CG 32 CODE RT-761-D PKG. _____

→ MAY -0-81-Z1026

EST. WGT. ~~2700~~ 2710 LBS.

STD. HRS. _____ TIME _____ M

PROCESSES		APPROVED BY
( ) RT-761-D	(J)	JJG 4-4-78
( ) RT-838-D	(I)	DCG 4-5-78
( )	( )	MTW 4-13-78
( )	( )	
TYPED BY		
NSA 4-19-78		

92

1

NON-BLEEDING

IPMENT		NAME: WATCHUNG® RED B	USE LBS.	N CODE	ACCT. LBS.
		NOTE: Do not start if press will not be available within 3 Hrs after making. Making Supv to review with P.R. Supv. & Record: Press will be ready M / P.R. Supv. Start Making M / Making Supv.			
Prep 1	1	Record: Batches since Sparkler last cleaned.			
		After 5 batches, clean, dress Sparkler & pre-coat with 15#		777-A	
	2	Obtain for S 12		740-C	
	3	Obtain for S 27		82-C	
	4	Install DV & CV Recorder & Controller charts			
S21/ S31	5	Run 16" (160 G) water into V- & adj to 80-100°F			
	6	Add in 2-3 min	110	99-A	110
	7	Add in 1-2 min	50	530-A	50
	8	Stir 5 min & Record: pH (9.5-10.5)			
	9	Stir 20 min or longer to dissolve for S 30			
S22 3	10	Run 35" (722 G) water into V-922			
	11	Weigh in V-926 & run in M , %		7-D	216
	12	Turn on agitator & steam & dump in from S 2 Lot #100% %		740-C	1105
	13	Dump in	25	113-A	25
	14	Dump in	10	777-A	10
	15	Heat to 212-214°F Watch Foam			
	16	Record: BY must be +. Adj if needed Assume 50%		7-D	
	17	Stir 15 min at 212-214°F, then shut off steam. Watch Foam			
	18	Record: HT F & Rec F			
	19	Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 24			
Misc. 4	20	Measure units in V-928 for S 39 & M %		28-D	533
	21	Weigh in PT for S 42 M , %		725-A	401
	22	Weigh in drum for S 48		725-A	40
904/CV 5	23	Run 1" (G) water into V-			
		Note: Use CV if MTY. If CV is not MTY, use V-904			
	24	When S 19 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start Total Min			

EQUIPMENT		PAGE 2 CG 32 CODE RT-761-D (J) LBS.	USE LBS.	N CODE	ACCT. LBS.
902	25	Run 56" (1566 G) water into V-902			
6	26	Weigh in V-926 & run in M %		7-D	682
	27	Dump in from S 3 Lot		82-C	1012
	28	Adj to 70-90°F & stir 10 min to dissolve			
	29	Slurry in 30 Gal water & pour into V-902	100	39-A	100
	30	Steam eject in V-921-931 from S 9			
922 &	31	When S 24 complete, stop pump & insert V-922 foot plug			
904/CV	32	Run in 12" (247 G) water & heat to 180-190°F			
7	33	Pump V-922 thru sparkler into V-904/CV			
	34	When V-922 MTY blow out sparkler into V-904/CV			
	35	Weigh & add to V- Lot	18 oz	749-C	1
	36	Heat V-904/CV to 165-170°F for S 39			
		NOTE: If N-740-C solution was pumped directly from sparkler to CV at S's 23 & 24 omit S's 37 & 38			
CV	37	Run in 1" (95 G) water into V-			
8	38	If V-904 is used, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min) maintain CV at 165-170°F			
	39	Run in N-28-D from S 21 in 12-15 min			
	40	Stir 5 min			
	41	Adj to 43" (4080 G) at 32-38°F	45 x 330	57-A	
	42	Run in N-725-A from S 21 AFAP (5-10 min)			
	43	Stir 10 min at 32-38°F maintaining + CR, + KI			
		Record: Time Start 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 (+)			
	44	Dump in	1116	20-A	1116
	45	Dump in	244	246-B	244
	46	Dump in	130	65-A	130
	47	Add for maintaining 32-38°F during coupling	36x330	57-A	
902	48	Pour N-725-A from S 22 into V-902			
9	49	Dump in	189	165-A	189
CV	50	Immediately couple V-902 thru undersurface distributor into			
10		CV in 18-22 min. Maintain CV at 32-38°F			
		Record: Start Total Min			
	51	Stir 5 min & Record: Base (+), Diazo (-)			
		pH (9.0-9.8)			
	52	If necessary, adj to pH 9.0-9.8 Record: pH Assume 50%		7-D	
		Assume 32%		28-D	
	53	Weigh in drum & pour in	45	588-A	45
	54	Heat to 184-186°F in 70-75 min			
	55	Record: HT °F & Rec °F			
	56	Stir 30 min at 184-186°F			
	57	After 10 min S 56 stir, record: pH (8.8-9.3)			
	58	If necessary, adj to pH 8.8-9.3 Assume 50%		7-D	
		Record: pH If pH above 9.3 do not adjust			
	59	When S 56 complete, flood to 180-190" (± 18000 G) & stop agitator			

DUP050098190

EQUIPMENT		PAGE 2 CO 32 CODE RT-761-D (J), RT-838-D (H) LBS.	USE LBS.	N/A CODE	ACCT. LBS.
902 6-	25	Run 56" (1566 G) water into V-902			
	26	Weigh in V-926 & run in M 7 48.29 %	1506	7-D	735
	27	Dump in from S 3 Lot 0420	1058	82-C	1058
	28	Adj to 70-90°F & stir 10 min to dissolve			
	29	Slurry in 30 Gal water & pour into V-902	105	39-A	105
	30	Steam eject in V-921-931 from S 9			
922 & 904/CV 7	31	When S 24 complete, stop pump & insert V-922 foot plug			
	32	Run in 10" (247 G) water & heat to 180-190°F & Circulate 15 Min thru Sparkler			
	33	Pump V-922 thru sparkler into V-904/CV (See Below for S 33)			
	34	When V-922 MTY blow out sparkler into V-904/CV			
	35	Weigh & add to V- Lot E8007	4	148-C	4
	36	Heat V-904/CV to 165-170°F for S 39			
		NOTE: If N-740-C solution was pumped directly from sparkler to CV at S's 23 & 24 omit S's 37 & 38			
CV 8	37	Run in 1" (95 G) water into V-			
	38	If V-904 is used, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min) maintain CV at 165-170°F			
	39	Run in N-28-D from S 21 in 12-15 min			
	40	Stir 5 min			
	41	Adj to 43" (4080 G) at 32-38°F	50 x 330	57-A	16520
	42	Run in N-725-A from S 21 AFAP (5-10 min)			
	43	Stir 30 min at 32-38°F maintaining + CR, + KI			
		Record: Time Start 5:45p 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 (+)			
	44	Dump in	1166	20-A	1166
	45	Dump in	255	246-B	255
	46	Dump in	135	65-A	135
	47	Add for maintaining 32-38°F during coupling	36x330	57-A	11880
902 9	48	Pour N-725-A from S 22 into V-902			
	49	Dump in	189	165-A	189
CV 10.	50	Immediately couple V-902 thru undersurface distributor into CV in 18-22 min. Maintain CV at 32-38°F			
		Record: Start 7:15p Total Min 25			
	51	Stir 30 min & Record: Base + (+), Diazo — (-) pH 10.4 (10.0-10.5)			
	52	If necessary, adj to pH 10.0-10.5 Record: pH Assume 50%		7-D	
		Assume 32%		28-D	
	53	Weigh in drum & pour in	45	588-A	45
	54	Heat to 184-186°F in 70-75 min (AT 150°F, OPEN WATER SPRAYS 1/4 TURN)			
	55	Record: HT 185 °F & Rec 183 °F			
	56	Stir 30 min at 184-186°F			
	57	After 10 min S 56 stir, record: pH (9.5-10.0)			
	58	If necessary, adj to pH 9.5-10.0 Assume 50%		7-D	
		Record: pH 9.8 if pH above 10.0 do not adjust			
	59	When S 56 complete, flood to 180-190" (± 18000 G) & stop agitator			
		SHUT OFF WATER SPRAYS			
922/904/CV	33	RUN IN 5" (190G) WATER INTO V922. HEAT TO 190-195F. CIRCULATE [illegible]			

DUP050098191

EQUIPMENT	PAGE 3 CG 32 CODE RT-761-D (J), RT-838-D (H)	USE LBS.	N CODE	ACCT. LBS.
	When instructed by Processing Area half-way thru pressing			
	1. Dump in	10	588-A	10
	2. Stir 5 min			
	3 Advise processing to resume pressing			

START	FIN	OPTR
7:00 AM	3:00 AM	322
3:PM	10:Pm	223

DELAY NO OK ON PRESS FROM P.R.
No Light in V-905, Socket is cracked.

1741
863
878

QUIPMENT		PAGE 3 CG 32 CODE RT-698-D (L) EST WGT. 2220 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 14	57	When S 52 complete, strike V-902 at 155-160°F thru under surface distributor into CV in 2-3 min			
		Record: Start Total Min			
	58	Heat CV to 193-195°F in 10-15 min			
	59	Stir 60 min at 193-195°F Record: Start			
	60	After 20 min S48 stir Record: pH (8.8-9.3)			
	61	If necessary, adj to pH 8.8-9.3 Assume 50%		7-D	
		& Record: pH Assume 32%		28-D	
	62	After S 59 stir flood to 180-190" (±18000 G) & stop agitator			
		When instructed by Processing Area half way thru pressing,			
		(1) Dump in	10	588-A	10
		(2) Stir 5 min			
		(3) Advise Processing to resume pressing			
		START FIN OPTR			

FORM A

CODE RT-761 LOT E-1026 VATS 903, 922, 802 EQUIP. SPARKLER

DATE 4/30/81 OPER M. NELSON SUPERVISOR [signature]

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 after finished - hatches on abbe's.
19. All tools cleaned & placed in rack or proper place.
20. Ice house clean - tools on racks.
21. Revolvator cleaned - platform & pit.

ATTACH TO MAKE CARD

DUP050098194

FORM "B"

POOR _____
FAIR _____
GOOD _____
EXCELLENT _____

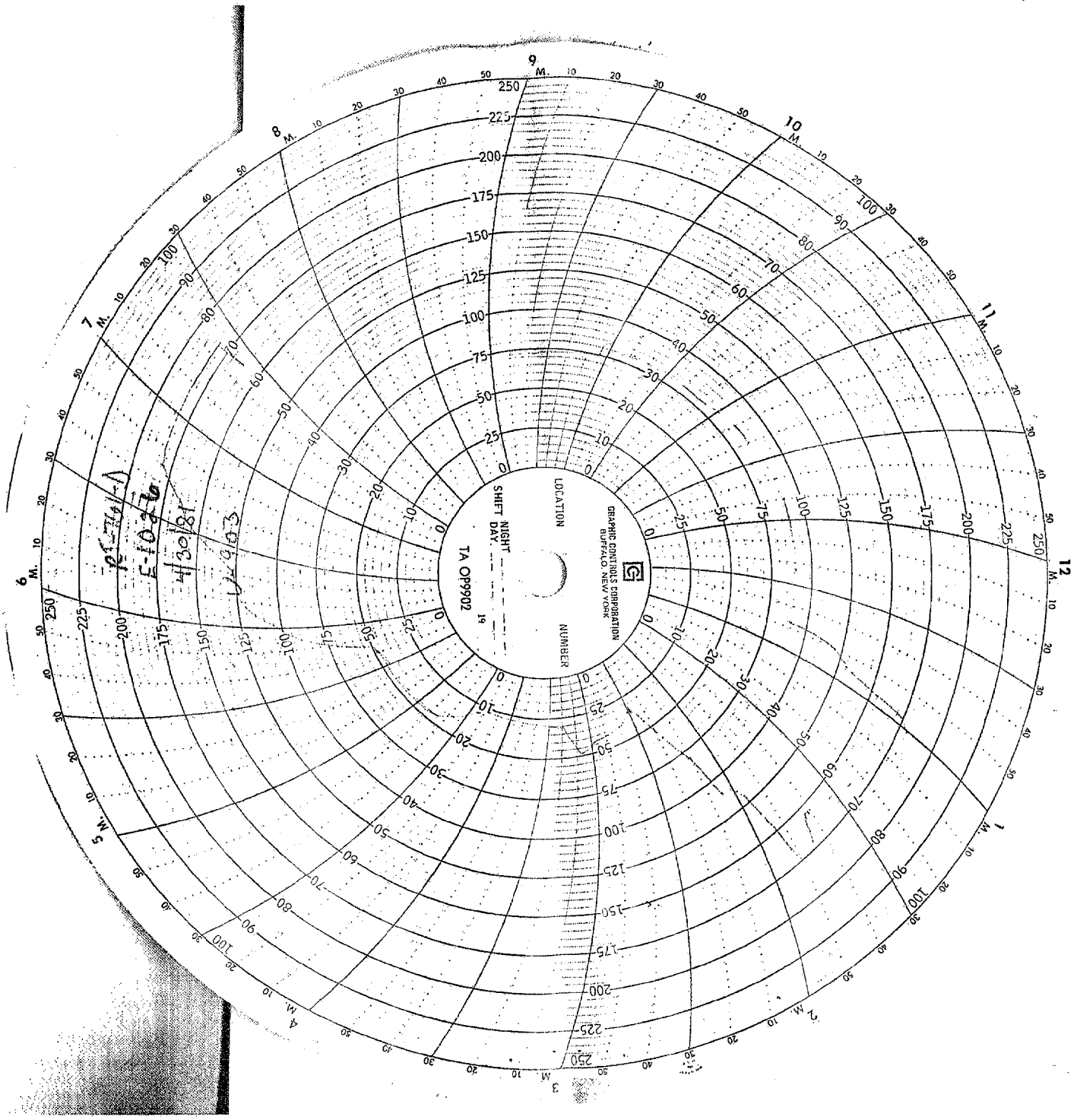
FORM TO OPERATOR TO CLEAN EQUIPMENT

HOUSEKEEPING - EQUIPMENT _____ RATING P, F, G, E,

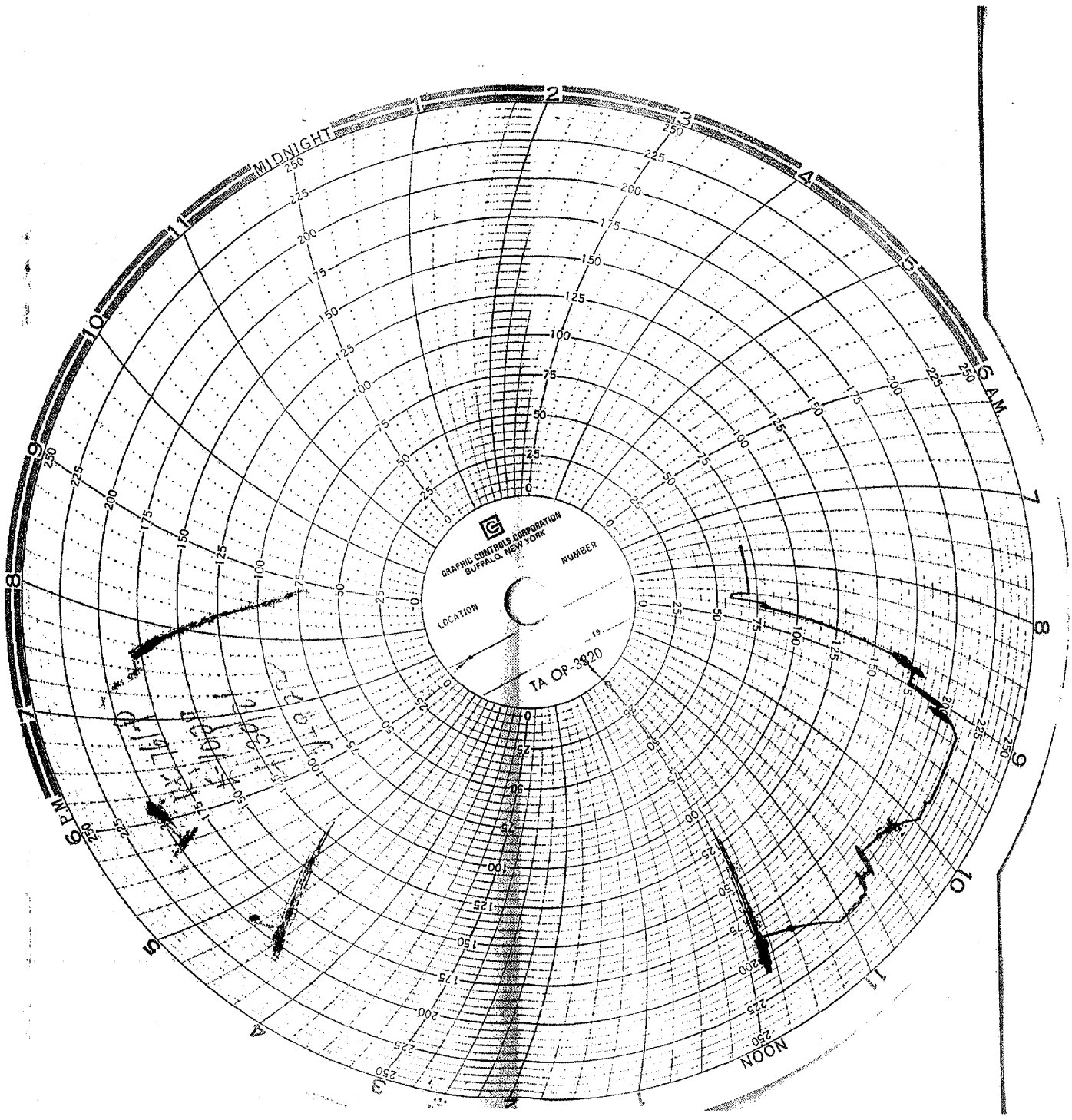
1. Scrub color off top & sides. _____
2. SCRAPE or scrube steel work. _____
3. Scrape floor. _____
4. Scrub floor. _____
5. Sweep Floor. _____
6. Scrape & scrub under & around vat. _____
7. Align hoses. _____
8. Store hoses in racks. _____
9. Store tools. _____
10. Discard bolts, strings, paper, etc. _____
11. Sweep up debris before hosing pad. _____
12. Coil Water hoses. _____
13. Discard material from strainer permanently. _____
14. Pails or containers painted, N-Code. _____
15. Patch bags, consolidate stumps. _____
16. Repairs needed:
    1. Lag steam lines. _____
    2. Repair batch covers. _____
    3. Repair leaks (pump, valve etc.) _____
    4. Repair manhole cover or chains. _____
    5. Paint. _____
    6. Measuring sticks. _____
    7. Scales _____
    8. Misc. - _____ _____

OPERATOR _____
SUPERVISOR _____

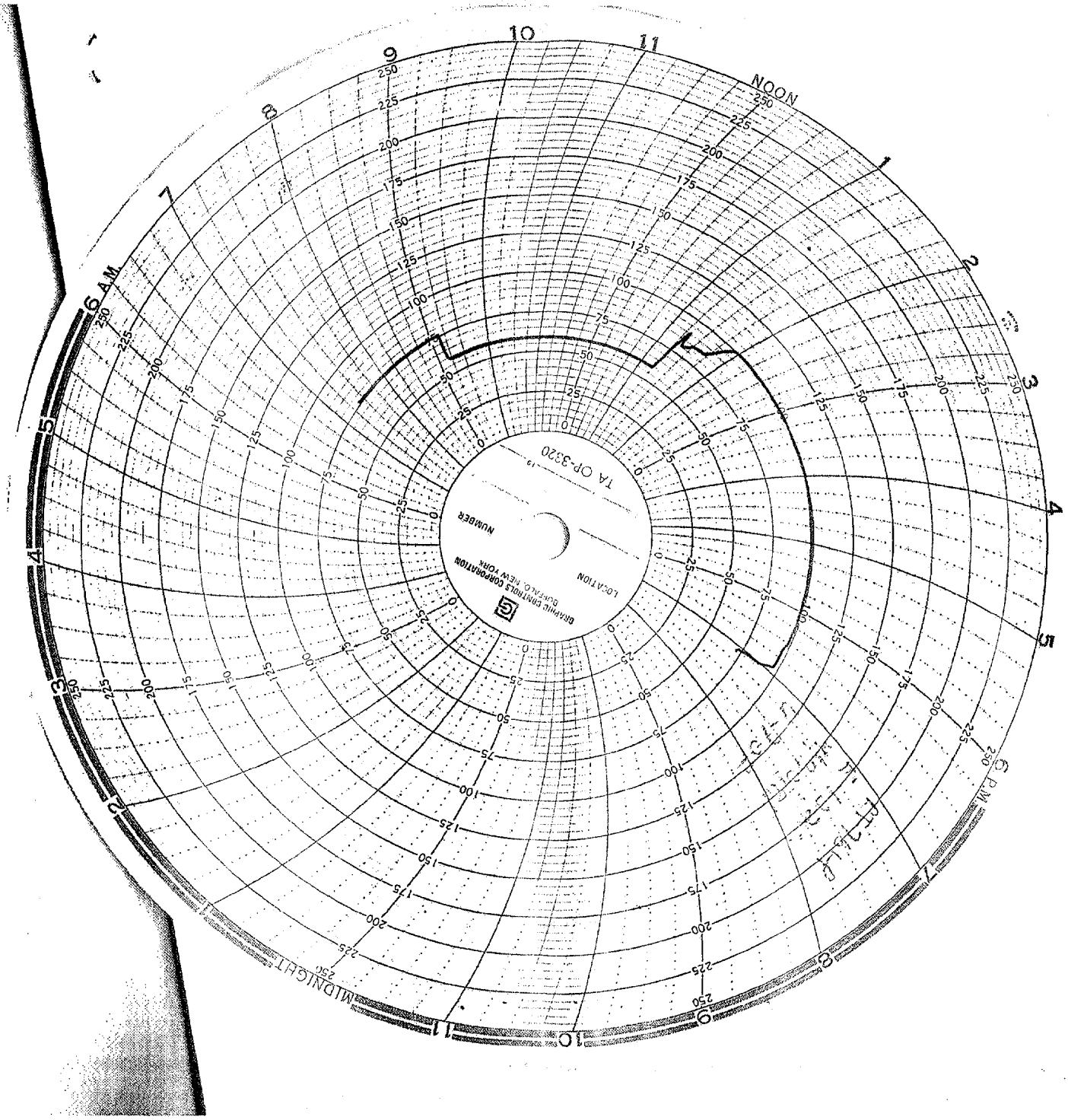
DUP050098195



DUP050098196



DUP050098197



DUP050098198