

S.V.

C.V. 901 903

D.V. 902,904

QPL

CG 32 CODE RT-880-D PKG ---

PROCESSES
() RT-880-D (G)APPROVED BY
EWK 12-31-81

OCT 28 1982

L2H76

(DATE)

(LOT NUMBER)

TYPED BY: JMH

EST. WT. ~~100~~ * LBS.

STANDARD HRS. 9.3

TIME 7 A.M.

PREPARATION NOTES:

Precoat Sparkler

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			
4	INSTALL DV & CV RECORDER & CONTROLLER CHART			

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921/ 931 2	5 RUN 12" (120G) WATER INTO V-921 & ADJ TO 80-100 DEG F 6 ADD IN 2-3 MIN DRESINATE XX 7 STIR 5 MIN & RECORD PH _____ (9.5-10.5) 8 STIR 20 MIN OR LONGER TO DISSOLVE FOR S36	115	99-A	115
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922 3	9 RUN 37" (762G) WATER INTO V-922 10 WEIGH IN SODIUM HYDROXIDE IN V-926 & RUN IN M 12, 50.16 % 11 TURN ON AGITATOR & STEAM & DUMP IN FROM S2	451	7-D 740-C	226 1157
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check weight
second yr
attached
sheet

	LOT	#100%	%	
2-CHLORO	321	319	98.30	325
4-AMINO	"	319	98.30	325
TOLUENE	"	319	98.30	325
5-SULFONIC	322	200	98.62	203
ACID				

DATE PRINTED: 1/13/62

EQUIP MENT		PAGE 2 OF 4 CG 32 CODE RT-880-D (G)	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>11:04</u> TOTAL MIN <u>11</u> CLARITY <u>good</u>			
	18	RECORD: HT <u>215°F</u> F & REC <u>good</u> F			

MISC	19	WEIGH SODIUM NITRITE IN PT-1 FOR S45			
4		M <u>9</u> , <u>33.36%</u> <u>1124</u>	725-A	375	
	20	WEIGH SODIUM NITRITE IN DRUM FOR S51			
		M <u>9</u> , <u>33.36%</u> <u>132</u>	725-A	44	
	21	WEIGH SODIUM NITRITE IN DRUM FOR S52			
		M <u>9</u> , <u>33.36%</u> <u>132</u>	725-A	44	
	22	MEASURE <u>66 3/4</u> UNITS IN V-928 FOR S42			
		HYDROCHLORIC ACID M <u>2</u> , <u>31.01%</u> <u>1796</u>	28-D	557	

904/ CV	23	RUN 1" (<u> </u> G) WATER INTO V- <u>201</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> </u> TOTAL MIN <u>11</u>			

902	25	RUN 63" (1648G) WATER INTO V-902			
6	26	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN			
		M <u>12</u> , <u>50.16%</u> <u>943</u>	7-D	473	
	27	DUMP IN FROM S3			
		3-HYDROXY LOT <u>8343</u>	82-C	1058	
		3-NAPHTHOIC ACID <u>8335</u>			
		<u>8346</u>			
	28	ADJ TO 70-90 DEG F & STIR TO DIS <u>110</u>	1-C		

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	31	RUN IN 5" (104G) WATER & HEAT TO 190-195 F			
9		CIRCULATE 15 MIN THRU SPARKLER.			

904/CV	32	PUMP V-922 THRU SPARKLER INTO V-904/CV			
10		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 (G)	USE LBS	N-CODE	ACCT LBS
904/CV 10 CONT	33	DISSOLVE ALKANOL XC IN 20G WATER AT 135-145 F WATER FROM HOT WATER MIXER IN DRUM & POUR IN	32	133-B	32
	34	HEAT V-904/CV TO 165-170 F FOR S41			
902 11	35	WHEN S28 COMPLETE, MEASURE TRISULPHOIL SOAP D IN CALIBRATED CONTAINER, SLURRY WITH 46G WATER IN DRUM & POUR INTO V-902	105	39-A	105
	36	STEAM EJECT IN V-921/931 FROM S8			
PT-2 12	37	RUN SODIUM HYDROXIDE INTO PT M <u>12</u> , <u>50.16%</u>	<u>263</u>	7-D	132
	38	ADJ TO 20" (72G)			
	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 13	40	RUN 1" (95G) WATER INTO V- <u>901</u>			
	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 _____			
	42	RUN IN N-28-D HYDROCHLORIC ACID FROM S22 IN 12-15 MIN.			
	43	STIR 5 MIN			
	44	ADJ TO 45" (4252G) AT 32-38 DEG F	47X330	57-A	<u>15410</u>
	44	RECORD: TEMP <u>28</u> F, STICK			
	45	RUN IN N-725-A SODIUM NITRITE FROM S19 AFAP (5-10 MIN), & RINSE IN			
	46	STIR 20 MIN AT 32-38 F MAINTAINING <u>CR</u> , +KI FOR S54 RECORD: TIME START <u>23</u> CR <u>+</u> (+) KI <u>+</u> (+) NOTE:		57-A	
		1) IF CR-, KI-, ADD 20# "AS IS" INCREMENTS RECORD: CR _____ (+) KI _____ (+) HYDROCHLORIC ACID ASSUME 32%		28-D	
		2) IF CR+, KI-, ADD 20# "AS IS" INCREMENTS RECORD: CR _____ (+) KI _____ (+) SODIUM NITRITE ASSUME 33%		725-A	
	47	DUMP IN CALCIUM CHLORIDE	1166	20-A	1166
	48	DUMP IN STRONTIUM NITRATE	255	246-B, E	255
		RECORD: CR _____ (+) KI _____ (+)			
	50	ADD FOR MAINTAINING AT 32-38 DEG F DURING COUPLING	37X330	57-A	<u>12510</u>
	51	POUR IN N-725-A SODIUM NITRITE FROM S20			
902 14	52	POUR N-725-A SODIUM NITRITE FROM S21 INTO V-902			
	53	DUMP IN AMMONIUM CHLORIDE & STIR 2-3 MIN	228	165-A	226
CV 15	54	IMMEDIATELY COUPLE 902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN. MAINTAIN CV AT 32-38 DEG F. RECORD: START <u>349</u> TOTAL MIN. <u>20</u>			
	55	INSTALL 5/16" ORIFICE IN UNDERSURFACE ADDITION LINE			
	56	WHEN S54 COMPLETE, STIR 30 MIN & RECORD BASE <u>-</u> (+) DIAZO <u>+</u> (+) PH <u>4.4</u> (5.0-6.0)			

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EQUIP MENT		PAGE 4 OF 4 CG 32 CODE RT-880-D (G)	USE LBS	N-CODE	ACCT LBS
CV	57	RUN IN N-7-D FROM S39 THRU 5/16" ORIFICE			
15		& RINSE IN RECORD: <u>50</u> MIN (40-50 MIN)			
CONT	58	STIR 20 MIN & RECORD: PH <u>7.0</u> (7.0-8.5)			
	59	IF PH BELOW 7.0 ADJ TO PH 7.0-8.5 WITH			
		N-7-D ONLY. RECORD PH		7-D	
	60	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN			
		ASSUME 50%	110	7-D	55
	61	STIR 15 MIN & RECORD: BASE <u>1</u> (+)			
		DIAZO <u>-</u> (-) PH <u>8.8</u> (9.0-9.8)			
	62	IF PH BELOW 9.0 ADJ TO PH 9.0-9.8 WITH			
		N-7-D ONLY. RECORD PH <u>9.7</u>			
		SODIUM HYDROXIDE ASSUME 50%	<u>60</u>	7-D	<u>30</u>
	63	MEASURE I OCTANOL IN CALIBRATED CONTAINER			
		& POUR IN	37	588-A	37
	64	HEAT TO 193-195 DEG F IN 75-80 MIN. RECORD			
		START <u>6:35pm</u>			
	65	RECORD: HT <u>183</u> DEG F & REC <u>194</u> DEG F			
	66	STIR 30 MIN AT 193-195 DEG F. RECORD:			
		START <u>7:55pm</u>			
	67	AFTER 20 MIN S66 STIR RECORD:			
		PH <u>8.9</u> (8.8-9.3)			
	68	IF PH BELOW 8.8, ADJ TO PH 8.8-9.3 WITH			
		N-7-D ONLY. RECORD PH <u>8.9</u>			
		SODIUM HYDROXIDE ASSUME 50%	<u>70</u>	7-D	<u>35</u>
	69	WHEN S66 COMPLETE, FLOOD TO 180-190"			
		(+/-18,000G)			
	70	STOP AGITATOR			
		<u>TAKEN FINAL SAMPLE</u>			
		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 <u>7:00am</u> FIN <u>3:20pm</u> OPTR <u>3:01</u>			
		<u>3:00pm</u> <u>9:10pm</u> <u>709</u>			

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11-740 - C CHECK-WEIGH & CALCULATE

NEWARK CHECK-WEIGH

DUP050060754



