

S.V.

C.V. 901, 903

D.V. 904

CG 32 CODE RT-618-D PKG.

→ **DEC 10 38224**

EST. WGT. 2597 LBS.

STD. HRS. TIME M

| PROCESSES         |     | APPROVED BY  |
|-------------------|-----|--------------|
| ( ) RT-618-D (T)  |     | JJG 08-15-78 |
| ( ) Alternate ( ) |     | AMJ 09-20-78 |
| ( )               | ( ) |              |
| ( )               | ( ) |              |
| RETYPE BY         |     | P/R          |
| emw061279         |     | EWK 061579   |

DEC 11 1980

## NON-BLEEDING

| EQUIPMENT | NAME:                                        | WATCHUNG® RED Y                                                                                 | USE<br>LBS. | N<br>CODE | ACCT.<br>LBS. |
|-----------|----------------------------------------------|-------------------------------------------------------------------------------------------------|-------------|-----------|---------------|
| Prep 1    | Record:                                      | batches since Sparkler last cleaned. After 5 batches, clean, dress Sparkler & pre-coat with 15# | 15          | 777-A     | 16            |
|           | Obtain for S 11                              |                                                                                                 |             | 740-C     |               |
|           | Obtain for S 24                              |                                                                                                 |             | 253-C     |               |
|           | Install DV & CV Recorder & Controller charts |                                                                                                 |             |           |               |
| 921/931   | 5                                            | Run 10" (100 G) water into V-921 & adj to 80-100°F                                              |             |           |               |
|           | 6                                            | Add in 1-2 min                                                                                  | 50          | 530-A     | 50            |
| 2         | 7                                            | Stir 2 min & Record: pH 10.4 (9.5-10.5)                                                         |             |           |               |
|           | 8                                            | Stir 20 min or longer for S 27                                                                  |             |           |               |
| 922       | 9                                            | Run 28" (620 G) water into V-922                                                                |             |           |               |
| 3         | 10                                           | Weigh in V-926 & run in M/B 48.77%                                                              | 365         | 7-D       | 178           |
|           | 11                                           | Turn on agitator & steam & dump in from S 2                                                     |             | 740-C     | 920           |
|           |                                              | Lot 100%                                                                                        |             |           |               |
|           |                                              | 113 920 98.78                                                                                   | 931         |           |               |
|           | 12                                           | Dump in                                                                                         | 40          | 113-B     | 40            |
|           | 13                                           | Dump in                                                                                         | 10          | 777-A     | 10            |
|           | 14                                           | Heat to 212-214°F. Record: HT : 21.2 °F WATCH FOAM                                              |             |           |               |
|           | 15                                           | Record: BY + (+), 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                                   |             |           |               |
|           |                                              | Maintain at 190-195°F for S 19 & Record: HT °F                                                  |             |           |               |
|           |                                              | & Recorder 190 °F                                                                               |             |           |               |
|           |                                              | Record: Start 12:00 PM Total Min 70, Clarity CLEAR                                              |             |           |               |
|           |                                              | NOTE: Sample from hose -- show to Supervisor for OK                                             |             |           |               |
| 904       | 18                                           | Run 1" (50 G) water into V-904                                                                  |             |           |               |
| 4         | 19                                           | When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F                    |             |           |               |
|           |                                              | Record: Start 1:50 PM, Total Min 20                                                             |             |           |               |
| Misc      | 20                                           | Weigh in PT for S 35 M/B 33.47%                                                                 | 881         | 725-A     | 295           |
| 5         | 21                                           | Measure 80.94 units in V-928 for S 33 M/B 30.56%                                                | 1217        | 28-D      | 372           |
| CV        | 22                                           | Run 14" (1330 G) water into V-901                                                               |             |           |               |
| 6         | 23                                           | Weigh in V-926 & run in M/B 48.77%                                                              | 423         | 7-D       | 450           |
|           | 24                                           | Dump in from S 3                                                                                |             | 253-C     | 810           |
|           |                                              | Lot 504                                                                                         | 810         |           |               |
|           | 25                                           | Weigh on postal scale & dump in Lot -                                                           |             | 180-C     |               |
|           | 26                                           | Adj to 70-90°F & stir to dissolve                                                               |             |           |               |
|           | 27                                           | Steam eject V-921/931 into CV                                                                   |             |           |               |

| EQUIPMENT |    | PAGE 2 CG 32 CODE RT-618-D (I) EST. WGT. 2597 LBS.                                                                                     | USE LBS.   | N CODE | ACCT. LBS. |
|-----------|----|----------------------------------------------------------------------------------------------------------------------------------------|------------|--------|------------|
| 922       | 28 | When S 19 complete, shut off pump & insert V-922 foot plug                                                                             |            |        |            |
| 7         | 29 | Run in 10" (247 G) water & heat to <del>160-190°F</del> 190-195°F Circulate 15 min thru Sparkler - Pump V-922 thru Sparkler into V-904 |            |        |            |
| 904       | 30 | Pump V-922 thru Sparkler into V-904 See attached page for 5-30                                                                         |            |        |            |
| 8         | 31 | When MTY blow out Sparkler into V-904                                                                                                  |            |        |            |
|           | 32 | Heat to 165-170°F (Sample to Supervisor for OK & R)                                                                                    |            |        |            |
|           | 33 | Run in N-28-D from S 21 in 12-15 min & stir 5 min at 165-170°F                                                                         |            |        |            |
|           | 34 | Adj to 90" (2390 G) at 28-30°F & Record: Temp 72°F. 32"                                                                                | 42 x 330   | 57-A   | 1380       |
|           | 35 | Run in N-725-A from S 20 AFAP (5-10 min)                                                                                               |            |        |            |
|           | 36 | Stir 20 min at 28-35°F maintaining +CR, +KI for S 41                                                                                   |            | 57-A   |            |
|           |    | Record: Time Start 7:10 P, CR +, KI +                                                                                                  |            |        |            |
|           |    | NOTE: 1. If CR -, KI -, add 20# as is increments Assume 32%                                                                            |            | 28-A   |            |
|           |    | Record: CR (+), KI (+)                                                                                                                 |            |        |            |
|           |    | 2. If CR +, KI -, add 20# as is increments Assume 33%                                                                                  |            | 725-A  |            |
|           |    | Record: CR (+), KI (+)                                                                                                                 |            |        |            |
| CV        | 37 | Dump into CV                                                                                                                           | 150        | 65-A   | 150        |
| 9         | 38 | Adj to 33" (3130 G) at 28-32°F                                                                                                         | 33 x 330   | 57-A   | 1099       |
|           |    | Record: Temp 30°F & Volume 39 "                                                                                                        |            |        |            |
|           | 39 | Dump in                                                                                                                                | 212        | 165-A  | 212        |
|           | 40 | Stir 2-3 min                                                                                                                           |            |        |            |
|           | 41 | Immediately couple V-904 thru undersurface distributor into CV in 45-60 min. Maintain CV at 28-32°F                                    |            | 57-A   |            |
|           |    | Record: Start 4:40 P, Total Min 50, Final Temp 30°F                                                                                    |            |        |            |
|           | 42 | Stir 30 min & Record: Base + (+), Diazo - (-), pH 9.2 (9.0-9.8)                                                                        |            |        |            |
|           | 43 | If necessary, adj to pH 9.0-9.8                                                                                                        | Assume 50% | 7-D    |            |
|           |    | & Record: pH                                                                                                                           | Assume 32% | 28-D   |            |
|           | 44 | Heat to 178-180°F in 65-70 min &                                                                                                       |            |        |            |
|           |    | Record: HT 180°F & Recorder 180°F                                                                                                      |            |        |            |
| DV        | 45 | Run 2.4" (600 G) water into DV                                                                                                         |            |        |            |
| 10        | 46 | Turn on agitator & steam & dump in                                                                                                     | 1440       | 16-B   | 1440       |
|           | 47 | Heat to 155-160°F & stir to dissolve                                                                                                   |            |        |            |
| CV        | 48 | When S 44 complete, immediately strike DV thru undersurface distributor into CV in 7-10 min. Maintain CV at 178-180°F                  |            |        |            |
| 11        |    | Record: Start 7:20 P Total Min 10                                                                                                      |            |        |            |
|           | 49 | Heat CV to 198-202°F in 10-12 min                                                                                                      |            |        |            |
|           | 50 | Stir 5 min at 198-202°F                                                                                                                |            |        |            |
|           | 51 | Flood to 180-190" (+18,000 G)                                                                                                          |            |        |            |
|           | 52 | Record: pH 8.5 (9.0-9.4) & stop agitator SAMPLE                                                                                        |            |        |            |
|           |    | START FINISH OPTR                                                                                                                      |            |        |            |
|           |    | 7:00 AM 3:00 PM 301                                                                                                                    |            |        |            |
|           |    | 3:00 P 244-64-322                                                                                                                      |            |        |            |
|           |    | CLEANED SPARKLER & PRE COATED                                                                                                          |            |        |            |
|           |    | When instructed by Processing Area half way thru pressing.                                                                             |            |        |            |
|           |    | Dump in, stir 5 min, & stop agitator. Resume pressing.                                                                                 | 10         | 588-A  | 10         |

V932

304 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-3 30

V904

305 PUMP V-922 THRU SPARKLER  
INTO V-904

CONTINUE WITH S-3

FORM A

CODE \_\_\_\_\_ LOT \_\_\_\_\_ VATS \_\_\_\_\_ EQUIP. \_\_\_\_\_

DATE \_\_\_\_\_ OPER. \_\_\_\_\_ SUPERVISOR \_\_\_\_\_

- ~~1. Used all stumps, leave 1 stump identified.~~
- ~~2. Clean shovel.~~
- ~~3. Chute washed & top replaced.~~
- ~~4. Water hose coiled.~~
- ~~5. Steam ejector turned off after finished in vat.~~
- ~~6. Scale left clean.~~
- ~~7. Added ice to vat only when volume reaches agitator.~~
- ~~8. Floor cleaned around vats used.~~
- ~~9. Hoses coiled or on rack on diazo press.~~
- ~~10. Hoses not crossing walkway after finished.~~
- ~~11. Pump shut off after removing hose from intake.~~
- ~~12. Ice blower shut off after using.~~
- ~~13. All spills in area worked clean.~~
- ~~14. Door on instruments closed.~~
- ~~15. All empty drums removed from area & discarded.~~
- ~~16. Corrosive containers properly covered.~~
- ~~17. Top of vats cleaned of color, paper cups, strings, etc.~~
- ~~18. Vat door closed after finished - hatches on abbe's.~~
- ~~19. All tools cleaned & placed in rack or proper places.~~
- ~~20. Ice house clean - tools on racks.~~
- ~~21. Revolvator cleaned - platform & pit.~~

ATTACH TO MAKE CARD

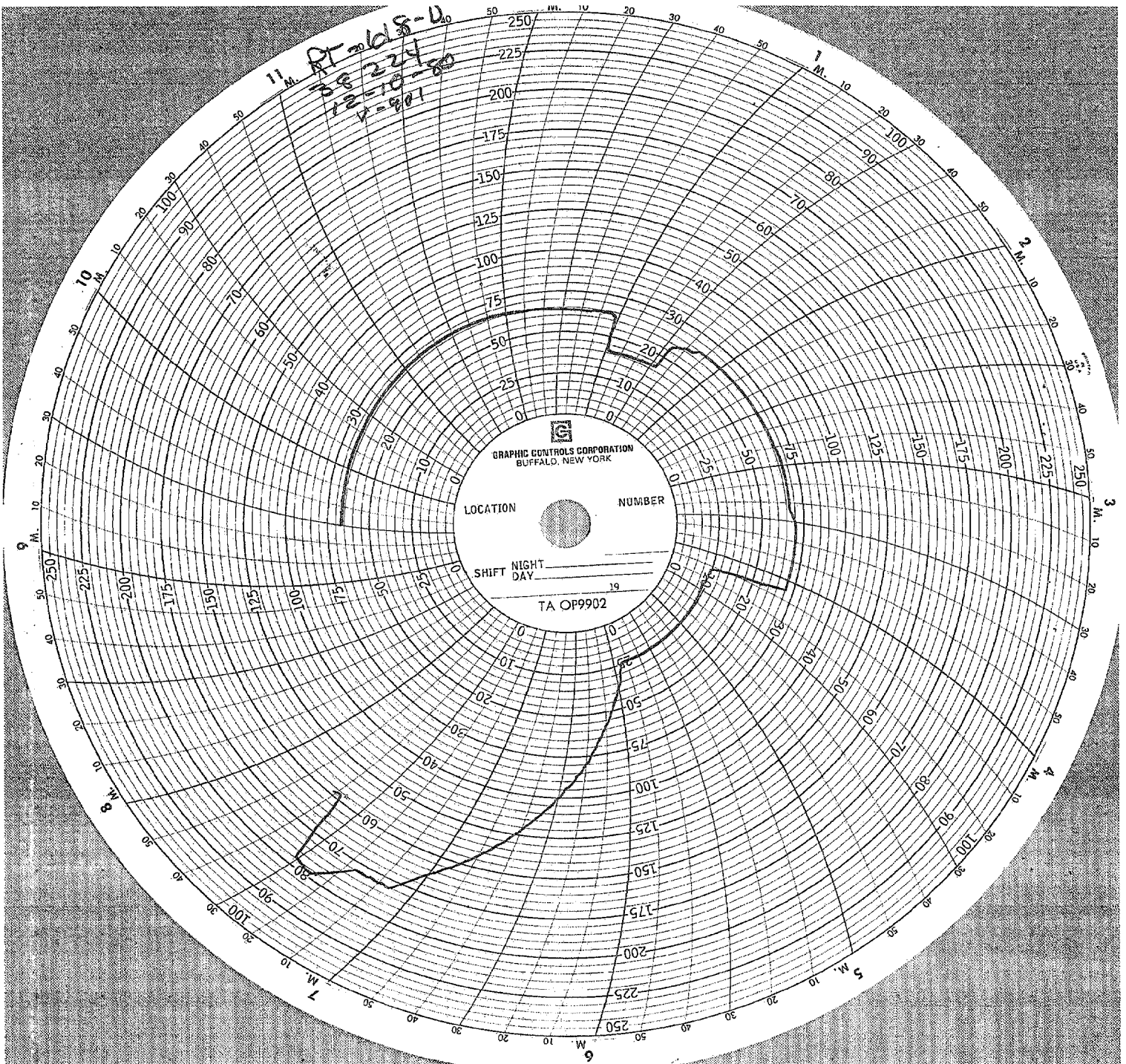
810  
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135  
2 hrs

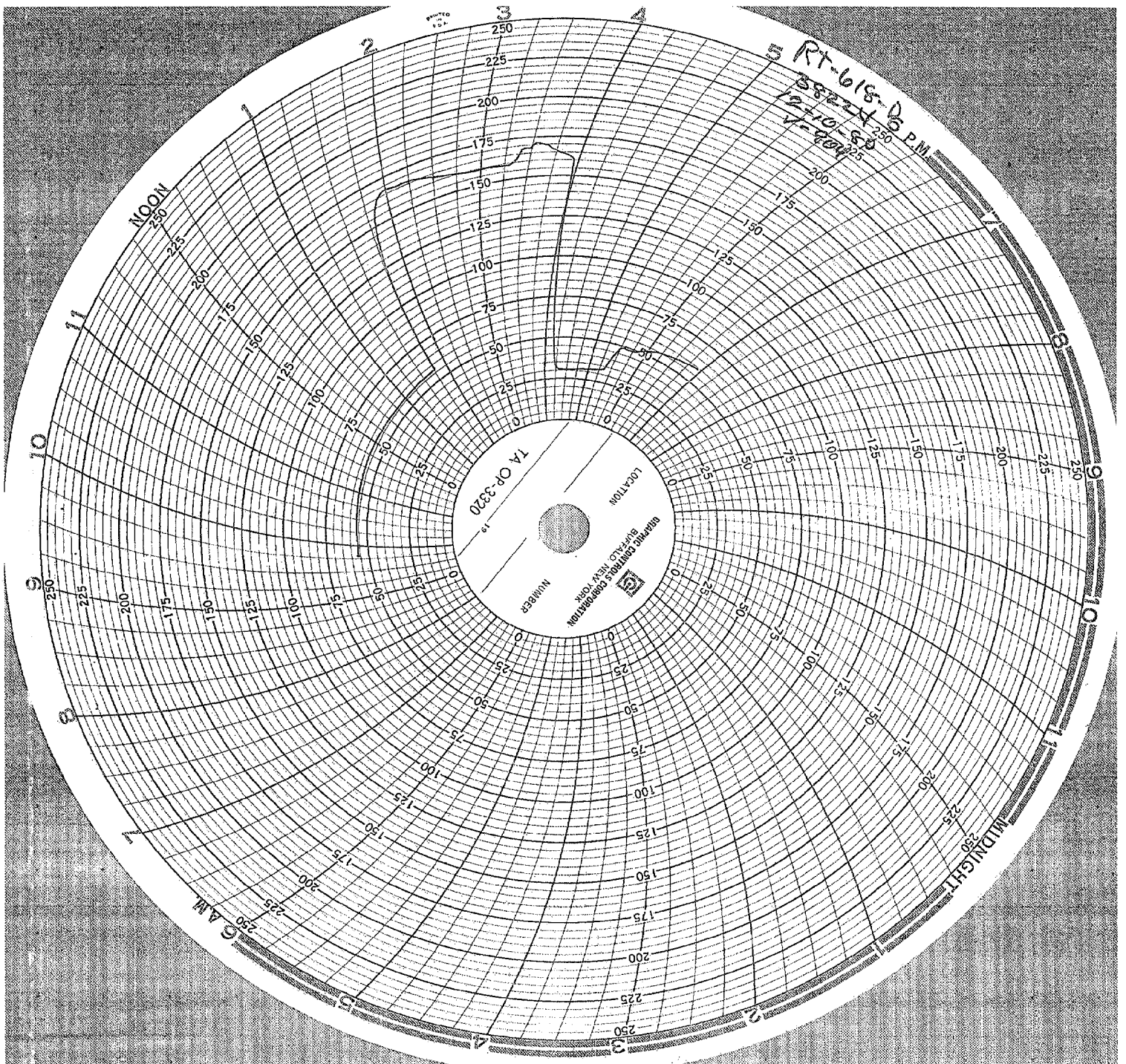
44  
136  
563

515  
225

257

240  
240  
240



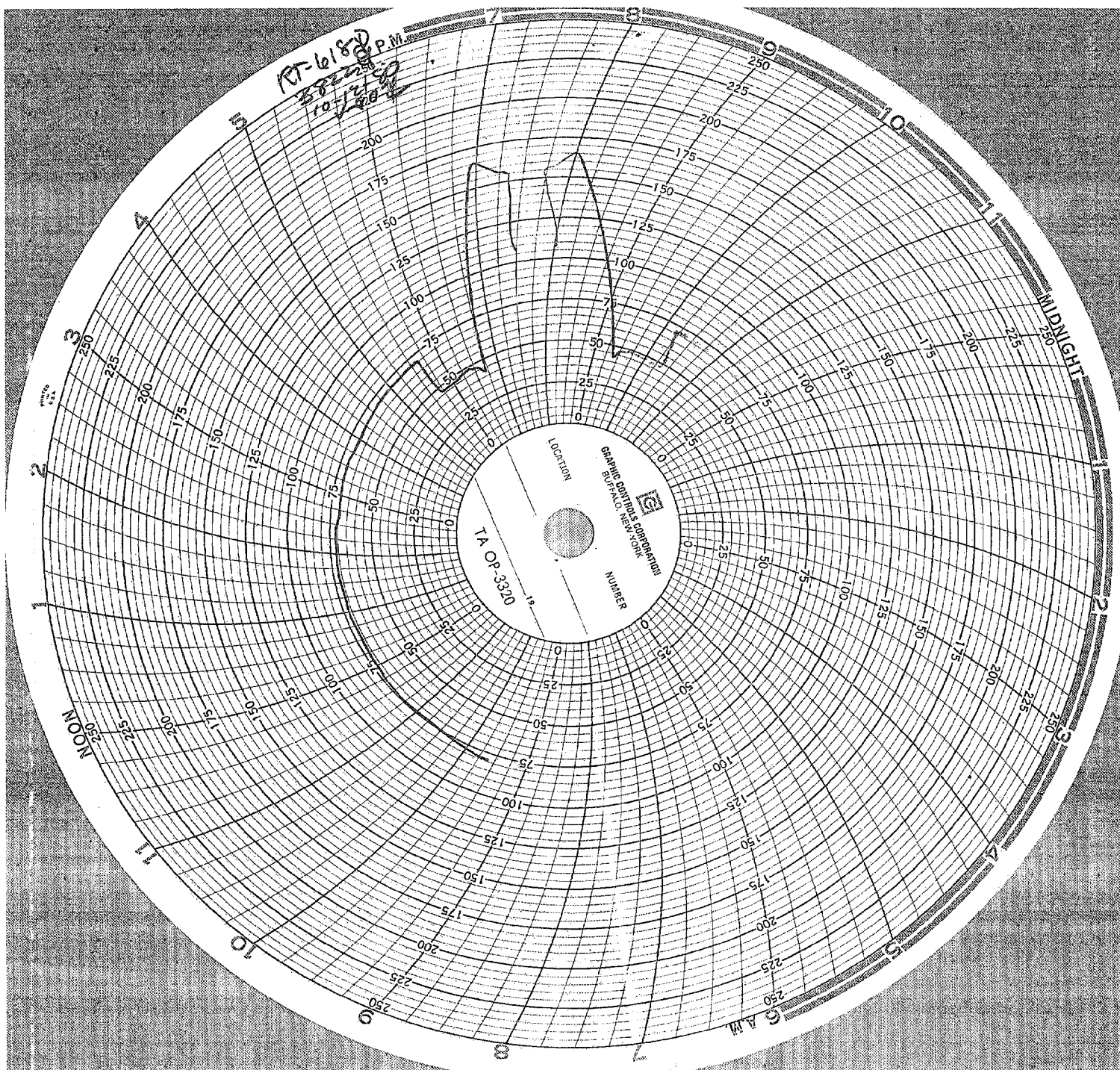




$$\begin{array}{r}
 110 \\
 13 \\
 \hline
 330 \\
 10 \\
 \hline
 1420
 \end{array}$$

$$\begin{array}{r}
 32 \\
 32 \\
 \hline
 990 \\
 9,9 \\
 \hline
 10890
 \end{array}$$

$$\begin{array}{r}
 110 \\
 13 \\
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 330 \\
 110 \\
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 1420
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DUP050106570