NOTE: NOTIFY PRESS ROOM AND ROPE OFF AREA UNDER V-922			
921/931 2	5	RUN 10"(100G) WATER INTO V-921 & ADJ TO 80-100 DEG F			
	6	ADD IN 1-2 MIN	63	530-A	63
	7	STIR 2 MIN & RECORD: PH 9.8 (9.5-10.5)			
	8	STIR 20 MIN OR LONGER FOR S27			
922 3	9	RUN 31" (700G) WATER INTO V-922			
	10	WEIGH IN V-926 & RUN IN M 9, 50.38%	400	7-D	201
	11	TURN ON AGITATOR & STEAM & DUMP IN FROM S2		740-C	1035
		LOT 197 100% 1035 99.3%	1042		
	12	DUMP IN	50	113-B	50
	13	DUMP IN	10	777-A	10
	14	HEAT TO 212-214 DEG F, RECORD HT 215 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			
		NOTE: RECORD: SPARKLER PRESSURE 0 PSI			
		IF NOT ZERO, NOTIFY SUPERVISOR			
	17	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 F FOR S19 & RECORD: HT _____ DEG F AND RECORDER 195 DEG F	MAY 26 1981		
		RECORD: START 8:50 PM TOTAL MIN 65, CLARITY OK. NOTE: SAMPLE FROM HOSE - SHOW TO SUPERVISOR FOR O.K.			

EQUIPMENT		PAGE 2 OF 3 CG 32 CODE RT-618-D (S)	USE LBS	N-CODE	ACCT LBS
904 4	18	RUN 1" (50G) WATER INTO V-904			
	19	WHEN S17 COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F			
		RECORD: START 9:55 PM, TOTAL MIN 35			
MISC 5	20	WEIGH IN PT FOR S35 M 7, 32.92%	1006	725-A	332
	21	MEASURE 84½ UNITS IN V-928 FOR S33	1302	28-D	419
		M 2, 32.00%			
CV 6	22	RUN 16" (1530G) WATER INTO V-901			
	23	WEIGH IN V-926 & RUN IN M 9, 32.56%	1003	7-D	507
	24	DUMP IN FROM S3 LOT 553 554	770 142	253-C	~~900~~ 912
	25	WEIGH ON POSTAL SCALE & DUMP IN LOT		~~7 100-C~~	
	26	ADJ TO 70-90 DEG F & STIR TO DISSOLVE			
	27	STEAM EJECT V-921/931 INTO CV			
922 7	28	WHEN S19 COMPLETE, SHUT OFF PUMP & INSERT V-922 FOOT PLUG			
	29A	RUN IN 10" (207G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER.			
904 8	29B	PUMP V-922 THRU SPARKLER INTO V-904			
922 9	30A	RUN IN 5" (103G) WATER INTO V-922 & HEAT TO 190-195 F. CIRCULATE 15 MIN THRU SPARKLER			
904 10	30B	PUMP V-922 THRU SPARKLER INTO V-904			
	31	WHEN MTY BLOW OUT SPARKLER INTO V-904			
	32	HEAT TO 165-170 F (SMPL TO SUPVR FOR O.K.)			
	33	RUN IN N-28-D FROM S21 IN 12-15 MIN & STIR 5 MIN AT 165-170 DEG F			
	34	ADJ TO 129"(3409G) AT 28-30 DEG F AND RECORD: TEMP _____DEG F, _____"	40X330	57-A	13200
	35	RUN IN N-725-A FROM S20 AFAP (5-10 MIN)			
	36	STIR 30 MIN AT 28-35 DEG F MAINTAINING +CR, +KI FOR S41 AND RECORD: TIME START 1:30 Am, CR + (+), KI + (+)			
		NOTE (1) IF CR-, KI-, ADD 20# AS IS INCREMENTS ASSUME 32%	_____	28-A	_____
		RECORD: CR_____(+), KI_____(+)			
		(2) IF CR+, KI-, ADD 20# AS IS INCREMENTS			
		RECORD: CR_____(+), KI_____(+) ASSUME 33%	_____	725-A	_____

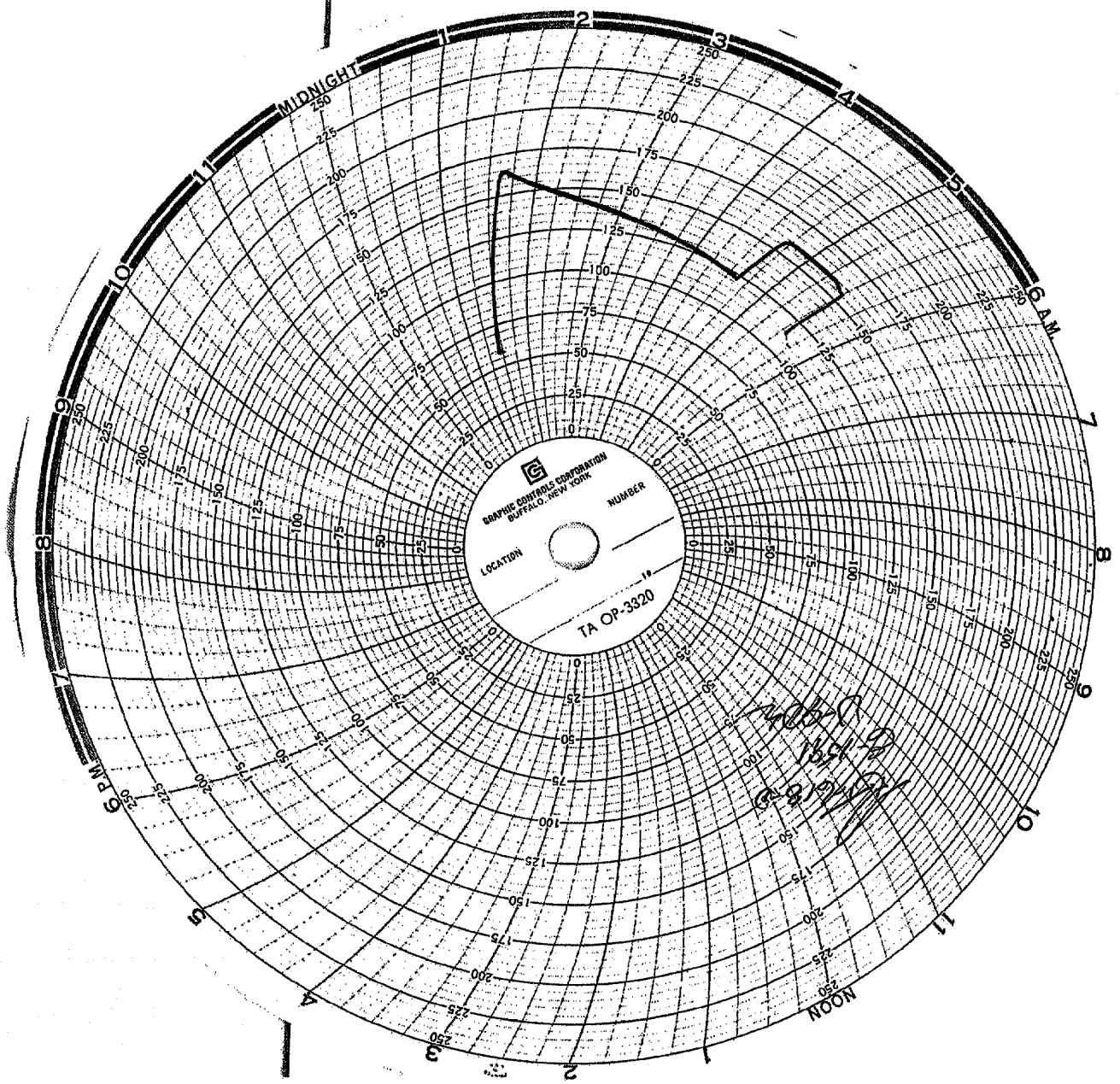
EQUIPMENT		PAGE 3 OF 3 CG 32 CODE RT-618-D (S)	USE LBS	N-CODE	ACCT LBS
CV 11	37	DUMP INTO CV	180	65-A	180
	38	ADJ TO 37" (3496G) AT 28-32 DEG F	35 X330	57-A	1155
		RECORD: TEMP 30 | 41 DEG F & VOLUME 40 "			
	39	WEIGH IN FROM DRUM	239	165-A	239
	40	STIR 2-3 MIN			
	41	IMMEDIATELY COUPLE DV THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 45-60 MIN. MAINTAIN CV AT 28-32 DEG F. RECORD: START 2:35 AM TOTAL MIN 60	____	57-A	____
	42	STIR 30 MIN & RECORD BASE + (+), DIAZO ____ (-), PH 9.5 (9.0-9.8) FINAL TEMP 41 DEG F			
	43	IF NECESSARY, ADJ TO PH 9.0-9.8 ASSUME 50%	_____	7-D	_____
		& RECORD: PH_____ ASSUME 32%	_____	28-D	_____
	44	HEAT TO 184-186 DEG F IN 65-70 MIN AND RECORD: HT 178 DEG F & RECORDER 185 DEG F			
DV 12	45	RUN 24 " (600G) WATER INTO DV			
	46	TURN ON AGITATOR & STEAM & DUMP IN	1620	16-B	1620
	47	HEAT TO 155-160 DEG F & STIR TO DISSOLVE			
CV 13	48	WHEN S44 COMPLETE, IMMEDIATELY STRIKE DV THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 7-10 MIN. MAINTAIN CV AT 184-186 DEG F. RECORD: START 5:15 AM, TOTAL MIN 8			
	49	HEAT CV TO 198-202 DEG F IN 10-12 MIN			
	50	STIR 5 MIN AT 198-202 DEG F			
	51	FLOOD TO 180-190" (+/-18,000G)			
	52	RECORD: PH 8.6 (9.0-9.4) & STOP AGITATOR			
		START FIN OPTR 5:30 Pm 11:00 Pm 144 11:00 Pm 5:15 Pm 201			
		WHEN INSTRUCTED BY PROCESSING AREA HALF WAY THRU PRESSING, DUMP IN, STIR 5 MIN. AND STOP AGITATOR. RESUME PRESSING.	10	588-A	10



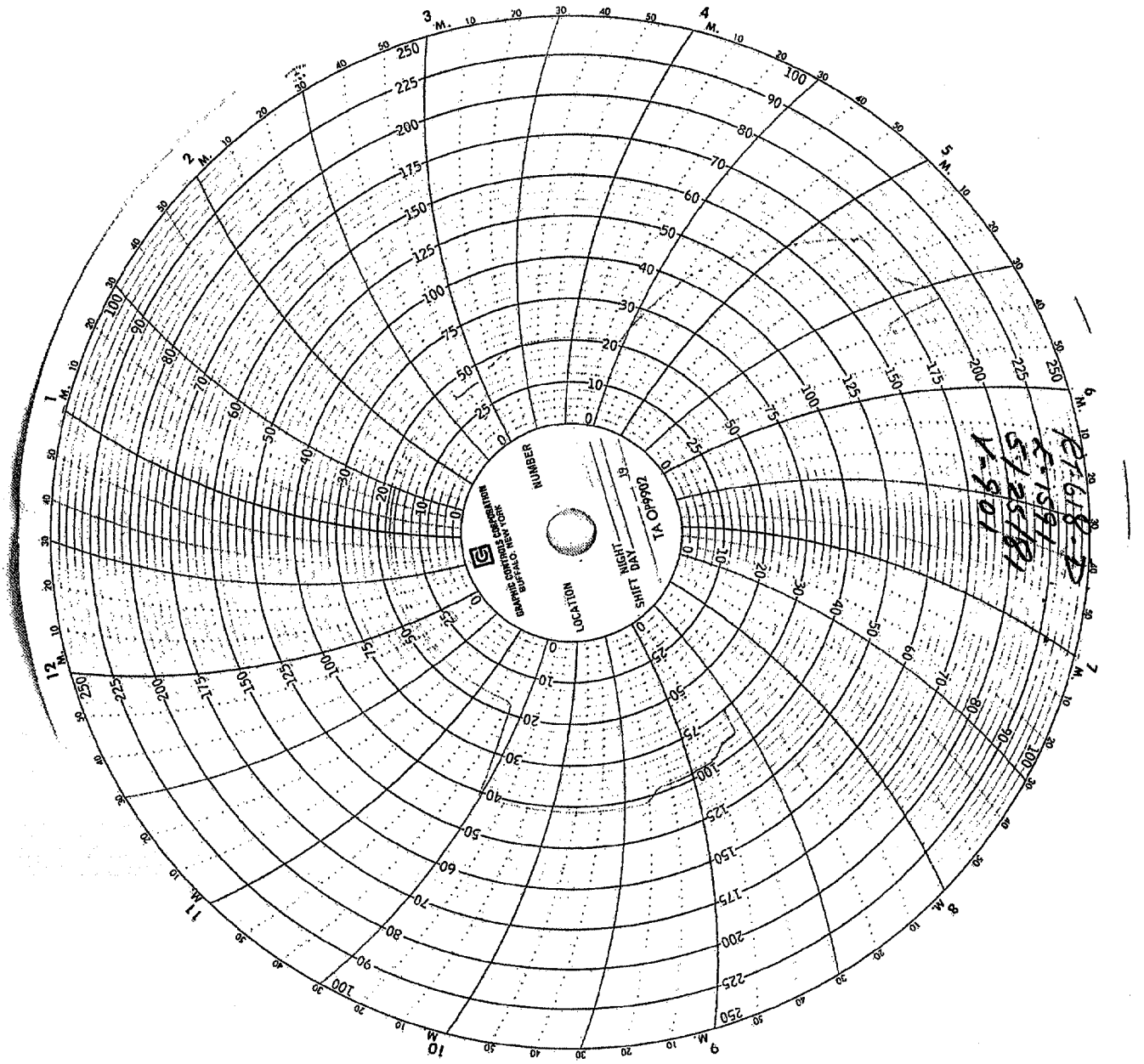
DUP050097528



DUP050097529



DUP050097530



DUP050097531

MD-3-A

PACKAGE TICKET (DRY AND PASTE ONLY)

CODE AT618 LOT E1591

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PQ
	17	2804	26-30	
	STUMP	10mm	2809	

TOTAL NET WT. 2804 PKG. N–CODE

PROD. SPVR. DATE WHSE. OPER.

6/16

DUP050097532

D.T
172.+
162.+
165.+
172.+
163.+
160.+
172.+
164.+
170.+
153.+
171.+
161.+
164.+
176.+
179.+
159.+
141.+
2804.T

PRODUCT NAME = WATCHUNG RED Y

CG 32 CODE RT-618-D PKG ___

LOT E1591

EST'D WGT 2902 LBS

TOTAL EST'D WGT= LBS (CRT ENTRY)

NON-BLEEDING
PROCESSES APPROVED BY
RT-618-D (S)
ALTERNATE
TYPED BY JMH

MAKING NOTES

JOB NAME: 32RT618DPS

INSTRUCTIONS					= PRESSING =	RECORD				
VAT	901				PRESSLOAD	1ST	2ND	3RD	4TH	5TH
DATE	5-25-81				STARTED	230 PM				
TIME	5:40PM				CAKES USED	68				
RELEASED BY	DCH				WATER ON	538 PM				
PRESS	95	96			HRS. WASHED	5				
NO.OF CAKES	68	68			OHMS	3.000				
PRESS WITHOUT AGITATION					HRS. WASHED					
WASH TO 3000 OHMS - 35-75 F WATER					OHMS					
TEST AFTER 2 HOURS					HRS. WASHED					
LOAD ON 10 CARS					OHMS					
USE MN FREE EQUIPMENT. INSTRUCT					CAKE CONDITION					
MAKING AREA TO ADD 10# N-588-A HALF-					NO CARS LOADED	9+3				
WAY THRU PRESSING. CLEAN MAGNETIC					EXPLAIN LOSSES					
SEPARATOR AFTER PRESSING										
CLEANED BY										
TIME CLEANED										
SAMPLES JAR					SAMPLED BY					
DELIVER TO					RELEASED BY					

= DRYING =

DRY 24 HOURS AT 180 F
USE MN FREE EQUIPMENT. USE PAPER LINERS IN L/P. HOLD ON TRACK 30 MIN BEFORE DUMPING PANS.

LUMP: - OK - WET - SALTS - CONTAMINATD

ADDITIONAL DRYING HOURS REQUIRED

SAMPLES
DELIVER TO

NO CARS PULLED
SAMPLED BY
RELEASED BY

NO DRUMS 19
LUMP WGT 2809
TDS

= GRINDING =

MILL 2 LSP 1/8"RP SCREEN 1750 RPM
MAX. TEMP. 150 F
DO NOT GRIND OTHER ORGANICS IN IMMEDIATE AREA. USE MN FREE EQUIPMENT.

SCREEN RPM
MAX. TEMP. F

EXPLAIN LOSSES

SAMPLE WITHOUT MIXING
SAMPLES 2 ENV.
DELIVER TO CTL

DATE MIXED

SAMPLED BY
RELEASED BY 6/16/81

DUP050097534

1.62 +
0.14 -
1.55 +
0.14 -
1.60 +
0.14 -
1.59 +
0.14 -
1.63 +
0.14 -
1.61 +
0.14 -
1.65 +
0.14 -
1.74 +
0.14 -
1.66 +
0.14 -
1.68 +
0.14 -
1.62 +
0.14 -
1.71 +
0.14 -
1.56 +
0.14 -
1.55 +
0.14 -
0.63 +
0.14 -
21.30 *

21.30 +
1.94 +
0.14 -
1.78 +
0.14 -
1.82 +
0.14 -
1.81 +
0.14 -
28.09 *

DUP050097535