S.V. C.V. 901, 903 D.V.

CG 32 CODE RT-428-D PKG. _____

→

EST. WGT. 2288 LBS.

STD. HRS. _____ TIME _____ M

PROCESSES			APPROVED BY
( )	RT-428-D	(T)	DCG 7/17/73
(D)	RC- 14-A	( )	IHD 7/19/73
(H)	RT-663-D	( )	JJG 4/ 9/74
( )		( )	
retyped by emw 091975			

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 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	If necessary, clean, dress Sparkler & pre-coat with 15#		777-A	
	2	Obtain for S 11		740-C	
	3	Obtain for S 38		82-C	
	4	Install DV & CV Recorder & Controller charts			
921/931 2	5	Run 10" (100 G) water into V- _____ & heat to 80-100°F			
	6	Add in 2-3 min	100	99-A	100
	7	Stir 5 min & Record: pH _____ (9.5-10.5)			
	8	Stir 20 min or longer to dissolve for S 41			
922 3	9	Run 28" (577 G) water into V-922			
	10	Weigh in V-926 & run in M _____, _____ %		7-D	165
	11	Turn on agitator & steam & dump in from S 2 Lot #100% %		740-C	843
	12	Dump in	25	113-A	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 15 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 _____, Total Min _____, Clarity _____, HT _____°F & Rec _____°F			
CV 4	18	Run 6" (669 G) water into V- _____			
	19	Measure _____ units in V-928 & run in M _____, _____ %		28-D	406
904 5	20	Run 2" (58 G) water into V-904			
	21	When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start _____ Total Min _____			
902 6	22	Run 45" (1300 G) water into V-902			
	23	Dump in & stir to smooth slurry for S 39	400	542-A	400

emw091975

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EQUIPMENT			USE LBS.	N CODE	ACCT. LBS.
MISC 7	24	Weigh in PT for S 33 M ____, ____ %		725-A	268
922 8	25	When S 21 complete, stop pump & insert V-922 foot plug			
	26	Run in 15" (309 G) water & heat to 180-190°F			
904 9	27	Pump V-922 thru Sparkler into V-904			
	28	When MT blow out Sparkler into V-904			
	29	Pour in	48	979-A	48
	30	Heat to 165-170°F			
CV 10	31	When S 30 complete, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min) Record: Start ____ Total Min ____			
	32	Adj to 34" (3223 G) at 32-38°F using Mano	40 x 330	57-A	____
		Record: Mano ____ " Stick ____ "			
	33	Run in N-725-D from S 24 AFAP (5-10 Min)			
	34	Stir 10 min at 32-38°F maintaining +KI M ____, ____ %		725-A	____
	35	Record: KI ____ (+)			
	36	Dump in	186	246-B	186
	37	Dump in	350	65-A	350
	38	Dump in from S 3 & stir 10 min Lot ____		82-C	771
902 11	39	Pour into V-902	190	122-D	190
CV 12	40	Immediately after S 39 complete, run V-902 thru undersurface distributor into CV in 18-22 min Record: Start ____ Total Min ____			
	41	Immediately after S 40 complete, steam eject V-921/931 into CV			
	42	Stir 5 min & Record: Diazo ____ (-), Base ____ (+) pH ____ (9.0-9.8), Temp ____ °F (50-60°F)			
	43	If necessary, adj to pH 9.0-9.8 Assume 50%	____	7-D	____
		& Record: pH ____ M ____, ____ %		28-D	____
	44	Heat to 173-175°F in 55-65 min & Record: HT ____ °F Rec ____ °F			
	45	Stir 60 min at 173-175°F Record: Start ____			
	46	After 20 min S 45 stir, Record: pH ____ (8.8-9.3) & if necessary, adj to pH 8.8-9.3 & Assume 50%	____	7-D	____
		Record: pH ____ M ____, ____ %		28-D	____
	47	After S 45 stir, flood to 180-190" (≈18,000 G) & stop agitator			

START FIN OPTR

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DATE PRINTED: 5/11/81

EQUIPMENT		PAGE 2 OF 3 CG 32 CODE RT-870-D (D)	USE LBS	N-CODE	ACCT LBS
922 3 CONT	17	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 DEG F FOR S22. RECORD: START 2:45 PM TOTAL MIN 60 CLARITY OK HT 195 F & REC 195 F			
CV 4 1/2	~~18~~ ~~19~~	RUN 8" (710 G) WATER INTO CV ~~904~~ 901 MEASURE 65 1/2 + 65 1/2 UNITS IN V 928 & RUN IN M 2, 32.00%	1743	28-D	558
904 5	20 ~~21~~	~~RUN 2" (58G) WATER INTO V 904~~ WHEN S17 IS COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F. RECORD: START 345 TOTAL MIN 60			
MISC 6	~~22~~	WEIGH IN PT FOR S 39 M 7 32.93%	1145	725-A	377
922 7	~~23~~ ~~24A~~ ~~24B~~	WHEN S 21 COMPLETE, SHUT OFF PUMP & INSERT V 922 FOOTPLUG RUN IN 10" (209G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER AND PUMP V-922 THRU SPARKLER INTO V-904		[illegible]	[illegible]
902 8	~~25~~ ~~26~~ ~~27~~ ~~27A~~	RUN 56" (1566 G) WATER INTO V 902 WEIGH IN V-926 & RUN IN M 8, 49.83% DUMP IN FROM S 3 6292-250 6179-750 6191-20 LOT 6182 WEIGH ON POSTAL SCALE & DUMP IN LOT 85041	702 20 18	7-D 82-C 180-C	350 1040 18
922 9	~~28~~	RUN IN 5" (104G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904 10	~~29~~ ~~30~~ ~~31~~ ~~32~~	PUMP V-922 THRU SPARKLER INTO V-904 WHEN MTY BLOW OUT SPARKLER INTO V-904 DISSOLVE IN 20G WATER AT 150-160 F IN DRUM AND POUR IN HEAT TO 165-170 F FOR S37	5	133-B	5
932 11	~~33~~ ~~34~~ ~~35~~ ~~36~~	RUN 15" (308G) WATER INTO V-932 & ADJ TO 80-100 DEG F. ADD IN 6-7 MIN STIR 5 MIN & RECORD PH 10.2 (9.5-10.5) STIR 20 MIN OR LONGER TO DISSOLVE FOR S59	362	530-A	362

873 1746

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5-0
1650

DATE PRINTED: 5/11/81

EQUIPMENT		PAGE 3 OF 3 CG 32 CODE RT-870-D (D)	USE LBS	N-CODE	ACCT LBS
CV 11	37	WHEN S 32 COMPLETE, PUMP V 904 AT 165-170 DEG F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (12-15 MIN)	5X330	N57	1650
		RECORD: START ✓ TOTAL MIN. ✓	60X330		
	38	ADJ TO 43" (4080G) AT 32-38DEG F USING MANO	19800	57-A	1980
		RECORD: MANO ✓ " STICK 62 "			
	39	RUN IN N-725-A FROM S 22 AFAP (5-10 MIN)			
	40	STIR 30 MIN AT 32-38 DEG F MAINTAINING +KI M_____.____%		725-A	
	41	RECORD: KI + (+)			
	42	DUMP IN:	1087	20-A	1087
	43	DUMP IN	72	246-B	72
902 12	44	WHEN S28 COMPLETE, STEAM EJECT V-921/931 FROM S8 INTO V-902			
	45	POUR IN	261	122-D	261
CV 13	46	IMMEDIATELY COUPLE V-902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN. RECORD: START 35 TOTAL MIN 20			
PT 14	47	WHILE COUPLING S 48 WEIGH IN PT M 8, 49.83 %	301	7-D	150
	48	DILUTE TO MAXIMUM VOLUME (+,-100G) FOR S 52			
CV 15	49	WHEN S46 COMPLETE, STIR 5 MIN & RECORD: DIAZO + (+) BASE + (+) PH 5.2 (5.0-6.0) TEMP 60 (50-60 F)			
	50	RUN IN PT FROM S48 THRU UNDERSURFACE LINE AND STIR 15 MIN.			
	51	RECORD: DIAZO − (-) BASE + (+) PH 9.2 (9.0-9.8)			
	52	RUN IN N-246-E SOL'N FROM S48 → ? IM.			
	53	STEAM EJECT IN V-932 FROM S36			
	54	STIR 15 MIN & RECORD: PH 9.2 (9.0-9.8)			
	55	IF PH BELOW 9.0 ADJ TO PH 9.0-9.8 WITH N-7-D ONLY. RECORD PH_____ ASSUME 50%		7-D	
	55	MEASURE IN CALIBRATED CONTAINER & POUR IN	35	588-A	35
	56	HEAT TO 193-195 DEG F IN 70-75 MIN & RECORD HT 195 DEG F AND REC 195 DEG F			
	57	STIR 60 MIN AT 193-195 DEG F. RECORD: START 10:25			

STIR
10:25
11:25

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