CG 32 CODE RT-870-D PKG ___ PROCESSES ( ) RT-870-D (K) APPROVED BY: EWK 01/11/82

OCT 18 1982 K2K69 2394 LBS.
(DATE) (LOT) (EST WT) COMTYP JOB NAME: 32RT870DMK

STANDARD HRS. _____ TIME 7 A.M.

PREPARATION NOTES: _____

NON-BLEEDING

EQUIPMENT		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. SUPV TO REVIEW WITH P.R. SUPV & 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.	OK to continue & Tim		
PREP 1	1	RECORD:_____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/ [redacted] 2	5	RUN 11" (110G) WATER INTO V-921 & ADJ TO 80-100 DEG F			
	6	ADD IN 2-3 MIN DRESINATE X	108	530-A	108
	7	STIR 5 MIN & RECORD PH 9.8 (9.5-10.5)			
	8	STIR 20 MIN OR LONGER TO DISSOLVE FOR S44			
922 3	9	RUN 35" (722G) WATER INTO V-922			
	10	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M 12, 50.16 %	403	7-D	202
	11	TURN ON AGITATOR & STEAM & DUMP IN FROM S2		740-C	1035
		2-CHLORO LOT #100% %	223		
		4-AMINOTOLUENE 314 / 322 — 220 / 50 — 98.45 / 98.52	51		
		5-SULFONIC 282 — 651 — 98.62	661		
		ACID 284 — 114 — 98.57	116		
	12	DUMP IN ACTIVATED CARBON	25	113-B	25
	13	DUMP IN FILTER AID	10	777-A	10
	14	HEAT TO 212-214 DEG F WATCH FOAM!!			
	15	RECORD: BY 1 (+) 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 0 PSI. IF NOT ZERO NOTIFY SUPERVISOR.			

Check-Weigh w/ Record on back page

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LOT= _____ _ COMTYP JOB NAME = 32RT870DMK PAGE 02 DATE PRINTED: 9/11/82

EQUIPMENT			USE LBS	N-CODE	ACCT LBS
		PAGE 2 OF 4 CG 32 CODE RT-870-D (K)			
922 3 CONT	17	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 DEG F FOR S21. RECORD: START 220 TOTAL MIN 15 CLARITY 0/ HT _____ F & REC 202 F			
CV 4	18	RUN 8* (710 G) WATER INTO V 901			
MISC 5	19	MEASURE 95 1/2 UNITS IN V 928 FOR S38A HYDROCHLORIC ACID M 2 31.01 %	1609	28-D	499
904/CV 6	20	RUN 2* (58G) WATER INTO V-904/CV			
	21	WHEN S17 IS COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F. RECORD: START 1:25AM TOTAL MIN 60			
MISC 7	22	WEIGH SODIUM NITRITE IN PT FOR S39 M 9 33.36 %	1010	725-A	337
922 8	23	WHEN S 21 COMPLETE, SHUT OFF PUMP & INSERT V-922 FOOTPLUG			
	24A	RUN IN 10* (209G) WATER & HEAT TO 190-195 F			
	24B	CIRCULATE 15 MIN THRU SPARKLER AND PUMP V-922 THRU SPARKLER INTO V-904/CV			
902 9	25	RUN 85* (1696 G) WATER INTO V-902			
	26	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M 12 .5016 %	935	7-D	468
	27	DUMP IN FROM S 3 3-HYDROXY-2-NAPHTHOIC ACID LOT 8294 Check Weight & Release on back Page	930	82-C	930
	27A	WEIGH 1-HYDROXY-2-NAPHTHOIC ACID ON POSTAL SCALE & DUMP IN LOT 10713	16	180-C	16
	27B	ADJ. TO 70-90*F & STIR TO DISSOLVE			
922 10	28	RUN IN 5* (104G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904/CV 11	29	PUMP V-922 THRU SPARKLER INTO V-904/CV			
	30	WHEN MTY BLOW OUT SPARKLER INTO V-904/CV			
	31	DISSOLVE ALKONOL XC IN 20G WATER AT 150-160 F FROM HOT WATER MIXER IN DRUM & POUR IN	5	133-B	5
	32	HEAT TO 165-170 F FOR S37			
922 12	33	RUN 34* (329G) WATER INTO V-932 & ADJ TO 80-100 DEG F.			
	34	ADD IN 6-7 MIN DRESINATE X		530-A	
	35	STIR 5 MIN & RECORD PH 10.2 (9.5-10.5)	319		319
	36	STIR 20 MIN OR LONGER TO DISSOLVE FOR S52			

DUP050102090

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EQUIPMENT		PAGE 3 OF 4 CG 32 CODE RT-870-D (K)	USE LBS	N-CODE	ACCT LBS
		NOTE: IF N-740-C SOL'N WAS PUMPED DIRECTLY FROM SPARKLER TO CV OMIT S37.			
CV 11	37	WHEN S 32 COMPLETE, PUMP V 904 AT 165-170 DEG F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (12-15 MIN) RECORD: START_____ TOTAL MIN._____			
	38A	RUN IN N-28-D HYDROCHLORIC ACID FROM S19 AFAP IN 12-15 MIN MAINTAIN CV AT 165-170*F	45		
	38B	ADJ TO 43° (4080G) AT 32-38DEG F (28°F) RECORD: STICK_____°	X330	57-A	14850
	39	RUN IN N-725-A SODIUM NITRITE FROM S22 AFAP (5-10 MIN) & RINSE IN PT			
	40	STIR 10 MIN AT 32-38 DEG F MAINTAINING KI SODIUM NITRITE M 9 3.326 %		725-A	
	41	RECORD: KI 1 (+)			
	42	DUMP IN CALCIUM CHLORIDE	972	20-A	972
	43	DUMP IN STRONTIUM NITRATE	65	246-B,E	65
902 14	44	WHEN S28 COMPLETE, STEAM EJECT V-921/ FROM S8 INTO V-902			
	45	DUMP IN AMMONIUM CHLORIDE	204	165-A	204
CV 15	46	IMMEDIATELY COUPLE V-902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN, LET TEMP RISE FREELY RECORD: START 2:10 PM TOTAL MIN 20 M.N.			
PT 16	47	WHILE COUPLING S 46 WEIGH SODIUM HYDROXIDE IN PT M 12 50.16 %	267	7-D	134
	48	DILUTE TO MAXIMUM VOLUME (+,-100G) FOR S 50			
CV 17	49	WHEN S46 COMPLETE, STIR 5 MIN & RECORD: DIAZO + (+) BASE + (+) PH 4.43 (5.0-6.0) TEMP 60 (50-60 F)			
	50	RUN IN PT FROM S48 THRU UNDERSURFACE LINE, RINSE IN PT AND STIR 15 MIN.			
	51	RECORD: DIAZO — (+) BASE + (+) PH 9.25 (9.0-9.8)			
	52	STEAM EJECT IN V-932 FROM S36			
	53	STIR 5 MIN & RECORD: PH 9.2 (9.0-9.8)			
	54	IF PH BELOW 9.0 ADJ TO PH 9.0-9.8 WITH N-7-D ONLY. RECORD PH_____			
		SODIUM HYDROXIDE ASSUME 50%		7-D	
	55	MEASURE I OCTANOL IN CALIBRATED CONTAINER & POUR IN	38	588-A	38
	56	HEAT TO 193-195 DEG F IN 70-75 MIN & RECORD HT 194 DEG F AND REC 195 DEG F			
	57	STIR 60 MIN AT 193-195 DEG F. RECORD: START 4:30 PM			

DUP050102091

EQUIPMENT		PAGE 4 OF 4 CG 32 CODE RT-870-D (K)	USE LBS	N-CODE	ACCT LBS
CV 15 CONT.	~~58~~	AFTER 20 MIN S57 STIR, RECORD: PH 8.4 (8.8-9.3)			
		IF PH BELOW 8.8, ADJ TO PH 8.8-9.3 WITH N-7-D ONLY. RECORD PH 8.9 SODIUM HYDROXIDE RECORD PH _____ ASSUME 50%	60	7-D	30
	~~59~~	AFTER S 57 STIR, FLOOD TO 180-190* (+,-18,000 G) & STOP AGITATOR			
		WHEN INSTRUCTED BY PROCESSING HALFWAY THRU PRESSING			
		1) DUMP IN I OCTANOL	10	588-A	10
		2) STIR 5 MIN.			
		3) ADVISE PROCESSING TO RESUME PRESSING			

START	FIN	OPTR
1000	5004	126
3:00 PM	8:50 PM	320

N-7-D For VAT 922

Weighed up 408# on CAUSTIC Scale

Check weighed into DRUM

And got A TOTAL of 352#

Added 51# To make weight

Required.

N-7-D For VAT. 902

weighed up 933# on CAUSTIC Scale

Check weighed into DRUM AS Follows

252# G 47 TARE = 205# net

261# G " " = 214# net

255# G " " = 208# net

274# G " " = 227# net

70# G. " " = 23#

ADDed 56 # to make weight

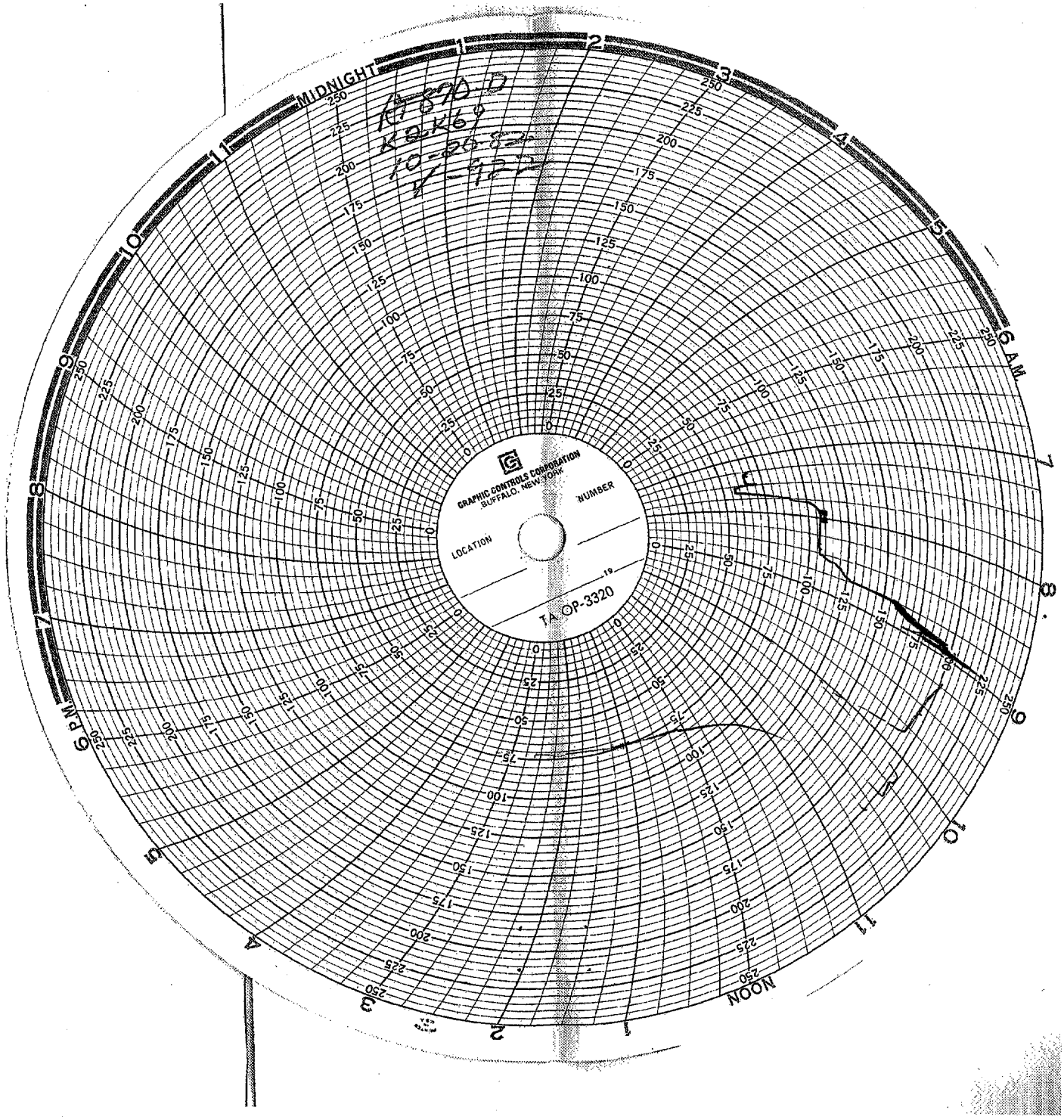
DUP050102093

CODE: AT-870 LOT K2K69

N- 740 -C CHECK-WEIGH & CALCULATE

DRUM STENCILED					NEWARK CHECK-WEIGH				
LOT	GROSS	TARE	Net	%	GROSS	TARE	NET		#/100%
3[illegible]	243	STEAM		98.45	243	20	223	X % AS DECIMAL	220
[illegible]	71			98.52	71	20	51		50
282	351		325	98.62	351	19	332		327
282	348		325	98.62	348	19	329		324
284	351	[illegible]	-	98.57	351	[illegible]	116		114
Total WT									1035
N- 82 -C									
5294	266	16	250		267	15	252		
5294	266	16	250		268	16	252		
[illegible]	266	16	250		268	16	252		
[illegible]		STEAM					173		
							930		

DUP050102094



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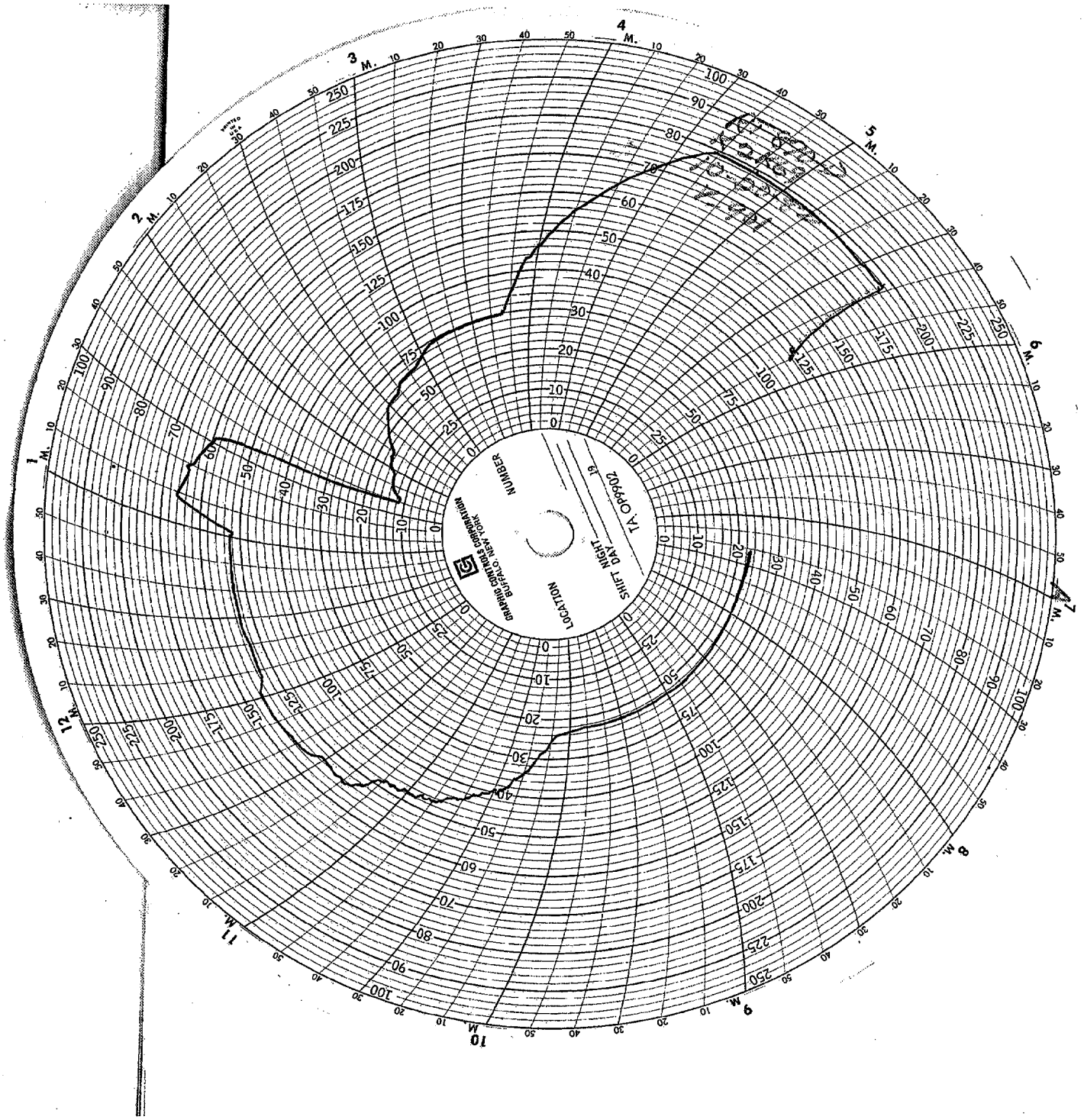

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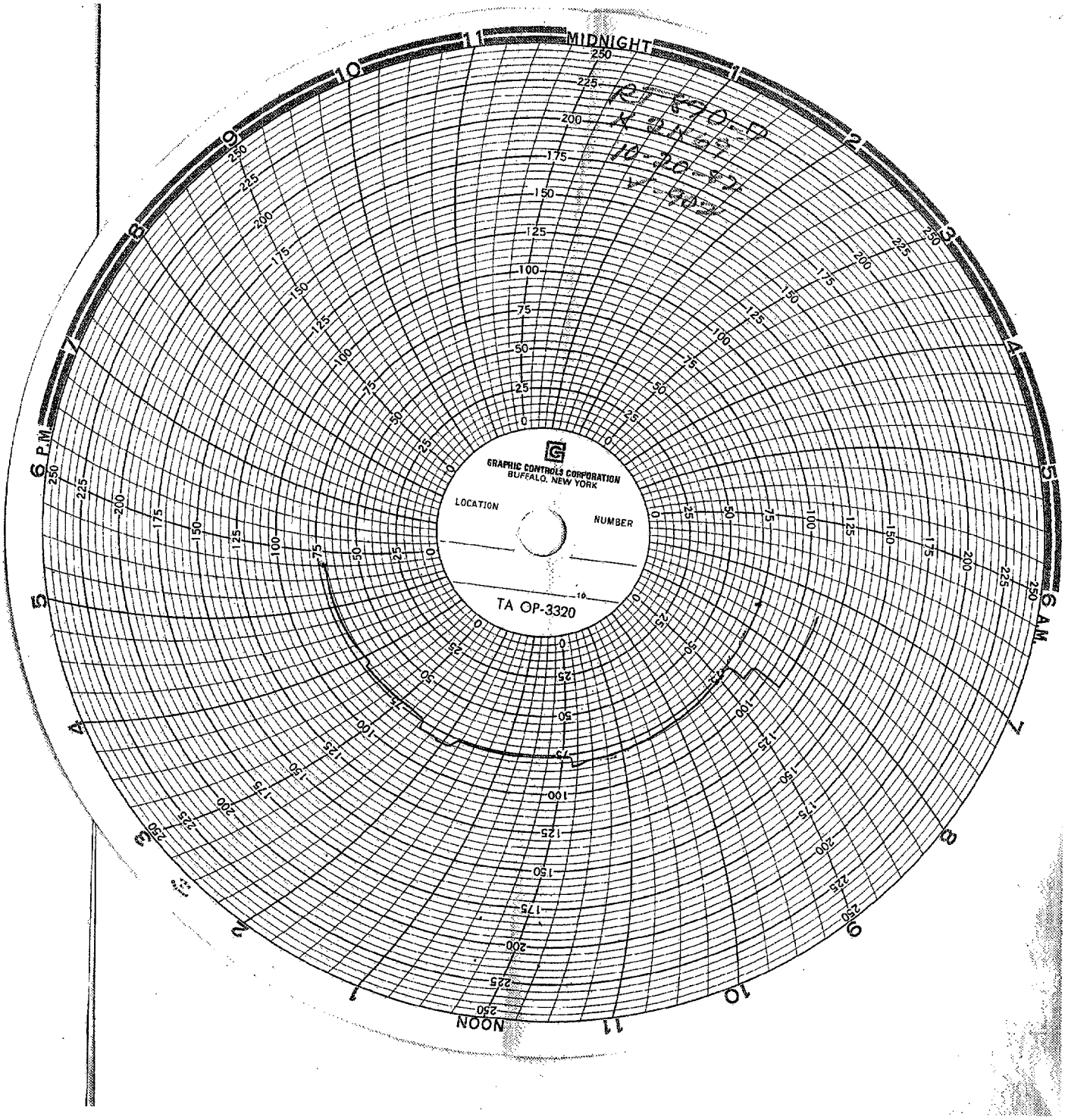

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