

S.V.

C.V. 901 903

D.V. 902,904

CG 32

CODE RT-880-D

PKG ---

PROCESSES

APPROVED BY

JUN 14 1982

F2K25

() RT-880-D (F)

EWK 12-28-81

(DATE)

(LOT NUMBER)

TYPED BY: JMH

EST. WT. 2026* LBS.

STANDARD HRS. 9.3

TIME ____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: ____ 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	5 RUN 9" (90G) WATER INTO V-921 & ADJ TO 80-100 DEG F			
2	6 ADD IN 2-3 MIN DRESINATE XX 7 STIR 5 MIN & RECORD PH. 9.8 (9.5-10.5) 8 STIR 20 MIN OR LONGER TO DISSOLVE FOR S36	88	99-A	88
922 3	9 RUN 31" (639G) WATER INTO V-922 10 WEIGH IN SODIUM HYDROXIDE IN V-926 & RUN IN M 10 4955 % 367		7-D 740-C	182 927
	11 TURN ON AGITATOR & STEAM & DUMP IN FROM S2 LOT #100% 99.34 290 2-CHLORO 279 288 98.64 648 4-AMINO 274 239 TOLUENE 5-SULFONIC ACID			

JUN 21 1982

908
6/18

DATE PRINTED: 6/02/82

EQUIP MENT		PAGE 2 OF 4 CG 32 CODE RT-880-D (F)	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>1415</u>			
		TOTAL MIN <u>30</u> CLARITY <u>0.5</u>			
	18	RECORD: HT <u>195</u> F & REC <u>195</u> F			
MISC	19	WEIGH SODIUM NITRITE IN PT-1 FOR S45			
4		M <u>9</u> , <u>33.36</u> %	<u>902</u>	725-A	301
	20	WEIGH SODIUM NITRITE IN DRUM FOR S51			
		M <u>9</u> , <u>33.36</u> %	<u>105</u>	725-A	35
	21	WEIGH SODIUM NITRITE IN DRUM FOR S52			
		M <u>9</u> , <u>33.36</u> %	<u>105</u>	725-A	35
	22	MEASURE <u>21 3/4</u> UNITS IN V-928 FOR S42			
		HYDROCHLORIC ACID M <u>1</u> , <u>29.89</u> %	<u>1495</u>	28-D	447
904/ CV	23	RUN 1' (<u> </u> G) WATER INTO V- <u>901</u>			
5	24	NOTE USE CV IF MTY, IF CV NOT MTY USE V-904			
		WHEN S18 IS COMPLETE, PUMP IN V-922 THRU			
		SPARKLER, MAINTAIN V-922 AT 190-195 DEG F.			
		RECORD: START <u>1450</u> TOTAL MIN <u>45</u>			
902	25	RUN 53" (1383G) WATER INTO V-902			
6	26	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN			
		M <u>10</u> , <u>49.55</u> %	<u>767</u>	7-D	380
	27	DUMP IN FROM S3 LOT		82-C	848
		3-HYDROXY	<u>7668</u>		
		2-NAPHTHOIC ACID	<u>7588</u>		
	28	ADJ TO 70-90 DEG F & STIR TO DISSOLVE			
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			

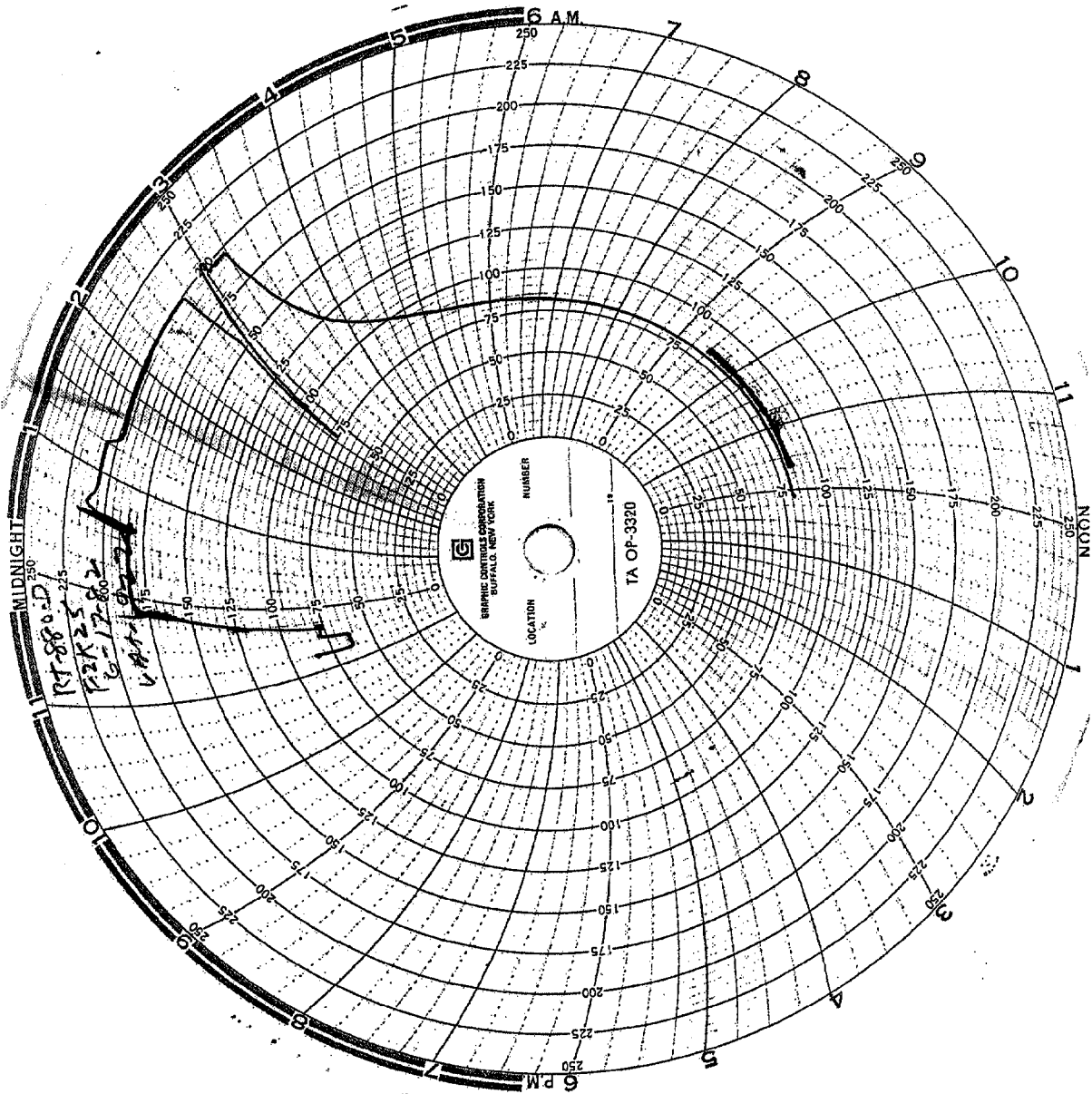
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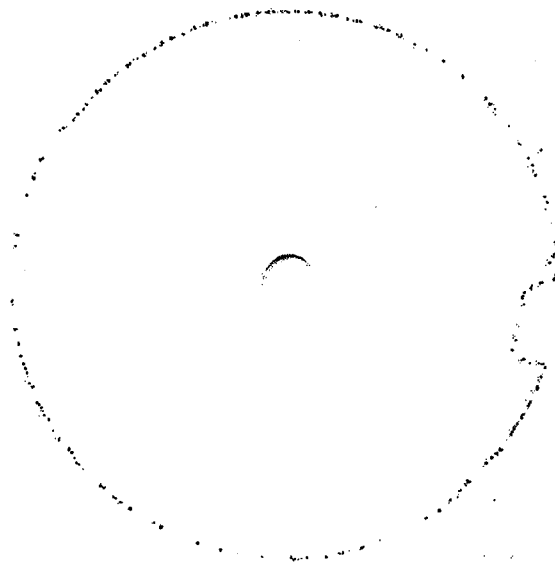
EQUIP MENT		PAGE 3 OF 4 CG 32 CODE RT-880-D (F)	USE LBS	N-CODE	ACCT LBS
904/CW	33	DISSOLVE ALKANOL XC IN 20G WATER AT 135-145			
10		F WATER FROM HOT WATER MIXER IN DRUM & POUR	26	133-B	26
CONT	34	IN HEAT V-904/CV TO 165-170 F FOR S41			
902	35	WHEN S28 COMPLETE, MEASURE TRISULPHOIL SOAP	84	39-A	84
11		D IN CALIBRATED CONTAINER, SLURRY WITH 46G			
	36	WATER IN DRUM & POUR INTO V-902			
		STEAM EJECT IN V-921/931 FROM S8			
PT-2	37	RUN SODIUM HYDROXIDE INTO PT M. 10, 49.55, 214		7-D	106
12	38	ADJ TO 17" (59G)			
	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	40	RUN 1" (95G) WATER INTO V-901			
13	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 37" (3496G) AT 32-38 DEG F	48 X330	57-A	15840
	46	RECORD: TEMP 30 F, STICK 37			
	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		57-A	
	49	+KI FOR S54 RECORD: TIME START 9.58P			
	50	CR (+) KI (+) NOTE:			
	51	1) IF CR-, KI-, ADD 20# "AS IS" INCREMENTS RECORD: CR (+) KI (+)			
	52	HYDROCHLORIC ACID ASSUME 32%		28-D	
	53	2) IF CR+, KI-, ADD 20# "AS IS" INCREMENTS RECORD: CR (+) KI (+)			
	54	SODIUM NITRITE ASSUME 33%		725-A	
	55	DUMP IN CALCIUM CHLORIDE	935	20-A	935
	56	DUMP IN STRONTIUM NITRATE	205	246-B,E	205
	57	DUMP IN BARIUM SULFATE	44	65-A	44
	58	ADD FOR MAINTAINING AT 32-38 DEG F DURING COUPLING	35 X330	57-A	11550
	59	POUR IN N-725-A SODIUM NITRITE FROM S20			
902	60	POUR N-725-A SODIUM NITRITE FROM S21 INTO V-902			
14	61	DUMP IN AMMONIUM CHLORIDE & STIR 2-3 MIN	172	165-A	172
CV	62	IMMEDIATELY COUPLE 902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN. MAINTAIN CV AT 32-38 DEG F. RECORD: START 10.45P			
15	63	TOATL MIN. 25			
	64	INSTALL 5/16" ORIFICE IN UNDERSURFACE ADDITION LINE			
	65	WHEN S54 COMPLETE, STIR 30 MIN, & RECORD:			

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EQUIP MENT		PAGE 4 OF 4 CG 32 CODE RT-880-D (F)	USE LBS	N-CODE	ACCT LBS
CV	57	RUN IN N-7-D FROM S39 THRU 5/16" ORIFICE			
15		& RINSE IN RECORD: 45 MIN (40-50 MIN)			
CONT	58	STIR 20 MIN & RECORD: PH 4.9 (7.0-8.5)			
	59	IF PH BELOW 7.0 ADJ TO PH 7.0-8.5 WITH			
	60	N-7-D ONLY. RECORD PH 7.4 ASSUME 50%	120	7-D	60
	61	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN			
	62	ASSUME 50%	88	7-D	44
	63	STIR 15 MIN & RECORD: BASE (+)			
	64	DIAZO (-) PH 9.0 (9.0-9.8)			
	65	IF PH BELOW 9.0 ADJ TO PH 9.0-9.8 WITH			
	66	N-7-D ONLY. RECORD PH 9.9 BASE 5+	130	7-D	65
	67	SODIUM HYDROXIDE ASSUME 50%			
	68	MEASURE I OCTANOL IN CALIBRATED CONTAINER			
	69	& POUR IN	31	588-A	31
	70	HEAT TO 193-195 DEG F IN 75-80 MIN. RECORD			
	71	START 125			
	72	RECORD: HT 193 DEG F & REC 193 DEG F			
	73	STIR 60 MIN AT 193-195 DEG F. RECORD:			
	74	START 235			
	75	AFTER 20 MIN S66 STIR RECORD:			
	76	PH 8.6 (8.8-9.3)			
	77	IF PH BELOW 8.8, ADJ TO PH 8.8-9.3 WITH			
	78	N-7-D ONLY. RECORD PH 9.2	70	7-D	35
	79	SODIUM HYDROXIDE ASSUME 50%			
	80	WHEN S66 COMPLETE, FLOOD TO 180-190"			
	81	(F/-18,000G)			
	82	STOP AGITATOR			
WHEN INSTRUCTED BY PROCESSING AREA 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		
	1100P	700A	126		
	9:35P	11:02	352		
	11 PM	4 AM	120		

N-28 INSTRUMENT NOT WORKING PROPERLY
 Pumping $\pm$ 5 HRS, TO VRT 928
 ONLY Reached $\pm$ 48 UNITS





$$\frac{12}{10} = 1\frac{2}{5}$$

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