

b.v.

c.v. 901, 903

b.v. 902, 904

CG 32 CODE RT-428-D PKG.

→ DEC -2 80 38107

EST. WGT. 2332 LBS.

STD. HRS. TIME 7A M

| PROCESSES    |     | APPROVED BY |          |
|--------------|-----|-------------|----------|
| ( ) RT-428-D | (H) | JUG         | 07-10-78 |
| (F) RC-14-A  | ( ) | DCG         | 08-10-78 |
| ( ) RT-139-P | (P) | MW          | 08-11-78 |
| ( )          | ( ) |             |          |
| TYPED BY     |     |             |          |
| emw082178    |     |             |          |

**CLEAN UP**  
**AS YOU GO ALONG**

**LEAVE ONE STUMP ONLY**

**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 hrs after Making. Making Supv to review with P.R. Supv & Record:<br>Press will be ready M 17-7 P.R. Supv D.A.<br>Start Making M 17-2 Making Supv P.C. |          |        |            |
| Prep 1    | 1 Record: 2 batches since Sparkler last cleaned<br>After 5 batches clean, dress Sparkler & pre-coat with 15#                                                                                                     |          | 777-A  |            |
|           | 2 Obtain for S 11                                                                                                                                                                                                |          | 740-C  |            |
|           | 3 Obtain for S 40                                                                                                                                                                                                |          | 82-C   |            |
|           | 4 Install DV & CV Recorder & Controller charts                                                                                                                                                                   |          |        |            |
| 9/1/931 2 | 5 Run 10" (100 G) water into V-931 & heat to 80-100°F<br>6 Add in 2-3 min<br>7 Stir 5 min & Record: pH 10.1 (9.5-10.5)<br>8 Stir 20 min or longer to dissolve for S 43                                           | 100      | 530-A  | 100        |
| 922 3     | 9 Run 28" (577 G) water into V-922<br>10 Weigh in V-926 & run in M 13, 42.77 %<br>11 Turn on agitator & steam & dump in from S 2                                                                                 | 338      | 7-D    | 165        |
|           | Lot #100%<br>112 843 98.81 853                                                                                                                                                                                   |          | 740-C  | 843        |
|           | 12 Dump in                                                                                                                                                                                                       | 25       | 113-B  | 25         |
|           | 13 Dump in                                                                                                                                                                                                       | 10       | 777-A  | 10         |
|           | 14 Heat to 212-214°F                                                                                                                                                                                             |          |        |            |
|           | 15 Record: BY + (+) If necessary add to +BY Assume 50% WATCH FOAM                                                                                                                                                |          | 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 21<br>Record: Start 11:20 P, Total Min 45, Clarity OK<br>HT 198 OF & Rec 200 OF                                    |          |        |            |
| M sc 4    | 18 Measure 85 1/2 units in V-928 for S 33 M 12, 30.56 %<br>19 Weigh in PT for S 36 M 13, 33.47 %                                                                                                                 | 1324     | 28-D   | 406        |
|           |                                                                                                                                                                                                                  | 801      | 725-A  | 268        |
| 9/14/CV 5 | 20 Run 1" ( G) water into V-903<br>NOTE: Use CV if MTY. If CV is not available, use V-904<br>21 When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 11:35 P Total Min 15 |          |        |            |

| EQUIPMENT |    | PAGE 2 CG 32 CODE RT-428-D (W) EST. WGT. 2332 LBS.                                                                     | USE LBS. | N CODE | ACCT LBS. |
|-----------|----|------------------------------------------------------------------------------------------------------------------------|----------|--------|-----------|
| 902       | 25 | Run 45" (1300 G) water into V-902                                                                                      |          |        |           |
| 6         | 26 | Weigh in V-926 & run in M 13 . 48.77% 254                                                                              |          | 7-D    | 124       |
|           | 24 | Dump in & stir to smooth slurry for S 41                                                                               | 400      | 542-A  | 400       |
| 922       | 25 | When S 21 complete, stop pump & insert V-922 foot plug                                                                 |          |        |           |
| 7         | 26 | Run in 12" (247 G) water & heat to 190-195°F. Circulate 15 min thru Sparkler - Pump V-922 thru Sparkler into V-904/CV  |          |        |           |
| 904/CV    | 27 | Pump V-922 thru Sparkler into V-904/CV 527- see attached page                                                          |          |        |           |
| 8         | 28 | When MTY blow out Sparkler into V-904/CV                                                                               |          |        |           |
|           | 29 | Pour in                                                                                                                | 48       | 979-D  | 48        |
|           | 30 | Heat to 165-170°F                                                                                                      |          |        |           |
| CV        |    | NOTE: If N-740-C sol'n (S's 20 & 21) was pumped directly from Sparkler to CV, omit (S's 31 & 32)                       |          |        |           |
| 9         | 31 | Run in 1" (95 G) water into V-                                                                                         |          |        |           |
|           | 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 | Adj to 34" (3223 G) at 32-38°F 50                                                                                      | 40 x 330 | 57-A   | 16500     |
|           | 36 | Run in N-725-D from S 19 AFAP (5-10 min)                                                                               |          |        |           |
|           | 37 | Stir 20 min at 32-38°F maintaining +CR, +KI                                                                            |          |        |           |
|           |    | Record: Time Start 205 A, 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                                                                                                                | 186      | 246-E  | 186       |
|           | 39 | Dump in                                                                                                                | 350      | 65-A   | 350       |
|           | 40 | Dump in from S 3 & stir 10 min Lot                                                                                     |          | 82-C   | 771       |
|           |    | 482.8 771                                                                                                              |          |        |           |
| 902       | 41 | Dump into V-902 & stir 2-3 min                                                                                         | 166      | 165-A  | 166       |
| 10        |    |                                                                                                                        |          |        |           |
| CV        | 42 | Immediately after S 41 complete, run V-902 thru undersurface distributor into CV in 18-22 min. Let CV temp rise freely |          |        |           |
| 11        |    | Record: Start 300 A, Total Min 20                                                                                      |          |        |           |
|           | 43 | Immediately after S 42 complete, steam eject V-921/931 into CV                                                         |          |        |           |
|           | 44 | Stir 20 min & Record: Diazo - (-), Base + (+)                                                                          |          |        |           |
|           |    | pH 9.5 (9.0-9.8), Temp 56 °F (50-60°F)                                                                                 |          |        |           |
|           | 45 | If necessary, adj to pH 9.0-9.8 Assume 50%                                                                             |          | 7-D    |           |
|           |    | & Record: pH Assume 32%                                                                                                |          | 28-D   |           |
|           | 46 | Weigh & pour in                                                                                                        | 25       | 588-A  | 25        |
|           | 47 | Heat to 193-195°F in 65-75 min & Record: HT 190 °F                                                                     |          |        |           |
|           |    | Rec 190 °F                                                                                                             |          |        |           |
|           | 48 | Stir 15 min at 193-195°F Record: Start 600 A                                                                           |          |        |           |
|           | 49 | Record: pH 8.9 (8.8-9.3)                                                                                               |          |        |           |
|           | 50 | Flood to 180-190" (±18,000 G) & stop agitator                                                                          |          |        |           |
|           | 51 | When instructed by Processing Area halfway thru pressing dump in & stir 5 min. Stop agitator & resume pressing         | 10       | 588-A  | 10        |
|           |    |                                                                                                                        |          |        |           |
|           |    | START 9:00 Pm 11:00 Pm 11:00 P                                                                                         |          |        |           |
|           |    | FIN 11:00 Pm 6:35 A                                                                                                    |          |        |           |
|           |    | OPTR 201 209                                                                                                           |          |        |           |



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

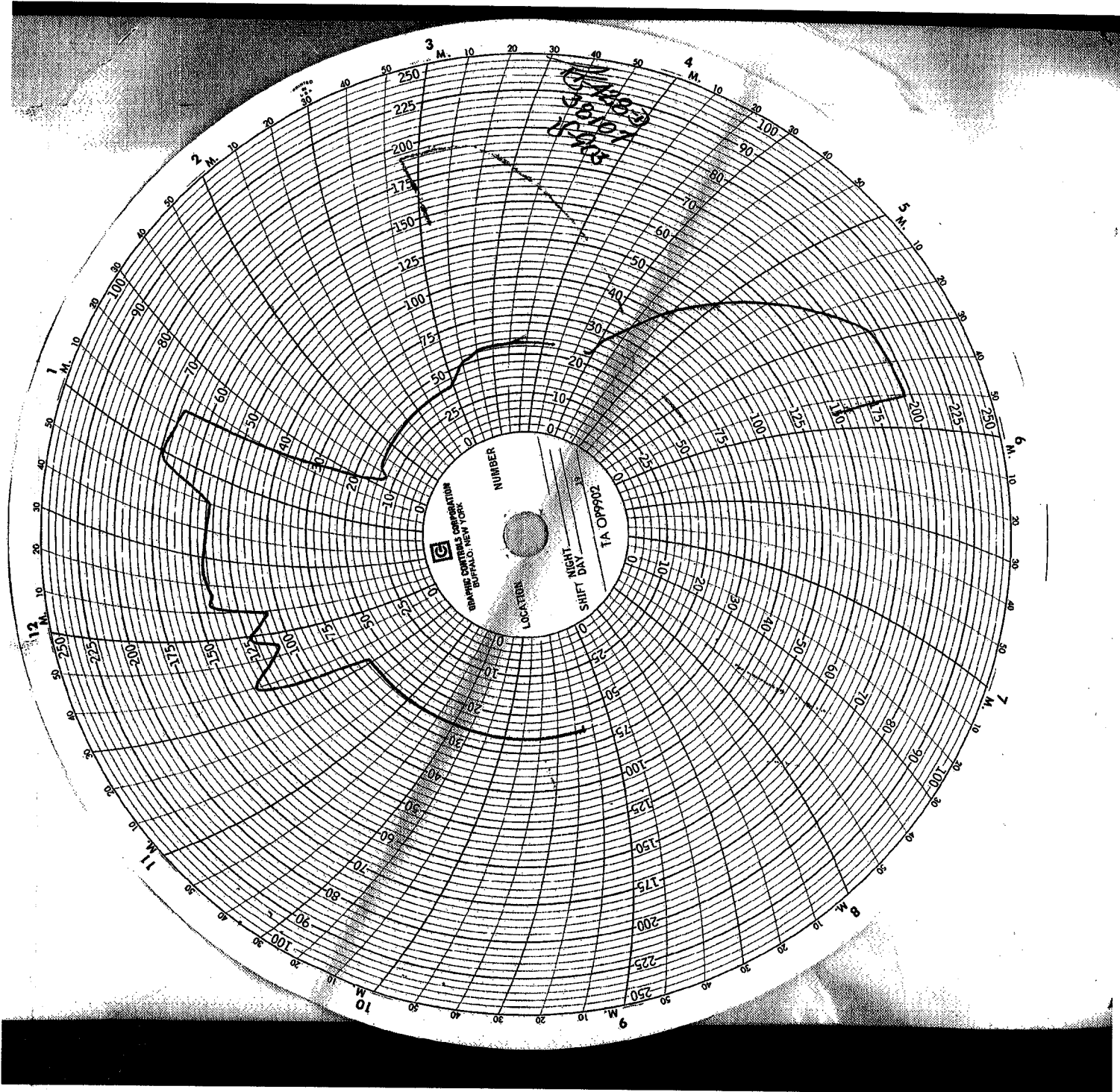
FORM A

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

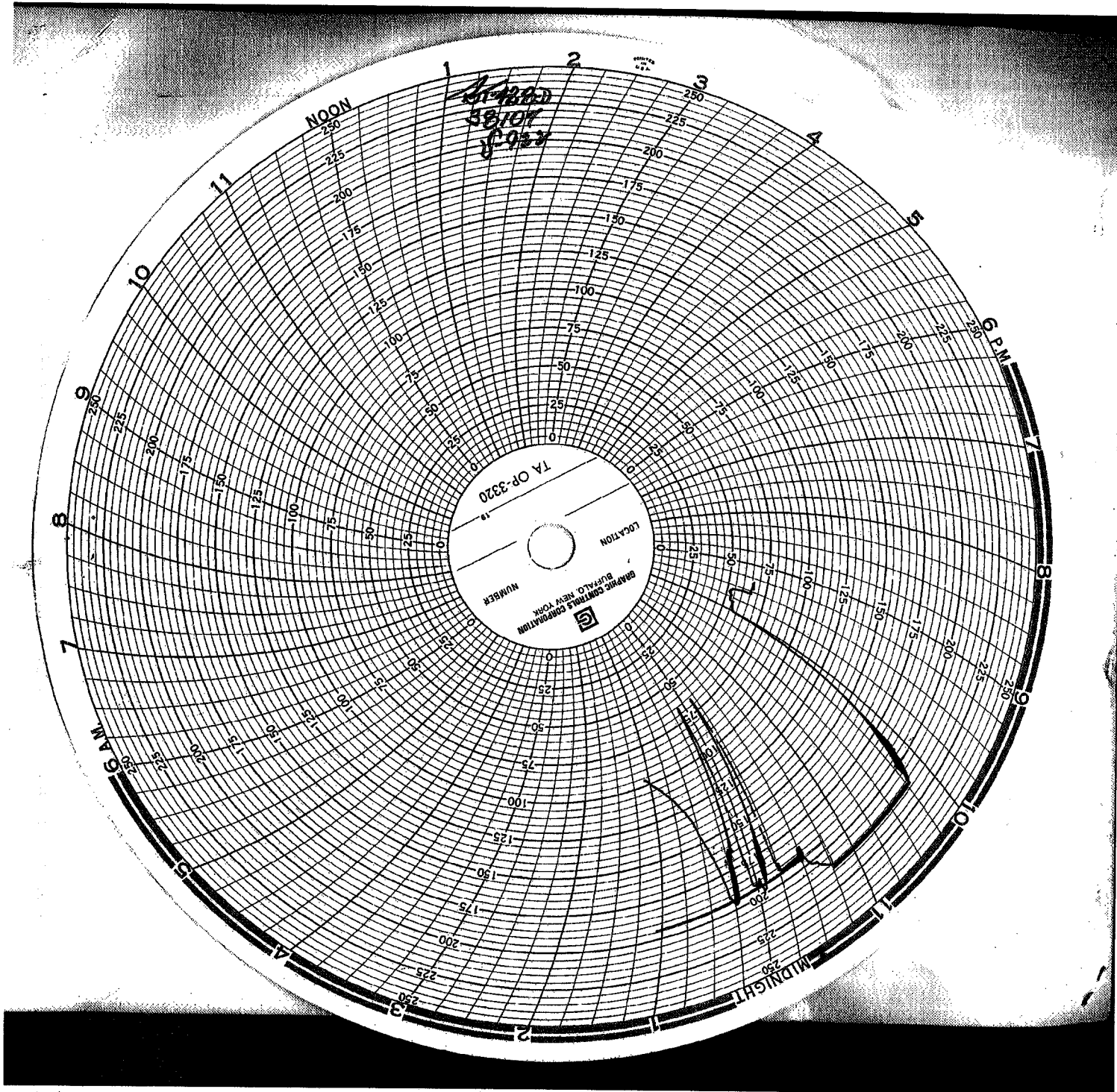
DATE \_\_\_\_\_ OPER. \_\_\_\_\_ SUPERVISOR \_\_\_\_\_

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. Revolver cleaned - platform & pit.

ATTACH TO MAKE CARD



DUP050107737



DUP050107738

