CG 32 CODE RT-761-D PKG. _____

→ SEP · 15 80 37085

EST. WGT. 2054 LBS.

STD. HRS. _____ TIME _____ M

PROCESSES		APPROVED BY
( ) RT-761-D	(K)	JJG 4-4-78
( ) RT-838-D	(J)	DCG 4-11-78
( )	( )	MTW 4-13-78
( )	( )	
TYPED BY		
NSA 4-17-78		

PUNCHED & CHECKED

Use Flake Caustic

SEP 19 1980

NON-BLEEDING

UIPMENT		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 / P.R. Supv. Start Making M / Making Supv.			
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 12 Lot 100 X OPERATOR 301		740-C	
	3	Obtain for S 27 Lot 447 X		[illegible]	
	4	Install DV & CV Recorder & Controller charts			
921/ 931 2	5	Run 12" (120 G) water into V- 922 & adj to 80-100°F			
	6	Add in 1-2 min	80	99-A	80
	7	Add in 1-2 min	40	530-A	40
	8	Stir 5 min & Record: pH 10.1 (9.5-10.5)			
	9	Stir 20 min or longer to dissolve for S 30			
922 3	10	Run 28" (527 G) water into V-922		721-D	
	11	Weigh in V-926 & run in M Flake %	165	~~7-D~~	165
	12	Turn on agitator & steam & dump in from S 2		740-C	845
		Lot #100% %			
use Lot 100 only		100 845 98.6	857		
	13	Dump in	25	113-A	25
	14	Dump in	10	777-A	10
	15	Heat to 212-214°F Watch Foam			
	16	Record: BY + must be +. Adj if needed Assume 50%		7-D	
	17	Stir 30 min at 212-214°F, then shut off steam Watch Foam			
	18	Record: HT F & Rec 195 F			
	19	Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 24 Record: Start 11:00 AM Total Min 11:15 Clarity CLEAR			
Misc. 4	20	Measure 83 3/4 units in V-928 for S-39 M 7 , 31.62%	1281	28-D	407
	21	Weigh in PT for S 42 M 10 , 32.71 %	922	725-A	305
	22	Weigh in drum for S 48 10 32.71	97	725-A	32
904/CV 5	23	Run 1" G water into V- 901 Note: Use CV if MTY. If CV is not MTY, use V-904			
901	24	When S 19 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F Record: Start 11:30 AM Total Min 35			

9829 REV.

N35096

QUIPMENT		PAGE 2 CG 32 CODE RT-761-D (K), RT-838-D (M)	USE LBS.	N CODE	ACC LBS
902 6	25	Run 45" (1250 G) water into V-902		721-D	525
	26	Weigh in V-926 & run in M Flake %	525	[illegible]	[illegible]
	27	Dump in from S 3 Lot		[illegible]	[illegible]
		Weight 497 4863	752	[illegible]	[illegible]
	27A	WEIGH ON POSTAL SCALE & ADD	8	36-C	8
	27B	WEIGH ON POSTAL SCALE & ADD	10	180-C	10
	28	Adj to 70-90°F & stir 10 min to dissolve			
	29	Slurry in 30 Gal water & pour into V-902	76	39-A	76
	30	Steam eject in V-921/931 from S 9			
922 & 904/CV 7	31	When S 24 complete, stop pump & insert V-922 foot plug			
	32	Run in 12" (247 G) water & heat to 180-190°F			
	33	Pump V-922 thru Sparkler into V-904/CV			
	34	When V-902 MTY blow out Sparkler into V-904/CV			
	35	~~Weigh & add to V-904~~ [illegible]	[illegible]	[illegible]	[illegible]
	36	Heat V-904 to 165-170°F for S 39			
		Note: If N-740-C solution was pumped directly from Sparkler to CV at S's 23 & 24 omit S's 37 & 38			
CV 8	37	Run 1" (95 G) water into V-			
	38	If V-904 is used, pump V-904 at 165-170°F thru under- surface distributor into CV AFAP (12-15 min) - Maintain CV at 165-170°F			
	39	Run in N-28-D from S 20 in 12-15 min			
	40	Stir 5 min			
	41	Adj to 35" (3300 G) at 32-38°F	36x330	57-A	11,880
	42	Run in N-725-A from S 2 AFAP (5-10 min)			
	43	Stir 10 min at 32-38°F maintaining +CR, +KI	[illegible]	[illegible]	[illegible]
		Record: Time Start 2:00 PM 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 (+)			
	44	Dump in	850	20-A	850
	45	Dump in	186	246-D	[illegible]
	46	Dump in	100	65-A	100
	47	Add for maintaining 32-38°F during coupling	30x330	57-A	9,900
902 9	48	Pour N-725-A from S 22 into V-902			
	49	Dump in	144	165-A	144
CV 11	50	Immediately couple V-902 thru undersurface distributor into CV in 18-22 min. Maintain DV at 32-38°F			
		Record: Start 3:50 PM Total Min 16			
	51	Stir 5 min & Record: Base + (+), Diazo — (-) Rec 42 °F; HT 46 °F			
		pH (9.0-9.8) 10.0-10.5			
	52	If necessary, adj to pH 9.0-9.8 & Record: pH 10.5 Assume 50%		7-D	
		10.0-10.5 Assume 32%		28-D	
	53	Weigh in drum & pour in	28	588-D	28
	54	Heat to 184-186°F in 70-75 min			
	55	Record: HT 180°F & Rec 186°F			
	56	Stir 60 min at 184-186°F			
	57	After 10 min S 56 stir, record: pH 9.9 (9.5-10.0)			
	58	If necessary, adj to pH 9.5-10.0 Assume 50%		7-D	
		Record: pH If pH above 10.0 do not adjust.			
	59	When S 56 complete, flood to 180-190" (±18000 G) & stop agitator			
		When instructed by Process Area halfway thru pressing			
	1	Dump in	10	588-A	10

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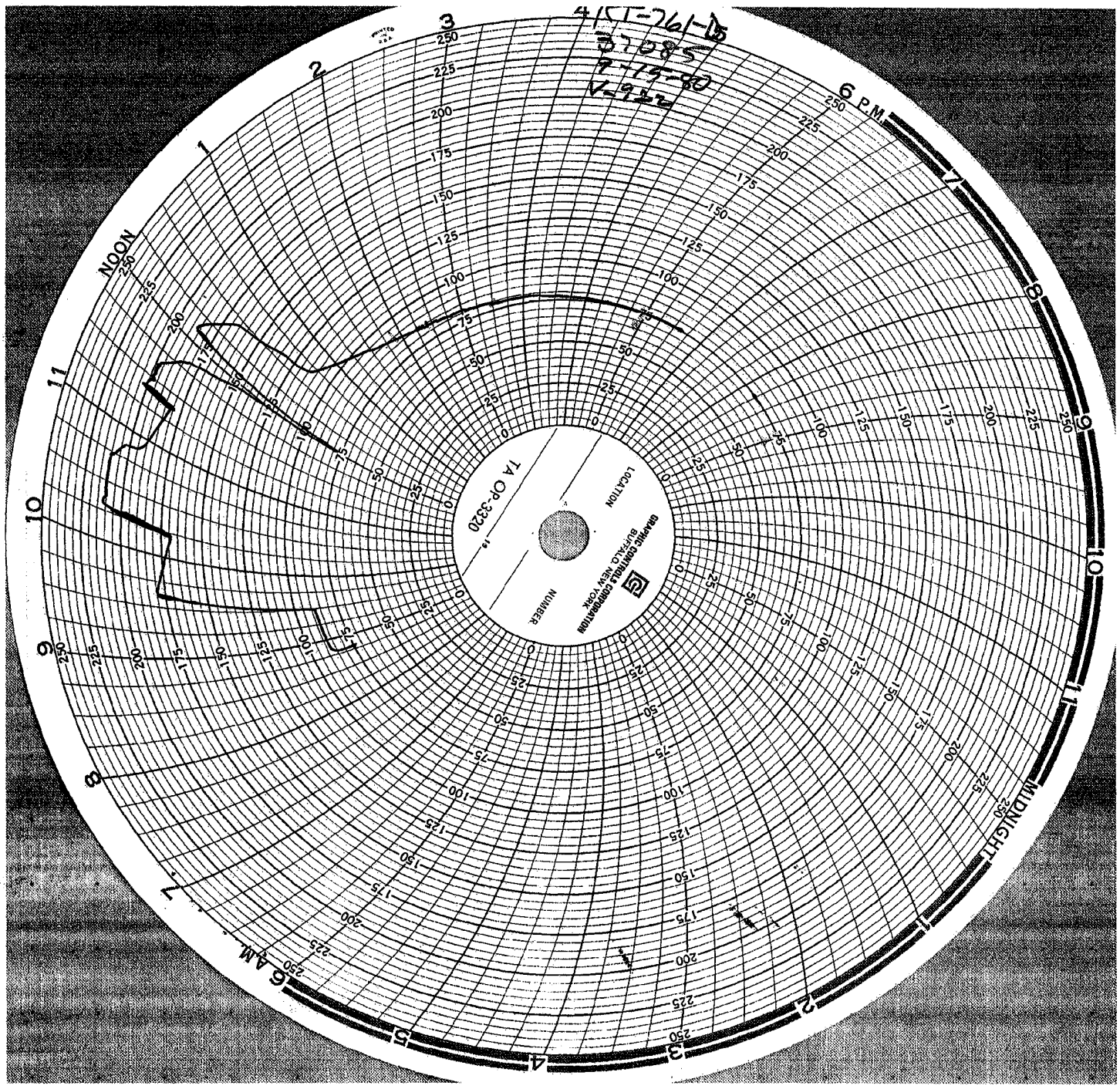
JUIPMENT		PAGE 3 CG 32 CODE RT-761-D (K) , RT-838-D (M)	USE LBS.	N CODE	ACCT. LBS.
	2	Stir 5 min			
	3	Advise Processing to resume pressing			
		START FIN OPTR			
		7:00AM 3:00PM 391			
		2:00PM 7:15PM 144			

13830 REV.

DUP050107635



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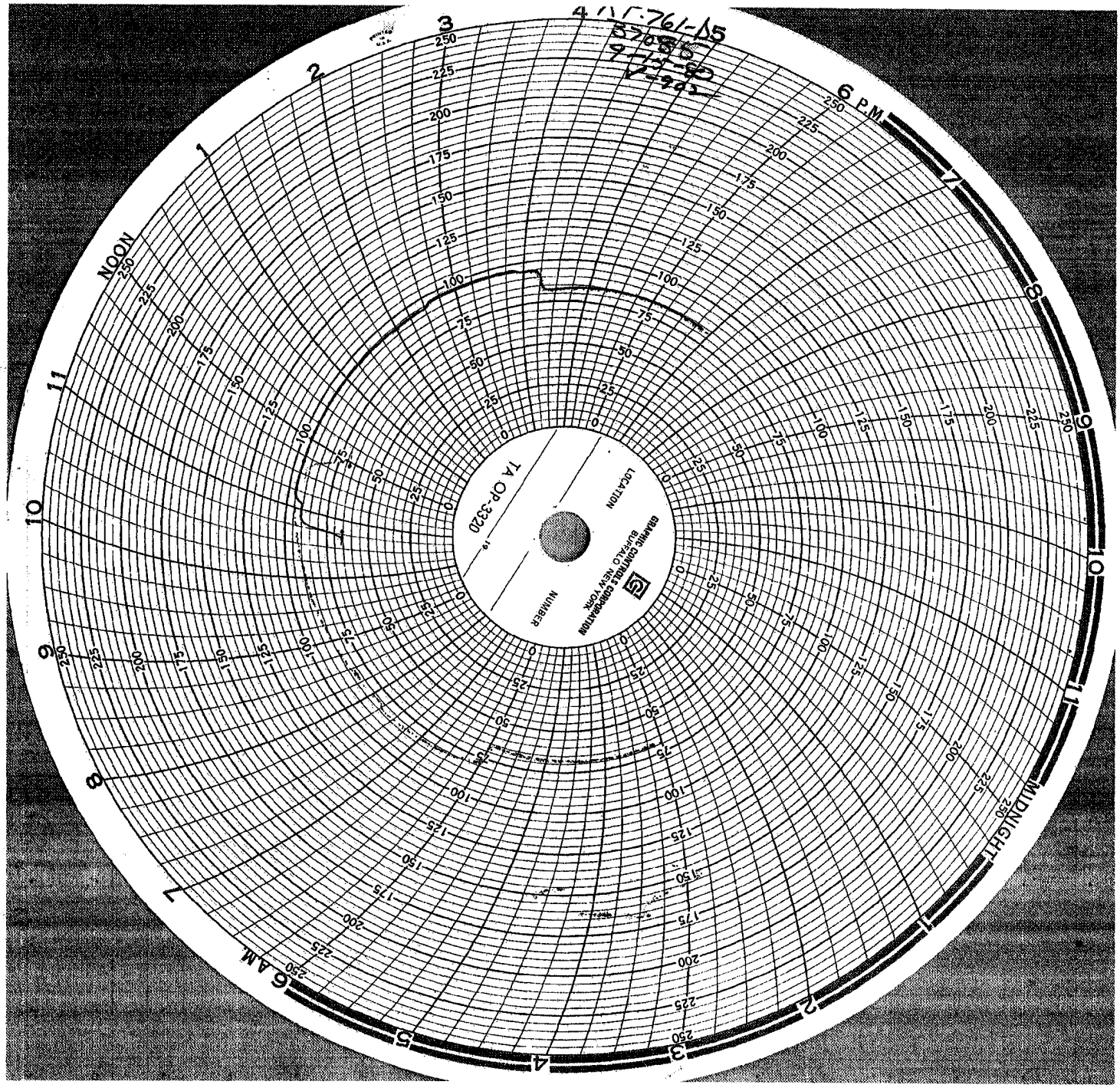

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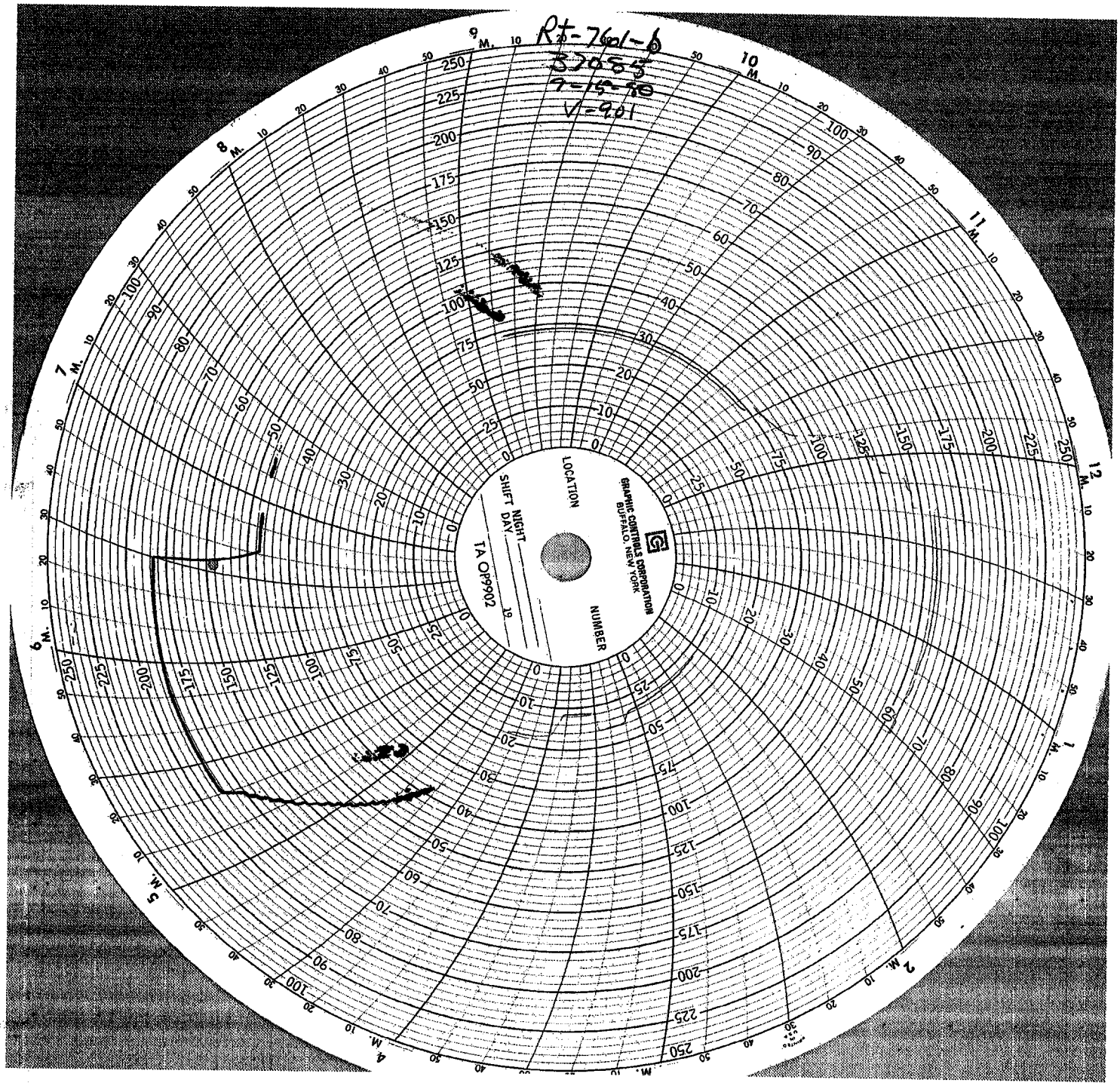

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