

CG 32 CODE RT-428-D PKG.

EST. WGT. 3168 LBS.

STD. HRS. TIME 3 P M

PROCESSES		APPROVED BY	
() RT-428-D	(X)	JJG	05-12-78
()	()	DCG	08-10-78
()	()	MW	08-11-78
()	()		
TYPED BY			
emw081678			

NON-BLEEDING

EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	WATCHUNG® RED B			
	Note: Do not start if press will not be available within 3 hours after making. Making Supv to review with P.R. Supv & Record:			
	Press will be ready M / P.R. Supv <i>D.P.</i>			
	Start Making M / Making Supv <i>E.C.</i>			
Prep 1	1 Record: batches since Sparkler last cleaned			
	2 After 5 batches, clean, dress Sparkler & pre-coat with 15#		777-A	
	3 Obtain for S 11		740-C	
	4 Obtain for S 40		82-C	
	5 Install DV & CV Recorder & Controller Charts			
921/931 2	6 Run 13" (130 G) water into V-931 & heat to 80-100°F	125	530-A	125
	7 Add in 2-3 min			
	8 Stir 5 min & Record: pH 10.6 (9.5-10.5)			
	9 Stir 20 min or longer to dissolve for S 53			
922 3	10 Run 35" (722 G) water into V-922		721	
	11 Weigh in V-926 & run in M , % 216		740-C	216
	12 Turn on agitator & steam & dump in from S 2			1107
	Lot #100% %			
	111 1104 9882 1120			
	13 Dump in	25	113-B	25
	14 Dump in	10	777-A	10
	15 Heat to 212-214°F Watch Foam			
	16 Record: BY (+) If necessary add to +BY Assume 50%			
	17 Stir 30 min at 212-214°F, then shut off steam Watch Foam			
	18 Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 22			
	Record: Start 915 Total Min 15 Clarity 0.1C			
	HT 195 °F & Rec 195 °F			
4	19 Measure 1701 units in V-928 for S 33 M 11 3087 % 1727		28-D	533
	20 Dissolve in 30 gal water in 55 gal drum at 90-110°F	60	246-E	60
	for S 52			
	21 Weigh in PT for S 36 M 13 3347 % 1141		725-A	382

N35113

EQUIPMENT	PAGE	2 CG 32 CODE RT-428-D (X) EST. WGT.	3168 LBS.	USE LBS.	N CODE	ACCT. LBS.
904/CV 5	21	Run 1" () G water into V-904 Note: Use coupling vat if MTY. If CV is not available, use V-904				
	22	When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 930 Total Min 15				
902 6	23	Run 56" (1618 G) water into V-902				
	24	Dump in & stir to smooth slurry for S 42	525	542-A	525	
922 7	25	When S 22 complete, stop pump & insert V-922 foot plug				
	26	Run in 12" (247 G) water & heat to 190-195°F. Circulate 15 min. Sparkler Pump V-922 thru Sparkler into V-904/CV				
904/CV 8	27	Pump V-922 thru Sparkler into V-904/CV. See the attached page				
	28	When MTY blow out Sparkler into V-904/CV				
	29	Pour in	75	979-D	75	
	30	Heat to 165-170°F				
CV 9		NOTE: If N-740-C sol'n (S's) was pumped directly from Sparkler to CV, run S 31 & 32				
	31	Run in 1" (95 G) water into V-904				
	32	Pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min). Maintain 165-170°F in CV				
	33	Run in N-28-D from S 18 in 12-15 min				
	34	Stir 15 min at 165-170°F				
	35	Add to 43" (4080 G) at 32-38°F	50 x 330	57-A	21,750	
	36	Run in N-725-A from S 20 AFAP (5-10 min)				
	37	Stir 20 min at 32-38°F maintaining + CR, + KI Record: Time Start 2:50 AM 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 (+)				
	38	Dump in	184	246-E	184	
	39	Dump in	570	65-A	570	
	40	Dump in from S 3 & stir 10 min Lot		82-C	1012	
		5320 1012				
	41	Add for maintaining 32-38°F thru S 48	30 x 330	57-A	16500	
902 10	42	Dump into V-902 & stir 2-3 min	250	165-A	250	
CV 11	43	Immediately after S 42 complete, pump V-902 thru undersurface distributor into CV in 18-20 min. Maintain 32-38°F in CV Record: Start 4:50 AM Total Min 20		57-A		
PT 12	44	During S 43, weigh in PT M % 150 721		7-D	150	
	45	Dilute to maximum volume (±100 G) for S 48				

EQUIPMENT	PAGE 3 CG 32 CODE RT-428-D (X) EST. WGT. 3168 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 13	46 When S 43 is complete, stir 30 min			
	47 Record: pH 5.9 (5.0-6.0), Temp 58 °F (32-38°F)			
	48 Run in N-7-D from S 45 thru undersurface line			
	49 Stir 15 min & Record: pH 9.3 (9.0-9.8)			
	50 If pH is below 9.0, adj to pH 9.0-9.8 Assume 50%		7-D	
	51 Record: pH 9.3, Diazo — (-), Base + (+)			
	52 Pour in N-246-E solution from S 19			
	53 Steam eject in V-921/931 solution from S 8			
	54 Heat to 180-182°F in 65-75 min & Record: HT 180 °F & Rec 182 °F			
	55 Stir 30 min at 180-182°F Record: Start 8:20 AM			
	56 Flood to 180-190" (±18,000 G)			
	57 Stir 5 min & Record: pH 8.6 (8.8-9.3)			
	58 If pH below 8.8, adj to pH 8.8-9.3 Assume 50%	40	7.1-D	40
	Record: pH 8.85			
	59 Stop agitator			
	When instructed by Processing Area halfway thru pressing,			
	dump in & stir 5 min	10	588-A	10
	Stop agitator & resume pressing			
	START FIN OPTR			
	11:00 AM 7:00 AM 301			
	7:00 AM 9:30 AM 194			

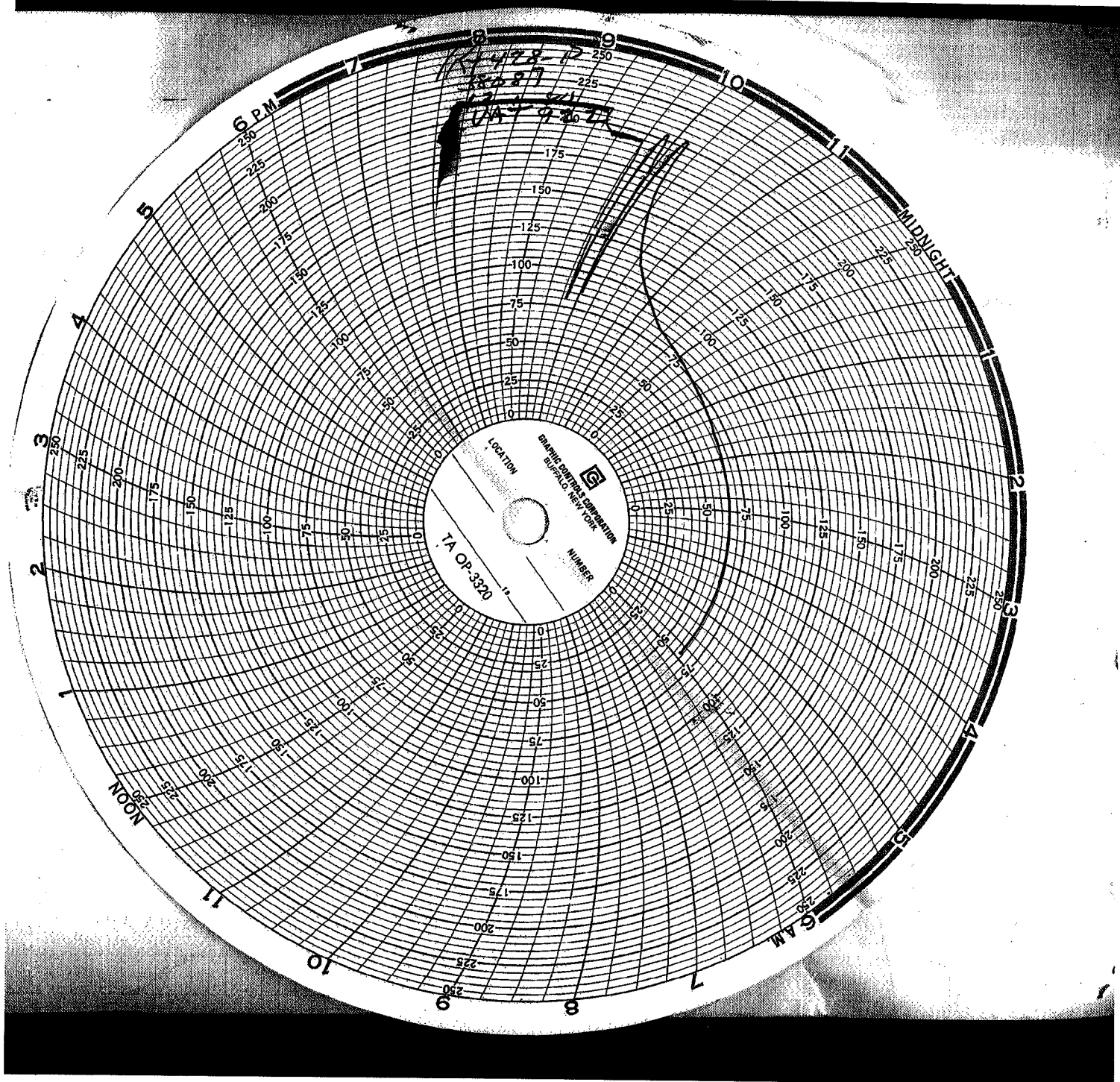
V922

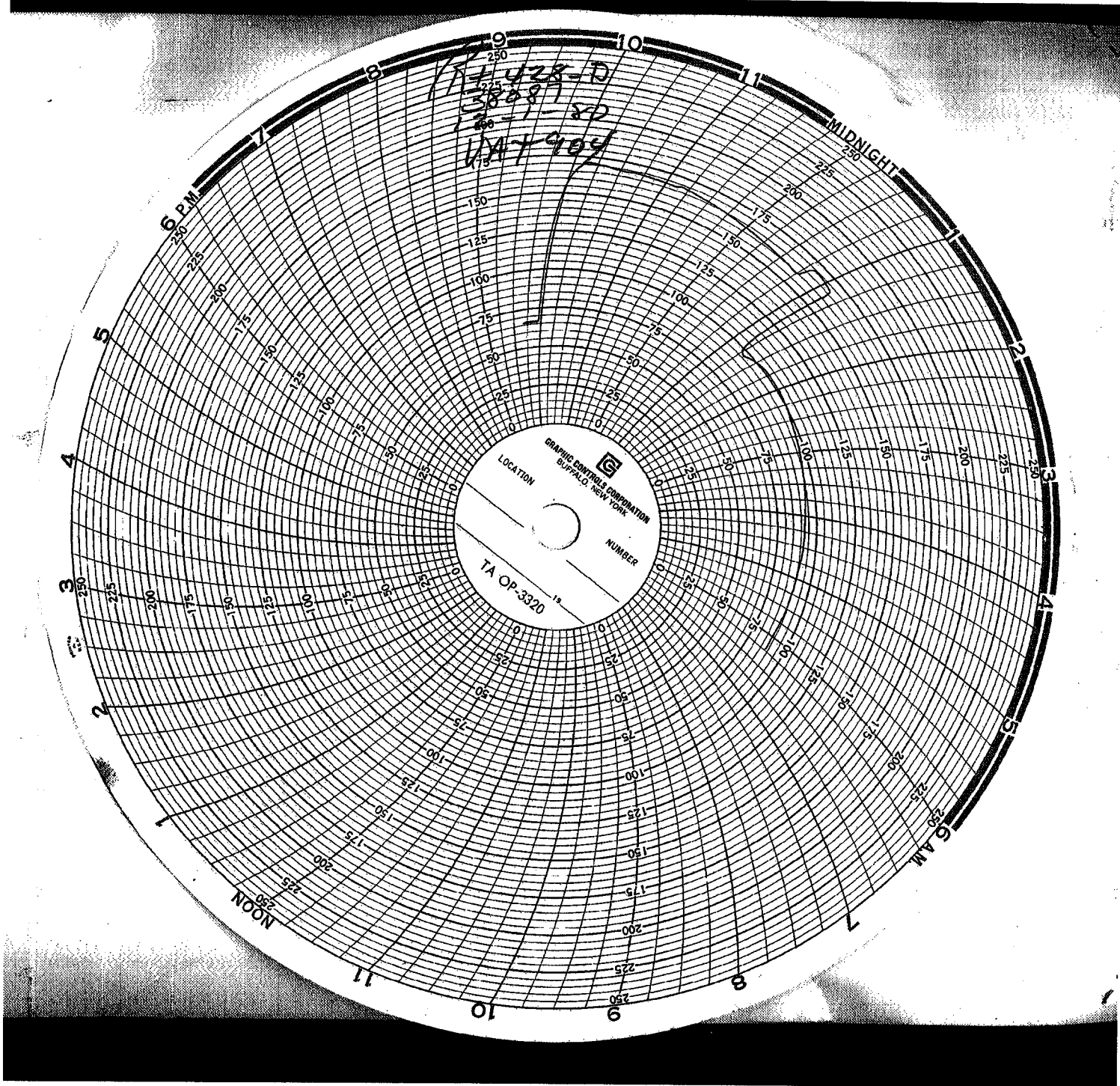
~~27~~ RUN 8" (165 GAL) WATER INTO
V922 & HEAT TO 190-195°F
CIRCULATE 15 MIN OR LONGER
THRU SPARKLER UNTIL SOLUTION
IS CLEAR. MAINTAIN 190-195°F
THRU S-~~27~~ 27

V904

~~27~~ PUMP V-922 THRU SPARKLER
INTO V-904

CONTINUE WITH S-28





1107
975-

132
1107

204
18
186

216
186
30