

CG 32

CODE RT-870-D

PKG

PROCESSES

APPROVED BY

OCT 15 1982

K2K67

2504

() RT-870-D (H)

EWK 1-11-82

COMTYP JOB NAME: 32RT870DMH

TYPED BY: JMH

(DATE)

(LOT)

(EST WGT)

STANDARD HRS. _____

TIME 7 A.M.

PREPARATION NOTES:

BOLL OVER
INSTRUMENT MALFUNCTION

NON-BLEEDING

EQUIP MENT	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.				
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 & DV RECORDER & CONTROLLER CHART			
921/ 2	5	RUN 11" (100G) 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 <u>10.1</u> (9.5-10.5)			
	8	STIR 20 MIN OR LONGER TO DISSOLVE FOR S49			
922 3	9	RUN 35" (722G) WATER INTO V-922			
	10	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M <u>12</u> , <u>50.16</u> %	104 423	7-D	52
	11	TURN ON AGITATOR & STEAM & DUMP IN FROM S2		7-D	212
	12	2-CHLORO- LOT $\pm 100\%$		740-C	1086
	13	4-AMINOTOLUENE <u>286</u> <u>286</u> <u>98.5</u> <u>290</u>		740-C	267
	14	5-SULFONIC <u>322</u> <u>31</u> <u>98.5</u> <u>32</u>			
	15	ACID <u>314</u> <u>749</u> <u>98.5</u> <u>761</u>			
	16	DUMP IN ACTIVATED CARBON	25	113-B	25
	17	DUMP IN FILTER AID	10	777-A	10
	18	HEAT TO 212-214 DEG F WATCH FOAM!!			
	19	RECORD: BY <u>+</u> (+) IF NECESSARY ADJ TO +BY SODIUM HYDROXIDE ASSUME 50%		7-D	
	20	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.			

OCT 19 1982

10/19

EQUIP MENT		PAGE 2 OF 4 CG 32 CODE RT-870-D (H)	USE LBS	N-CODE	ACCT LBS
922 3 CONT	17	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 DEG F FOR S22. RECORD: START <u>3:55 PM</u> TOTAL MIN <u>15</u> CLARITY <u>6E</u> HT <u>190</u> F & REC <u>190</u> F			
MISC 4	18	MEASURE UNITS IN V-928 FOR S39			
	19	HYDROCHLORIC ACID M <u>2</u> <u>31.01</u> %	<u>1412</u>	28-D	438
	20	WEIGH SODIUM NITRITE IN PT FOR S42			
		M <u>9</u> <u>3326</u> %	<u>1190</u>	725-A	397
	21	WEIGH SODIUM NITRITE IN DRUM FOR S50			
		M <u>9</u> <u>3326</u> %	<u>129</u>	725-A	43
904/CV 5	22	RUN 2" (58G) WATER INTO V-904/CV WHEN S17 IS COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F. RECORD: START <u>4:10 PM</u> TOTAL MIN <u>55</u>			
922 6	23	WHEN S22 COMPLETE, SHUT OFF PUMP AND INSERT V-922 FOOT PLUG			
	24A	RUN IN 10" (209G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904/CV 7	24B	AND PUMP V-922 THRU SPARKLER INTO V-904/CV			
902 8	25	RUN 65" (1696G) WATER INTO V-902			
	26	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M <u>12</u> <u>50.16</u> %	<u>795</u>	7-D	399
	27	DUMP IN FROM S3	<u>2670</u> LOT	82-C	994
		3-HYDROXY- 2-NAPHTHOIC ACID	<u>2123</u> <u>8223</u>		
	28A	ADJ TO 70-90 DEG F & STIR TO DISSOLVE	<u>212</u> <u>338</u>		
922 9	28B	RUN IN 5" (104G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904/CV 10	29	PUMP V-922 THRU SPARKLER INTO V-904/CV			
	30	WHEN MTY BLOW OUT SPARKLER INTO V-904/CV			
	31	DISSOLVE ALKANOL XC IN 20G WATER AT 150-160 F FROM HOT WATER MIXER IN DRUM & POUR IN.	<u>32</u>	133-B	32
	32	HEAT TO 165-170 F FOR S38			
922 11	33	RUN <u>34</u> (328G) WATER INTO V-932 & ADJ TO 80-100 DEG F.	<u>300</u>	530-A	<u>306</u>
	34	ADD IN 6-7 MIN DRESINATE X			
	35	STIR 5 MIN & RECORD PH <u>10.2</u> (9.5-10.5)			
	36	STIR 20 MIN OR LONGER TO DISSOLVE FOR S59			

EQUIP MENT		PAGE 3 OF 4 CG 32 CODE RT-870-D (H)	USE LBS	N-CODE	ACCT LBS
		NOTE: IF N-740-C SOL. WAS PUMPED DIRECTLY FROM SPARKLER TO CV S21,24B,29 OMIT S37 &38			
CV	12	RUN 1" (95G) WATER INTO V- PUMP V-904 AT 165-170 DEG F THRU UNDERSUR- FACE DISTRIBUTOR INTO CV AFAP (12-15 MIN) RUN IN N-28-D HYDROCHLORIC ACID FROM S18 IN 12-15 MIN. MAINTAIN 165-170°F IN CV. STIR 15 MIN AT 165-170 DEG F ADJ TO 46" (4347G) AT 32-38 DEG F RECORD: TEMP <u>32</u> DEG F, VOLUME <u>60</u> .	60 4X330	57-A	19,800
	142	RUN IN N-725-A SODIUM NITRITE FROM S19 AFAP (5-10 MIN) & RINSE IN PT NOTE: PROCESS HAS A VERY LOW N-28-D EXCESS CHECK CR VERY CAREFULLY			
	43	STIR 20 MIN AT 32-38 DEG F MAINTAINING +CR, +KI FOR S44. RECORD: TIME START <u>9:10^h</u> CR <u>+</u> , KI <u>+</u> NOTE: 1) IF CR-, KI- ADD 20% "AS IS" INCREMENTS RECORD CR <u>+</u> KI <u>+</u> HYDROCHLORIC ACID ASSUME 32% 2) IF CR+, KI- ADD 20% "AS IS" INCREMENTS RECORD CR <u>+</u> KI <u>+</u> SODIUM NITRITE ASSUME 33%		57-A	
	44	DUMP IN CALCIUM CHLORIDE	1026	20-A	1026
	45	ADD FOR MAINTAINING 32-38 DEG F THRU S55	32X330	57-A	10,560
PT	13	FILL PT APPROXIMATELY 1/2 FULL WITH 90-110° F WATER FROM HOT WATER MIXER DUMP IN STRONTIUM NITRATE STIR 30 MIN OR LONGER WITH LIGHTNIN MIXER TO SOLUTION FOR S58	68	246-B,E	68
902	14	WHEN S28A COMPLETE, STEAM EJECT <u>V-921</u> FROM S8 INTO V-902. POUR IN N-725-A SODIUM NITRITE FROM S20 ADD AMMONIUM CHLORIDE.	213	165-A	213
CV	15	IMMEDIATELY COUPLE V-902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN. RECORD: START <u>10:05^h</u> TOTAL MIN <u>25</u>			
PT	16	DURING S52 WEIGH SODIUM HYDROXIDE IN PT M <u>50.16</u> % DILUTE TO MAXIMUM VOLUME (+/-100G) FOR S56	279	7-D	140
CV	17	WHEN S52 COMPLETE, STIR 30 MIN & RECORD: DIAZO <u>+</u> (+) BASE <u>+</u> (+) PH <u>4.8</u> (5.0-6.0) TEMP <u>26°</u> (32-38 F) RUN SODIUM HYDROXIDE IN PT FROM S54 THRU UNDERSURFACE LINE, RINSE IN PT & STIR 15 MN RECORD: DIAZO <u>-</u> (-) BASE <u>+</u> (+) PH <u>9.5</u> (9.0-9.8) RUN IN STRONTIUM NITRATE N-246-B,E SOL'N FROM S48 & RINSE IN PT STEAM EJECT IN V-932 FROM S36 STIR 5 MIN & RECORD: PH <u>9.6</u> (9.0-9.8)			

EQUIP MENT		PAGE 4 OF 4 CG 32 CODE RT-870-D (H)	USE LBS	N-CODE	ACCT LBS
17 CONT	61	IF PH BELOW 9.0 ADJ TO PH 9.0-9.8 WITH N-7-D ONLY. RECORD PH			
	62	SODIUM HYDROXIDE ASSUME 50% POUR IN 1 OCTANOL	38	7-D 588-A	38
	63	HEAT TO 193-195 DEG F IN 70-75 MIN & RECORD HT 94 DEG F AND REC 194 DEG F			
	64	STIR 60 MIN AT 193-195 DEG F. RECORD: START 200A			
	65	AFTER 20 MIN S64 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 9.0 ASSUME 50%	20	7-D	10
	65	AFTER S64 STIR, FLOOD TO 180-190° (+/-18,000G) AND STOP AGITATOR			

WHEN INSTRUCTED BY PROCESSING AREA HALFWAY
THRU PRESSING, DUMP IN, STIR 5 MIN & STOP
AGITATOR. RESUME PRESSING.

10 588-A 10

START 3:00 PM 11:00 P	FIN 11:00 PM 3:15 A	DETR 322 126

N- 740 -C CHECK-WEIGH & CALCULATE

NEWARK CHECK-WEIGH

DUP050102111





