

S.V.

C.V. 901, 903

D.V. 904

CG 32 CODE RT-618-D PKG.

→ OCT 3 80 37326

EST. WGT. 2902 LBS.

STD. HRS. 10.4 TIME

ZAM

928

PROCESSES		APPROVED BY	
() RT-618-D (S)		JJG 08-15-78	
() RT-657-P (F)		AMJ 09-19-78	
()	()		
()	()		
TYPED BY			
emw092078			

N740-C-Use any hat

NON-BLEEDING

EQUIPMENT	NAME: WATCHUNG® RED Y	USE LBS.	N CODE	ACCT. LBS.
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 11		740-C	
	3 Obtain for S 24		253-C	
	4 Install DV & CV Recorder & Controller charts			
921/931 2	5 Run 10" (100 G) water into V-921 & adj to 80-100°F	63	530-A	63
	6 Add in 1-2 min			
	7 Stir 2 min & Record: pH 10.0 (9.5-10.5)			
	8 Stir 20 min or longer for S 27			
922 3	9 Run 34" (700 G) water into V-922			
	10 Weigh in V-926 & run in M 11, 49.64% 405		7-D	201
	11 Turn on agitator & steam & dump in from S 2		740-C	1035
	Lot 103 100% 959 98.35 975			
	103 76 98.23 77			
	12 Dump in	50	113-B	50
	13 Dump in	10	777-A	10
	14 Heat to 212-214°F. Record: HT °F; °F WATCH FOAM			
	15 Record: BY (+), if necessary, adj to +BY Assume 50%		7-D	
	16 Stir 30 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: HT °F			
	& Recorder °F			
	Record: Start 8:25 PM Total Min 70 Clarity OA			
	NOTE: Sample from hose - show to Supervisor for OK			
904 4	18 Run 1" (50 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 8:55 PM Total Min 55			
Misc 5	20 Weigh in PT for S 35 M 11, 33.21% 1000		725-A	332
	21 Measure 85 1/4 units in V-928 for S 33 M 7, 31.62% 1325		28-D	419
CV 6	22 Run 16" (1530 G) water into V-901			
	23 Weigh in V-926 & run in M 11, 49.64% 1021		7-D	507
	24 Dump in from S 3 Lot 499 912		253-C	912
	25 Weigh on postal scale & dump in Lot 7 180 C 7			
	26 Adjust to 70-90°F & stir to dissolve			
	27 Steam eject V-921/931 into CV			

N37502

EQUIPMENT	PAGE	CG	32	CODE	RT-618-D (S)	EST. WGT.	2902	LBS.	USE	N	ACCT.
									LBS.	CODE	LBS.
922	28				When S 19 complete, shut off pump & insert V-922 foot plug						
7	29				Run in 12" (247 G) water & heat to 180-190°F						
904	30				Pump V-922 thru Sparkler into V-904						
8	31				When MTY blow out Sparkler into V-904						
	32				Heat to 165-170°F (Sample & show to Supervisor for OK)						
	33				Run in N-28-D from S 21 in 12-15 min & stir 5 min at 165-170°F						
	34				Adj to 129" (3409 G) at 28-30°F & Record: Temp °F			45	42 x 330	57-A	1480
	35				Run in N-725-A from S 20 AFAP (5-10 min)						
	36				Stir 30 min at 28-35°F maintain +CR, +KI for S 41						
					Record: Time Start 12:45 P.M. 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 (+) Temp °F						
CV	37				Dump into CV				180	65-A	180
9	38				Adj to 37" (3496 G) at 28-32°F			35	34 x 330	57-A	11550
					Record: Temp 29 °F Volume 38"						
	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°F					57-A	
					Record: Start 1:20 P.M. Total Min. 60						
	42				Stir 30 min & Record: Base + (+), Diazo - (-),						
					Final Temp 30 °F, pH 9.4 (9.0-9.8)						
	43				If necessary, adj to pH 9.0-9.8					7-D	
					& Record: pH					28-D	
	44				Heat to 184-186°F in 65-70 min &						
					Record: HT 184 °F & Recorder 186 °F						
DV	45				Run 12" (600 G) water into DV						
10	46				Turn on agitator & steam & dump in				1620	16-B	1620
	47				Heat to 155-160°F & stir to dissolve						
CV	48				When S 44 complete, immediately strike DV thru undersurface						
11					distributor into CV in 7-10 min. Maintain CV at 184-186°F						
					Record: Start 5:28 P.M. Total Min 8						
	49				Heat CV to 198-202°F in 10-12 min						
	50				Stir 5 min at 198-202°F						
	51				Flood to 180-190" (±18,000 G)						
	52				Record: pH 8.6 (9.0-9.4) & stop agitator						
					SAMPLES						
					START 7:00 P.M.						
					3:00 P.M.						
					FIN 3:00 P.M.						
					6:00 P.M.						
					OPTR 37						
					381						
					DELAYED WAITING FOR N-16 (75 MINS)						
					When instructed by Processing Area half way thru pressing,						
					dump in & stir 5 min & stop agitator. Resume pressing				10	588-A	10





