

SG 32
OCT 25 1982

CODE RT-618-D PKG
L2H43

PROCESSES
() RT-618-D (T) APPROVED BY
EWK 12/8/81

(DATE) (LOT NUMBER)

EST. WT. ²³⁷⁰ LBS. STD/ HRS. TIME 3P M

TYPED BY: KLU

COMTYP JOB NAME: 32RT618DMT

PREPARATION NOTES:

PRE COAT SPARKLER. Done NON-BLEEDING

EQUIP MENT		NAME: WATCHUNG RED Y	USE LBS	N-CODE	ACCT LBS
PREP 1	1	RECORD: <i>00</i> BATCHES SINCE SPARKLER LAST CLEANED. AFTER 4 BATCHES, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15% DICALITE FILTER AID	<i>15</i>	777-A	<i>15</i>
	2	OBTAIN FOR S11 2-CHLORO-4-AMINOTOLUENE-5- SULFONIC ACID		740-C	
	3	OBTAIN FOR S24 3-HYDROXY-2-NAPHTHOIC ACID		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- <i>931</i> & ADJ TO 80-100 DEG F			
	6	ADD IN 1-2 MIN. DRESINATEX	50	530-A	50
	7	STIR 2 MIN & RECORD: PH <i>10.1</i> (9.5-10.5)			
	8	STIR 20 MIN OR LONGER FOR S27			
922 3	9	RUN 30" (620G) WATER INTO V-922			
	10	WEIGH IN V-926 SODIUM HYDROXIDE & RUN IN M <i>12</i> <i>50.16</i> % <i>305</i>		7-D	178
	11	TURN ON AGITATOR & STEAM & DUMP IN FROM S2 2-CHLORO- LOT 100% <i>920</i> <i>98.52</i> <i>934</i> 4-AMINOTOLUENE <i>322</i> -5-SULFONIC ACID		740-C	920
	12	DUMP IN ACTIVATED CARBON 779	40	113-B	40
	13	DUMP IN DICALITE FILTER AID	10	777-A	10
	14	HEAT TO 212-214 DEG F, RECORD HT <i>214</i> * F, <i>214</i> DEG F WATCH FOAM			
	15	RECORD BY <i>+</i> (+), IF NECESSARY ADJ TO +BY SODIUM HYDROXIDE ASSUME 50%		7-D	
	16	STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM NOTE: RECORD: SPARKLER PRESSURE <i>0.0</i> PSI IF NOT ZERO, NOTIFY SUPERVISOR			
	17	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 196-195 F FOR S19 & RECORD: HT <i>196</i> DEG F AND RECORDER <i>196</i> DEG F RECORD: START <i>5:00</i> , TOTAL MIN <i>15</i> CLARITY <i>Good</i> , NOTE: SAMPLE FROM HOSE - SHOW TO SUPERVISOR FOR O.K.			

OCT 27 1982

(Signature)

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 2 OF 3 CG 32 CODE RT-618-D (T)	USE LBS	N-CODE	ACCT LBS
904	18	RUN 1" (50G) WATER INTO V-904			
4	19	WHEN S17 COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F RECORD: START <u>5:25 A</u> , TOTAL MIN <u>8</u>			
MISC	20	WEIGH IN PT FOR S35 SODIUM NITRITE M <u>9</u> , <u>33.36%</u>	<u>884</u>	725-A	295
	21	MEASURE <u>80</u> UNITS IN V-928 FOR S33 HYDROCHLORIC ACID M <u>2</u> , <u>31.01%</u>	<u>1200</u>	28-D	372
CV	22	RUN <u>15"</u> (1330G) WATER INTO V- <u>903</u>			
6	23	WEIGH IN V-926 SODIUM HYDROXIDE & RUN IN M <u>12</u> , <u>50.16%</u>	<u>897</u>	7-D	450
	24	DUMP IN FROM S3 LOT 3-HYDROXY-2- <u>147</u> NAPHTHOIC ACID	<u>810</u>	253-C	<u>810</u>
	25	WEIGH IN S35 SODIUM NITRITE WEIGH IN S33 HYDROCHLORIC ACID			
	26	ADJ TO 70-90 DEG F & STIR TO DISSOLVE			
	27	STEAM EJECT V-921/931 INTO CV			
922	28	WHEN S19 COMPLETE, SHUT OFF PUMP & INSERT V-922 FOOT PLUG			
7	29A	RUN IN 10" (207G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER.			
904	29B	PUMP V-922 THRU SPARKLER INTO V-904			
8					
922	30A	RUN IN 5" (103G) WATER INTO V-922 & HEAT TO 190-195 F. CIRCULATE 15 MIN THRU SPARKLER			
9					
904	30B	PUMP V-922 THRU SPARKLER INTO V-904			
10	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 <u>28°F</u> *F, " ICE	40X330	57-A	<u>18150</u>
	35	RUN IN N-725-A FROM S20 AFAP (5-10 MIN) & RINSE IN PT			
	36	STIR 30 MIN AT 28-35 DEG F MAINTAINING +CR, +KI FOR S41 AND RECORD: TIME START <u>10:00 AM</u> CR (+), KI (+) NOTE (1) IF CR-, KI-, ADD 20# AS IS IN- CREMENTS HYDROCHLORIC ACID ASSUME 32% RECORD: CR (+), KI (+) (2) IF CR+, KI-, ADD 20# AS IS INCREMENTS SODIUM NITRITE. ASSUME 33% RECORD: CR (+), KI (+)		28-A	
				725-A	

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 3 OF 3 CG 32 CODE RT-618-D (T)	USE LBS	N-CODE	ACCT LBS
CV 11	37	DUMP INTO CV BARIUM SULFATE	50	65-A	50
	38	ADJ TO 35° (3130C) AT 28-32°F ICE	33X330	57-A	6930
	39	RECORD: TEMP 25 DEG F & VOLUME			
	40	WEIGH IN FROM DRUM AMMONIUM CHLORIDE	212	165-A	212
	41	STIR 2-3 MIN			
	42	IMMEDIATELY COUPLE DV THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 45-60 MIN. MAINTAIN CV AT 28-32 DEG F. RECORD: START 10:55 TOTAL MIN 35		57-A	
	43	STIR 30 MIN & RECORD: BASE + (+), DIAZO - (-), PH 9.7 (9.0-9.8) FINAL TEMP DEG F			
	44	IF NECESSARY, ADJ TO PH 9.0-9.8 AND RECORD PH SODIUM HYDROXIDE ASSUME 50% HYDROCHLORIC ACID ASSUME 32%		7-D 28-D	
	45	HEAT TO 188-190 DEG F IN 65-70 MIN AND RECORD: HT DEG F & RECORDER 190 DEG F NOTE: AT 174-176 F, OPEN WATER SPRAY 1 1/4 TURNS			
902 12	46	RUN 24" (618G) WATER INTO V902	1440	16-B	1440
	47	TURN ON AGITATOR & STEAM & DUMP IN BARIUM CHLORIDE			
	48	HEAT TO 188-190°F & STIR TO DISSOLVE			
CV 13	49	WHEN S44 COMPLETE, IMMEDIATELY STRIKE V902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 7-10 MIN. MAINTAIN CV AT 188-190 DEG F. - (Rise to 195°F) 984			
	50	RECORD: START 1:55A TOTAL MIN 10			
	51	HEAT CV TO 198-202 DEG F IN 10-12 MIN			
	52	STIR 5 MIN AT 198-202 DEG F			
	53	FLOOD TO 180-190° (+/-17,000G)			
	54	RECORD: PH 5.6 (9.0-9.4) & STOP AGITATOR SHUT OFF WATER SPRAYS			
		START EIR OPTR 1:50 7:00 3:42 2:00AM 2:26PM 3:01			
		WHEN INSTRUCTED BY PROCESSING AREA HALF WAY THRU PRESSING, DUMP IN, STIR 5 MIN & STOP AGITATOR. RESUME PRESSING. I-OCTANOL	10	588-A	10

DELETED Re cloth SPANOR Reclaimed 3:15 AM

LOT L2H43

N-740 -C

CHECK-WEIGH & CALCULATE

[illegible]

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 24. \\
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 55 \overline{) 11440.0} \\
 \underline{110} \\
 340 \\
 \underline{330} \\
 100
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