

S.V.

C.V. 901,903

D.V. 902,904

JPL

CG 32 CODE RT-880-D PKG ---

PROCESSES
() RT-880-D (G)APPROVED BY
EWK 12-31-81

OCT 29 1982

L2H79

(DATE)

(LOT NUMBER)

EST. WT. ~~2422~~ 2470 LBS.TYPED BY: JMH
STANDARD HRS. 9.3

TIME 7 A.M.

PREPARATION NOTES:

NON-BLEEDING

EQUIP MENT	NAME: WATCHUNG RED B	USE LBS	N-CODE	ACCT LBS
	NOTE: BATCH MUST BE PRESSED PROMPTLY TO CONTROL COLOR. DO NOT START IF PRESS WILL NOT BE AVAILABLE WITHIN 3 HRS AFTER MAKING. RECORD: PRESS WILL BE READY _____ M _____ PR SUPV START MAKING _____ M _____ / _____ MAKING SUPV			
	NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V-922			
	NOTE: RUN 15" WATER INTO V-904. PUMP WATER FROM V-904 THRU DISTRIBUTOR. IF WATER DOES NOT COME OUT OF ALL DISTRIBUTOR HOLES WITH FULL FORCE, NOTIFY SUPERVISOR			

PREP 1	RECORD: 5 BATCHES SINCE SPARKLER LAST CLEANED. AFTER 4 BATCHES, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15# DICALITE, FILTER AID		777-A	
2	OBTAIN FOR S11 2-CHLORO-4-AMINOTOLUENE-5- SULFONIC ACID		740-C	
3	OBTAIN FOR S27 3-HYDROXY-2-NAPHTHOIC ACID		82-C	
4	INSTALL DV & CV RECORDER & CONTROLLER CHART			

921/ 931 2	5 RUN 12" (120G) WATER INTO V-921 & ADJ TO 80-100 DEG F			
	6 ADD IN 2-3 MIN DRESINATE XX	115	99-A	115
	7 STIR 5 MIN & RECORD PH 10.1 (9.5-10.5)			
	8 STIR 20 MIN OR LONGER TO DISSOLVE FOR S36			

922 3	9 RUN 37" (762G) WATER INTO V-922			
	10 WEIGH IN SODIUM HYDROXIDE IN V-926 & RUN IN M 12 50.16 % 451		7-D	226
	11 TURN ON AGITATOR & STEAM & DUMP IN FROM S2		740-C	1157

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2-CHLORO	LOT 320	±100% 2.00	98.11	733
4-AMINO TOLUENE	321	457	98.30	465
5-SULFONIC ACID				

Check Weighs
Record on
attached
sheet

DATE PRINTED: 1/13/82

EQUIP MENT		PAGE 2 OF 4 CG 32 CODE RT-880-D (G)	USE LBS	N-CODE	ACCT LBS
922	12	DUMP IN ACTIVATED CARBON	25	113-B	25
3	13	DUMP IN FILTER AID	10	777-A	10
CONT.	14	HEAT TO 212-214 DEG F WATCH FOAM!!			
	15	RECORD: BY <u>+</u> MUST BE +, ADJ IF NECESSARY			
		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 <u>0</u> PSI. IF NOT ZERO NOTIFY			
		SUPERVISOR.			
	17	CIRCULATE 15 MIN OR LONGER THRU SPARKLER			
		UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195			
		DEG F FOR S24. RECORD: START <u>9:10</u>			
		TOTAL MIN <u>13</u> CLARITY <u>2nd</u>			
	18	RECORD: HT <u>215°F</u> F & REC <u>2:11</u> F			
MISC	19	WEIGH SODIUM NITRITE IN PT-1 FOR S45			
4		M <u>10</u> <u>32.76%</u>	<u>1145</u>	725-A	375
	20	WEIGH SODIUM NITRITE IN DRUM FOR S51			
		M <u>10</u> <u>32.76%</u>	<u>134</u>	725-A	44
	21	WEIGH SODIUM NITRITE IN DRUM FOR S52			
		M <u>10</u> <u>32.76%</u>	<u>134</u>	725-A	44
	22	MEASURE <u>66 3/4</u> UNITS IN V-928 FOR S42			
		HYDROCHLORIC ACID M <u>2</u> <u>31.01%</u>	<u>1796</u>	28-D	557
904/	23	RUN 1" (11G) WATER INTO V- <u>901</u>			
CV		NOTE USE CV IF MTY, IF CV NOT MTY USE V-904			
5	24	WHEN S18 IS COMPLETE, PUMP IN V-922 THRU			
<u>901</u>		SPARKLER, MAINTAIN V-922 AT 190-195 DEG F.			
		RECORD: START <u>9:00</u> TOTAL MIN <u>13</u>			
902	25	RUN 63" (1648G) WATER INTO V-902			
6	26	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN			
		M <u>12</u> <u>50.16%</u>	<u>943</u>	7-D	473
	27	DUMP IN FROM S3 LOT <u>8339</u>	<u>1058</u>	82-C	1058
		3-HYDROXY			
		2-NAPHTHOIC ACID			
	28	ADJ TO 70-90 DEG F & STIR TO DISSOLVE			
		<u>SAMPLE</u>			
922	29	WHEN S24 COMPLETE, SHUT OFF PUMP & INSERT			
7		V-922 FOOT-PLUG			
	30A	RUN IN 10" (209G) WATER & HEAT TO 190-195 F			
		CIRCULATE 15 MIN THRU SPARKLER.			
		CIRCULATE 15 MIN THRU SPARKLER.			
904/CV	30B	PUMP V-922 THRU SPARKLER INTO V-904/CV			
8					
922	30C	RUN IN 5" (104G) WATER & HEAT TO 190-195 F			
9		CIRCULATE 15 MIN THRU SPARKLER.			
904/CV	31	PUMP V-922 THRU SPARKLER INTO V-904/CV			
10	32	WHEN MTY BLOW OUT SPARKLER INTO V-904/CV			

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EQUIP MENT		PAGE 3 OF 4 CG 32 CODE RT-880-D (G)	USE LBS	N-CODE	ACCT LBS
904/CV 10 CONT	33	DISSOLVE ALKANOL XC IN 20G WATER AT 135-145 F F WATER FROM HOT WATER MIXER IN DRUM & POUR IN	32	133-B	32
	34	HEAT V-904/CV TO 165-170 F FOR S41			
902 11	35	WHEN S28 COMPLETE, MEASURE TRISULPHOIL SOAP D IN CALIBRATED CONTAINER, SLURRY WITH 46G WATER IN DRUM & POUR INTO V-902	105	39-A	105
	36	STEAM EJECT IN V-921/931 FROM S8			
PT-2 12	37	RUN SODIUM HYDROXIDE INTO PT M 12 50.16% 263		7-D	132
	38	ADJ TO 20° (72G)			
	39	STIR 5 MIN OR LONGER FOR S57			

NOTE: IF N-740-C SOLUTION WAS PUMPED
DIRECTLY FROM SPARKLER TO CV AT
S'S 23 & 24, OMIT S'S 40 & 41

CV 13	40	RUN 1" (95G) WATER INTO V			
	41	IF V-904 IS USED, PUMP V-904 AT 165-170 F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (12-15 MIN) MAINTAIN 165-170 DEG F			
	42	RECORD: START TOTAL MIN.			
	43	RUN IN N-28-D HYDROCHLORIC ACID FROM S22 IN 12-15 MIN.			
	44	STIR 5 MIN			
	45	ADJ TO 45° (4252°) AT 32-38 DEG F	7X330	57-A	16.500
	46	RECORD: TEMP 31 F, STICK			
	47	RUN IN N-725-A SODIUM NITRITE FROM S19 AFAP (5-10 MIN) & RINSE IN			
	48	STIR 20 MIN AT 32-38 F MAINTAINING +CR, +KI FOR S54 RECORD: TIME START		57-A	
	49	CR + (+) KI + (+) NOTE:			
	50	1) IF CR-, KI-, ADD 20# "AS IS" INCREMENTS RECORD: CR (+) KI (+)		28-D	
	51	HYDROCHLORIC ACID ASSUME 32%			
	52	2) IF CR+, KI-, ADD 20# "AS IS" INCREMENTS RECORD: CR (+) KI (+)			
	53	SODIUM NITRITE ASSUME 33%		725-A	
	54	DUMP IN CALCIUM CHLORIDE	1166	20-A	1166
	55	DUMP IN STRONTIUM NITRATE	255	246-B, E	255
	56	DUMP IN STRONTIUM NITRATE	255	246-B, E	255
	57	ADD FOR MAINTAINING AT 32-38 DEG F DURING COUPLING	27X330	57-A	82320
	58	POUR IN N-725-A SODIUM NITRITE FROM S20			
902	59	POUR N-725-A SODIUM NITRITE FROM S21 INTO V-902			
14	60	DUMP IN AMMONIUM CHLORIDE & STIR 2-3 MIN	228	165-A	228
CV 15	61	IMMEDIATELY COUPLE 902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN. MAINTAIN CV AT 32-38 DEG F. RECORD: START 2:29:37 PM TOATL MIN. 2:29:37 PM			
	62	INSTALL 5/16" ORIFICE IN UNDERSURFACE ADDITION LINE			
	63	WHEN S54 COMPLETE, STIR 30 MIN & RECORD: BASE (+) DIAZO (+) PH 4.6 (5.0-6.0)			

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EQUIP MENT		PAGE 4 OF 4 CG 32 CODE RT-880-D (G)	USE LBS	N-CODE	ACCT LBS
CV	57	RUN IN N-7-D FROM S39 THRU 5/16" ORIFICE			
15		& RINSE IN RECORD: MIN (40-50 MIN)			
CONT	58	STIR 20 MIN & RECORD: PH <u>6.4</u> (7.0-8.5)			
	59	IF PH BELOW 7.0 ADJ TO PH 7.0-8.5 WITH			
		N-7-D ONLY. RECORD PH <u>7.8</u> ASSUME 50%	<u>40</u>	7-D	<u>20</u>
	60	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN			
		ASSUME 50%	110	7-D	55
	61	STIR 15 MIN & RECORD: BASE <u>+</u> (+)			
		DIAZO <u>-</u> (-) PH <u>9.5</u> (9.0-9.8)			
	62	IF PH BELOW 9.0 ADJ TO PH 9.0-9.8 WITH			
		N-7-D ONLY. RECORD PH <u>-</u>		7-D	
		SODIUM HYDROXIDE ASSUME 50%			
	63	MEASURE I OCTANOL IN CALIBRATED CONTAINER			
		& POUR IN	37	588-A	37
	64	HEAT TO 193-195 DEG F IN 75-80 MIN. RECORD			
		START <u>6 PM</u>			
	65	RECORD: HT <u>186</u> DEG F & REC <u>196</u> DEG F			
	66	STIR 60 MIN AT 193-195 DEG F. RECORD:			
		START <u>7:15</u>			
	67	AFTER 20 MIN S66 STIR RECORD:			
		PH <u>8.2</u> (8.8-9.3)			
	68	IF PH BELOW 8.8, ADJ TO PH 8.8-9.3 WITH			
		N-7-D ONLY. RECORD PH <u>8.8</u>			
		SODIUM HYDROXIDE ASSUME 50%	<u>100</u>	<u>7-D</u>	<u>50</u>
	69	WHEN S66 COMPLETE, FLOOD TO 180-190"			
		(17-18,000G)			
	70	STOP AGITATOR			

WHEN INSTRUCTED BY PROCESSING AREA HALFWAY
THRU PRESSING
(1) DUMP IN I OCTANOL
(2) STIR 5 MIN
(3) ADVISE PROCESSING TO RESUME PRESSING

START

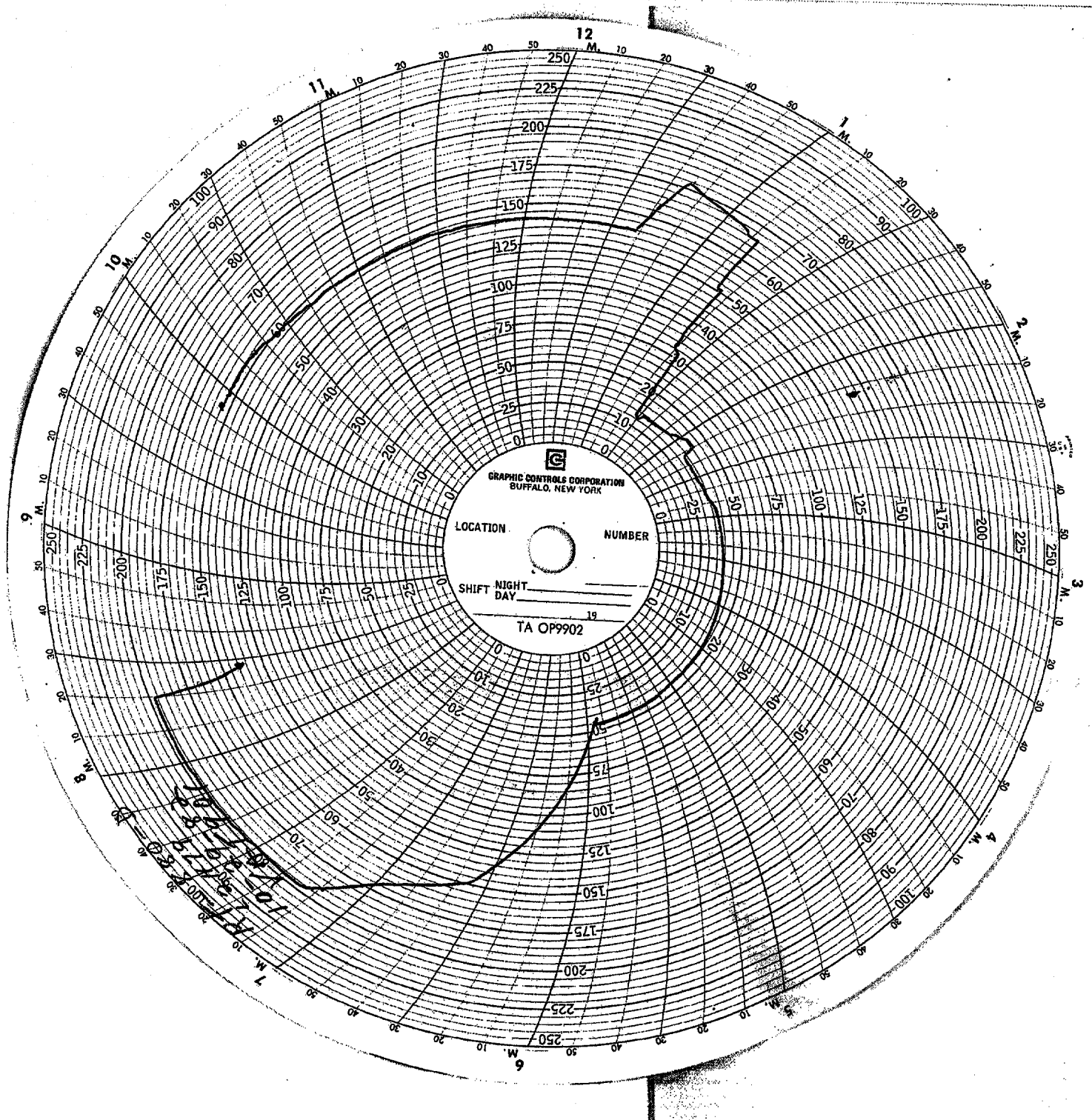
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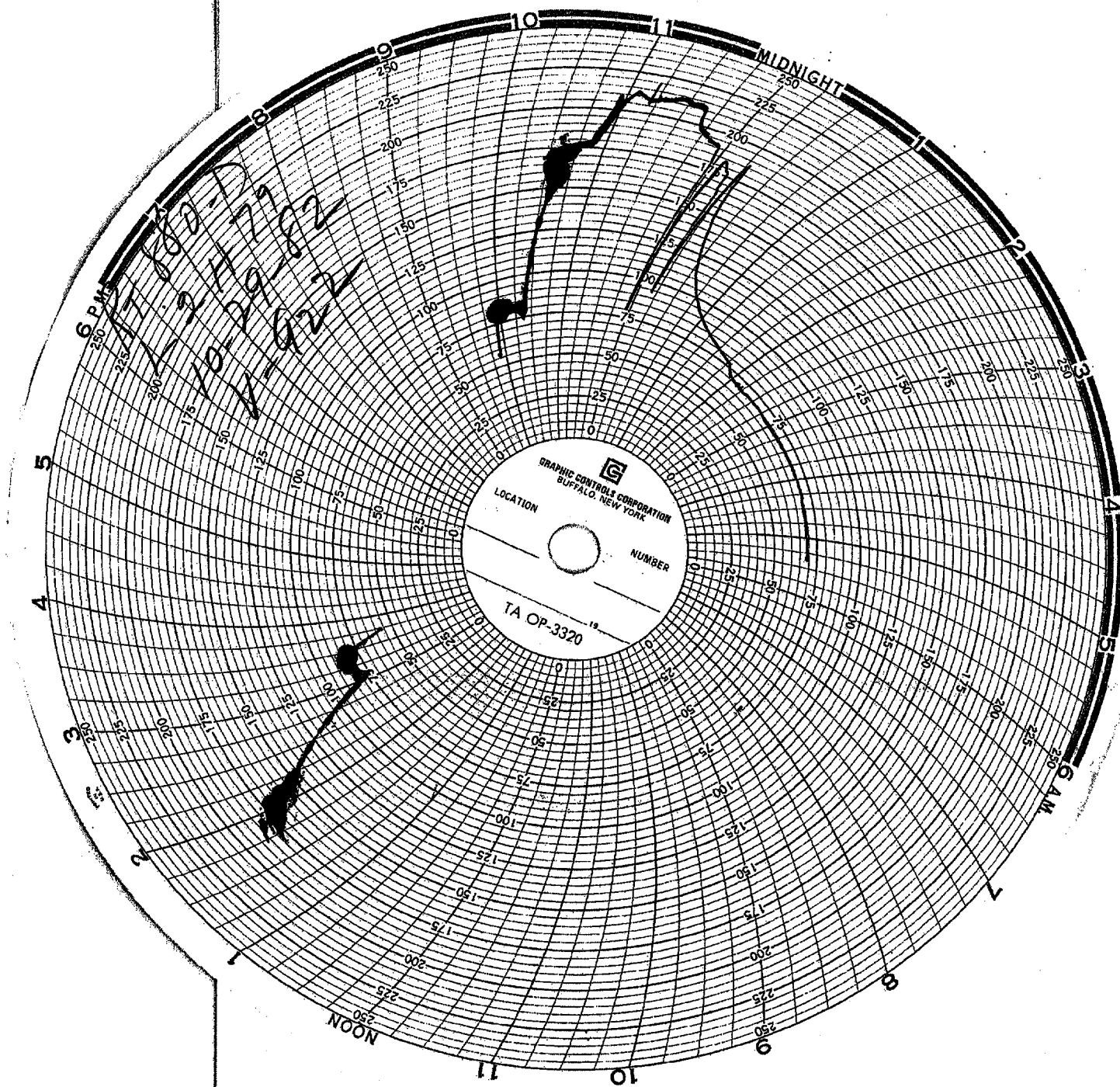
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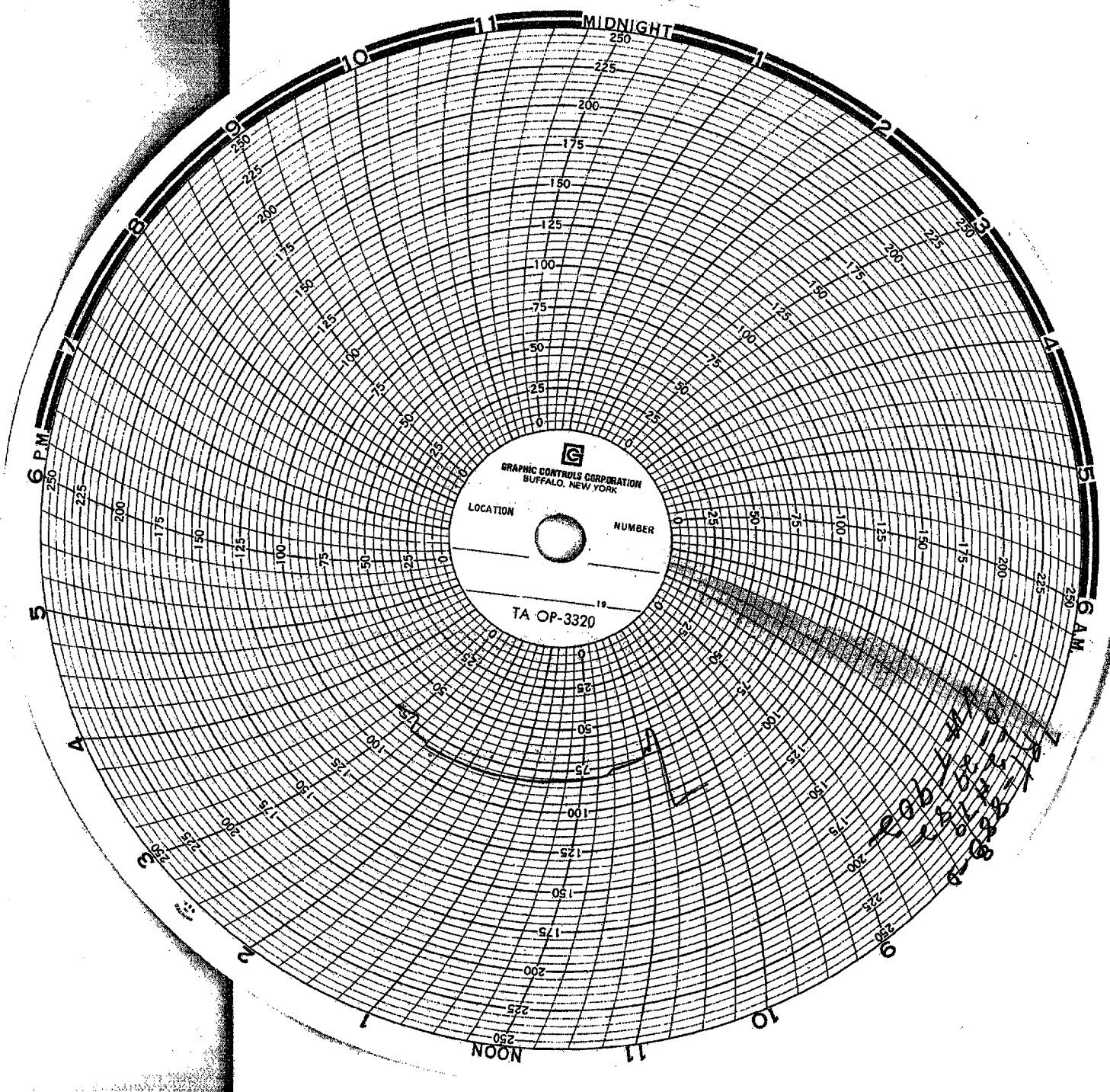
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N-740 - C CHECK-WEIGH & CALCULATE

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3.46