

CG 32 CODE RT-880-D PKG.

→ JUL 3 '80 36382

EST. WGT. 1921 LBS.

STD. HRS. TIME 7A M

| PROCESSES    |     | APPROVED BY  |  |
|--------------|-----|--------------|--|
| ( ) RT-880-D | (E) | JJG 08-16-78 |  |
| ( )          | ( ) | AMJ 01-22-79 |  |
| ( )          | ( ) |              |  |
| ( )          | ( ) |              |  |
| TYPED BY     |     |              |  |
| emw020679    |     |              |  |

If short N1-C, make up with  
N82-C or N252C

PUNCHED &amp; CHECKED

JUL - 3 1980

NON-BLEEDING

| QUIPMENT | NAME: WATCHUNG® RED B                                                                                                                                                                                                   | USE LBS.   | N CODE | ACCT. LBS. |
|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|--------|------------|
|          | NOTE: Batch must be pressed promptly to control color.<br>Do not start if press will not be available within<br>3 hrs after making. Record:<br>Press will be ready M 1 P R Supv<br>Start Making 9:12 M 7:13 Making Supv |            |        |            |
| Prep 1   | 1. Record: 1 batches since Sparkler last cleaned. After 5<br>batches, clean, dress Sparkler & pre-coat with 15#                                                                                                         |            | 777-A  |            |
|          | 2. Obtain for S 11                                                                                                                                                                                                      |            | 740-C  |            |
|          | 3. Obtain for S 27                                                                                                                                                                                                      |            | 82-C   |            |
|          | 4. Install CV & DV Recorder & Controller charts                                                                                                                                                                         |            |        |            |
| 921/922  | 5. Run 8" (80 G) water into V- 921 & adj to 80-100°F                                                                                                                                                                    |            |        |            |
| 2        | 6. Add in 2-3 min                                                                                                                                                                                                       | 80         | 99-A   | 80         |
|          | 7. Stir 5 min & Record: pH 10.0 (9.5-10.5)                                                                                                                                                                              |            |        |            |
|          | 8. Stir 20 min or longer to dissolve for S 36                                                                                                                                                                           |            |        |            |
| 922      | 9. Run 28" (578 G) water into V-922                                                                                                                                                                                     |            |        |            |
| 3        | 10. Weigh in V-926 & run in M 4, 48.97%                                                                                                                                                                                 | 337        | 7-D    | 165        |
|          | 11. Turn on agitator & steam & dump in from S 2                                                                                                                                                                         |            | 740-C  | 843        |
|          | Lot #100%<br>56 123 98.23%<br>64 720 98.55%                                                                                                                                                                             | 123<br>730 |        |            |
|          | 12. Dump in                                                                                                                                                                                                             | 25         | 113-B  | 25         |
|          | 13. Dump in                                                                                                                                                                                                             | 10         | 777-A  | 10         |
|          | 14. Heat to 212-214°F WATCH FOAM                                                                                                                                                                                        |            |        |            |
|          | 15. Record: BY + must be + 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.<br>Maintain at 190-195°F for S 24                                                                                                                    |            |        |            |
|          | Record: Start 11:20 AM, Total Min 15, Clarity ok                                                                                                                                                                        |            |        |            |
|          | 18. Record: HT, 73 OF & Rec 93 OF                                                                                                                                                                                       |            |        |            |
| Misc 4   | 19. Weigh in PT-1 for S 45 M 8, 33.62%                                                                                                                                                                                  | 815        | 725-A  | 274        |
|          | 20. Weigh in drum for S 51 M 8, 33.62%                                                                                                                                                                                  | 95         | 725-A  | 32         |
|          | 21. Weigh in drum for S 52 M 8, 33.62%                                                                                                                                                                                  | 95         | 725-A  | 32         |
|          | 22. Measure 843 units in V-928 for S 42 M 6, 30.85%                                                                                                                                                                     | 1316       | 28-D   | 406        |
| 924/CV 5 | 23. Run in 1" ( G) water into V- 923                                                                                                                                                                                    |            |        |            |
|          | NOTE: Use CV if MTY. If CV is not MTY, use V-924                                                                                                                                                                        |            |        |            |
|          | 24. When S 18 is complete, dump V-922 thru Sparkler, Maintain<br>V-922 at 190-195°F                                                                                                                                     |            |        |            |
|          | Record: Start 1:35 PM, Total Min 25                                                                                                                                                                                     |            |        |            |

V 903

| EQUIPMENT |    | PAGE 2 CG 32 CODE RT-880-D (E) EST. WGT.                                                                                | 1921 LBS.   | USE LBS. | N CODE | ACCT. LBS. |
|-----------|----|-------------------------------------------------------------------------------------------------------------------------|-------------|----------|--------|------------|
| 902       | 25 | Run 48" (1257 G) water into V-902                                                                                       |             |          |        |            |
| 6         | 26 | Weigh in V-926 & run in                                                                                                 | M 4. 48.97% | 704      | 7-D    | 345        |
|           | 27 | Dump in from S 3                                                                                                        | Lot 70      | 658      | 1-C    | 345        |
|           |    |                                                                                                                         | 2600        | 113      | 2520   | 113        |
|           | 28 | Adj to 70-90°F & stir to dissolve                                                                                       |             |          |        |            |
| 922       | 29 | When S-24 complete, shut off pump & insert V-922 foot-plug                                                              |             |          |        |            |
| 7         | 30 | Run in 12" (247 G) water & heat to 180-190°F                                                                            |             |          |        |            |
| 902/CV    | 31 | Pump V-922 thru Sparkler into V-902/CV                                                                                  |             |          |        |            |
| 8         | 32 | When MTX blow out Sparkler into V-902/CV                                                                                |             |          |        |            |
|           | 33 | Dissolve in 20 G water at 150-160°F in drum & pour in                                                                   |             | 24       | 133-B  | 24         |
|           | 34 | Heat V-902/CV to 165-170°F for S 40                                                                                     |             |          |        |            |
| 902       | 35 | When S 28 complete, measure in calibrated container,                                                                    |             | 76       | 39-A   | 76         |
| 9         |    | slurry with 46 G water in drum & pour into V-902                                                                        |             |          |        |            |
|           | 36 | Steam eject in V-921/902 from S 8                                                                                       |             |          |        |            |
| PT-2      | 37 | Run into PT-2                                                                                                           | M 4. 48.97% | 196      | 7-D    | 96         |
| 10        | 38 | Adj to 15" (54 G)                                                                                                       |             |          |        |            |
|           | 39 | Stir 5 min or longer for S 57                                                                                           |             |          |        |            |
|           |    | NOTE: If N-740-C solution was pumped directly from Sparkler to CV at S 23 & 24, omit S 40 & 41                          |             |          |        |            |
| CV        | 40 | Run 1" (95 G) water into V- 903                                                                                         |             |          |        |            |
| 11        | 41 | If V-904 is used, pump V-904 at 165-170°F thru undersurface distributor into CV A F A P (12-15 min). Maintain 165-170°F |             |          |        |            |
|           |    | Record: Start , Total Min                                                                                               |             |          |        |            |
|           | 42 | Run in N-28-D from S 22 in 12-15 min                                                                                    |             |          |        |            |
|           | 43 | Stir 5 min                                                                                                              |             |          |        |            |
|           | 44 | Adj to 34" (3264 G) at 32-38°F                                                                                          | 40          | 26 x 330 | 57-A   | 13200      |
|           |    | Record: Temp 32°F, Stick 37"                                                                                            |             |          |        |            |
|           | 45 | Run in N-725-A from S 19 A F A P (5-10 min)                                                                             |             |          |        |            |
|           | 46 | Stir 10 min at 32-38°F maintaining +CR, +KI for S 54                                                                    |             |          |        |            |
|           |    | Record: Time Start , 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 (+)                                                                                                  |             |          |        |            |
|           | 47 | Dump in                                                                                                                 |             | 850      | 20-A   | 850        |
|           | 48 | Dump in                                                                                                                 |             | 186      | 246-E  | 186        |
|           | 49 | Dump in                                                                                                                 |             | 40       | 65-A   | 40         |
|           | 50 | Add for maintaining at 32-38°F during coupling                                                                          | 30          | 29 x 330 | 57-A   | 9900       |
|           | 51 | Pour in N-725-A from S 20                                                                                               |             |          |        |            |
| 902       | 52 | Pour N-725-A from S 21 into V-902                                                                                       |             |          |        |            |
| 12        | 53 | Dump in & stir 2-3 min                                                                                                  |             | 156      | 165-A  | 156        |
| CV        | 54 | Immediately couple 902 thru undersurface distributor into CV                                                            |             |          |        |            |
| 13        |    | in 18-22 min. Maintain CV at 32-38°F                                                                                    |             |          |        |            |
|           |    | Record: Start 5:41:10 Total Min 22                                                                                      |             |          |        |            |
|           | 55 | Install 5/16" orifice in undersurface addition line                                                                     |             |          |        |            |
|           | 56 | When S 54 complete, stir 5 min &                                                                                        |             |          |        |            |
|           |    | Record: Base + (+), Diazo + (+), pH 4.9 (5.0-6.0)                                                                       |             |          |        |            |

| EQUIPMENT | "  | PAGE 3 CG 32 CODE RT-880-D (E) EST. WGT.                       | 1921 LBS.               | USE LBS.    | N CODE | ACCT. LBS. |
|-----------|----|----------------------------------------------------------------|-------------------------|-------------|--------|------------|
| CV        | 57 | Run in N-7-D from S 39 thru 5/16" orifice                      |                         |             |        |            |
| 13        |    | Record: 50 Min (40-50 min)                                     |                         |             |        |            |
| cont'd    | 58 | Stir 10 min & Record: pH 6.9 (7.0-8.5)                         |                         |             |        |            |
|           | 59 | If pH below 7.0 adj to pH 7.0-8.5 with N-7-D only Assume 50%   | 20                      | 7-D         | 10     |            |
|           |    | Record: pH 7.3                                                 |                         |             |        |            |
|           | 60 | Weigh in V-926 & run in Assume 50%                             | 80                      | 7-D         | 40     |            |
|           | 61 | Stir 5 min & Record: Base + (+), Diazo - (-), pH 8.8 (9.0-9.8) |                         |             |        |            |
|           | 62 | If pH below 9.0, adj to pH 9.0-9.8 with N-7-D only Assume 50%  | 50                      | 7-D         | 25     |            |
|           |    | Record: pH 7.7                                                 |                         |             |        |            |
|           | 63 | Measure in calibrated container & pour in                      | 28                      | 588-A       | 28     |            |
|           | 64 | Heat to 193-195°F in 75-80 min Record: Start 7:15 PM           |                         |             |        |            |
|           | 65 | Record: HT 175 OF & Rec 175 OF                                 |                         |             |        |            |
|           | 66 | Stir 60 min at 193-195°F Record: Start 9:15 PM                 |                         |             |        |            |
|           | 67 | After 20 min S 66 stir Record: pH 7.0 (8.9-9.3)                |                         |             |        |            |
|           | 68 | If pH below 8.8, adj to pH 8.8-9.3 with N-7-D only Assume 50%  |                         | 7-D         |        |            |
|           |    | Record: pH                                                     |                         |             |        |            |
|           | 69 | When S 66 complete, flood to 180-190" (±18,000 G)              |                         |             |        |            |
|           | 70 | Stop agitator                                                  |                         |             |        |            |
|           |    | When instructed by Processing Area half-way thru pressing      |                         |             |        |            |
|           |    | 1. Dump in                                                     | 10                      | 588-A       | 10     |            |
|           |    | 2. Stir 5 min                                                  |                         |             |        |            |
|           |    | 3. Advise Processing to resume pressing                        |                         |             |        |            |
|           |    | START 10:15 AM 3:00 PM                                         | FINISH 2:00 PM 10:30 PM | OPTR 407 27 |        |            |





