

S.V.

C.V. 901, 903

D.V. 902, 904

CG 32 CODE RT-428-D PKG.

→ MAY -0.81-31175

EST. WGT. 3219 LBS.

STD. HRS. TIME M

PROCESSES		APPROVED BY	
()	RT-428-D	(V)	JJG 07-10-78
()	RC-14-A	()	DCG 08-10-78
()	RT-139-P	(O)	MW 08-11-78
()		()	
TYPED BY			
emw081878			

NON-BLEEDING

EQUIPMENT	NAME:	WATCHUNG® RED B	USE LBS.	N CODE	ACCT. LBS.
	Note:	Do not start if press will not be available within 3 hours 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 11		740-C	
	3	Obtain for S 40		82-C	
	4	Install DV & CV Recorder & Controller Charts			
921/931 2	5	Run 10" (100 G) water into V- 931 & heat to 80-100°F			
	6	Add in 2-3 min	150	530-A	150
	7	Stir 5 min & Record: pH 10.0 (9.5-10.5)			
	8	Stir 20 min or longer to dissolve for S 43			
922 3	9	Run 35" (722 G) water into V-922			
	10	Weigh in V-926 & run in M 8, 49.83%	456	7-D	227
	11	Turn on agitator & steam & dump in from S 2		740-C	1162
		Lot #100% 173 1162 99.9	1163		
	12	Dump in	25	113-B	25
	13	Dump in	10	777-A	10
	14	Heat to 212-214°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 21 Record: Start 8:30 A Total Min 15 Clarity CLEAR HT 195°F & Rec 195°F			
Misc 4	18	Measure 37 1/2 units in V-928 for S 33 M 2, 32.00%	1750	28-D	560
	19	Weigh in PT for S 36 M 7, 32.93%	1124	725-A	370
904/CV 5	20	Run 1" () G) water into V- 903			
	21	Note: Use CV if MTY. If CV is not available use V-904 When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 8:45 Total Min 25			

EQUIPMENT	PAGE	CG	32 CODE	RT-428-D (V)	EST. WGT.	3066	LBS.	USE LBS.	N CODE	ACCT. LBS.
902 6	22	Run	56" (1618 G) water into V-902							
	23	Weigh in	V-926 & run in	M. 8	49.83%	347		7-D	123	
	24	Dump in & stir	to smooth slurry for S 41			557		542-A	557	
922 7	25	When S 21 complete,	stop pump & insert V-922 foot plug							
	26	Run in	13" (309 G) water & heat to 180-190°F. CIRCULATE 18 MIN THRU SPARKLER - PUMP							
904/CV 8	27	Run in	9" (177 G) water into V-922 & heat to 180-190°F. CIRCULATE 15 MIN THRU SPARKLER							
	28	Pump V-922 thru	Sparkler into V-904/CV							
	29	When MTY blow out	Sparkler into V-904/CV							
	30	Pour in				63		979-D	63	
	31	Heat to	165-170°F							
CV 9		NOTE:	If N-740-C sol'n (S's 20 & 21) was pumped directly from Sparkler to CV, omit (S's 31 & 32)							
	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	43" (4080 G) at 32-38°F			6056x330		57-A	19800	
	36	Run in	N-725-A from S 19 AFAP (5-10 min)							
	37	Stir	30 min at 32-38°F maintaining +CR, +KI							
		Record:	Time Start 11:35 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				256		246-E	256	
	39	Dump in				493		65-A	493	
	40	Dump in from	S 3 & stir 10 min					82-C	1063	
						6181	1017			
						6094	46			
902 10	41	Dump into	V-902 & stir 2-3 min			231		165-A	231	
CV 11	42	Immediately after	S 41 complete, pump V-902 thru undersurface distributor into CV in 18-20 min. Let CV temp rise freely. Record: Start 1:30 P Total Min							
	43	Immediately after	S 42 complete, steam eject V-921/931 into CV							
	44	Stir/5 min & Record:	Diazo - (-), Base + (+) pH 9.5 (9.0-9.8), Temp 55°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/93°F & Rec/95°F							
	48	Stir	15 min at 193-195°F Record: Start 4:05 P							
	49	Record:	pH 8.7 (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 agitation, resume pressing			10		588-A	10	
		START	7:10 A.M.	FIN	3:10 P.M.	OPTR	54-196			
			3:00 P.M.		4:00 P.M.					





