

S.V.

APR 15 1981

C.V. 901 903

D.V.

CG 32 CODE RC-14-A PKG ---

PROCESSES

APPROVED BY

MAY-0-81 E 1003

() RC-14-A (G)
() ALTERNATE ()
() ()

(DATE) (LOT NUMBER)

TYPED BY: JMH

ESTIMATED WGT 2997 LBS. STANDARD HRS. TIME M

PREPARATION NOTES:

EQUIP- MENT	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			
	NOTE: NOTIFY PRESS ROOM & ROPE OFF AREA UNDER V-922			

PREP 1	1 IF NECESSARY, CLEAN, DRESS SPARKLER & PRE- COAT WITH 15# (FILTER AID)		777-A	
	2 OBTAIN FOR S11 (RED 2B ACID DUPONT)		740-D	
	3 OBTAIN FOR S35 (BON CYANAMID)		253-C	
	4 INSTALL DV & CV RECORDER & CONTROLLER CHART			

921 2 V931	5 RUN 10" (100G) WATER INTO V-921 & HEAT TO 85-100 DEG F			
	6 ADD IN 2-3 MIN (DRESINATE X)	125	530-A	125
	7 STIR 5 MIN & RECORD: PH 9.7 (9.5-10.5)			
	8 STIR 20 MIN OR LONGER TO DISSOLVE FOR S45			

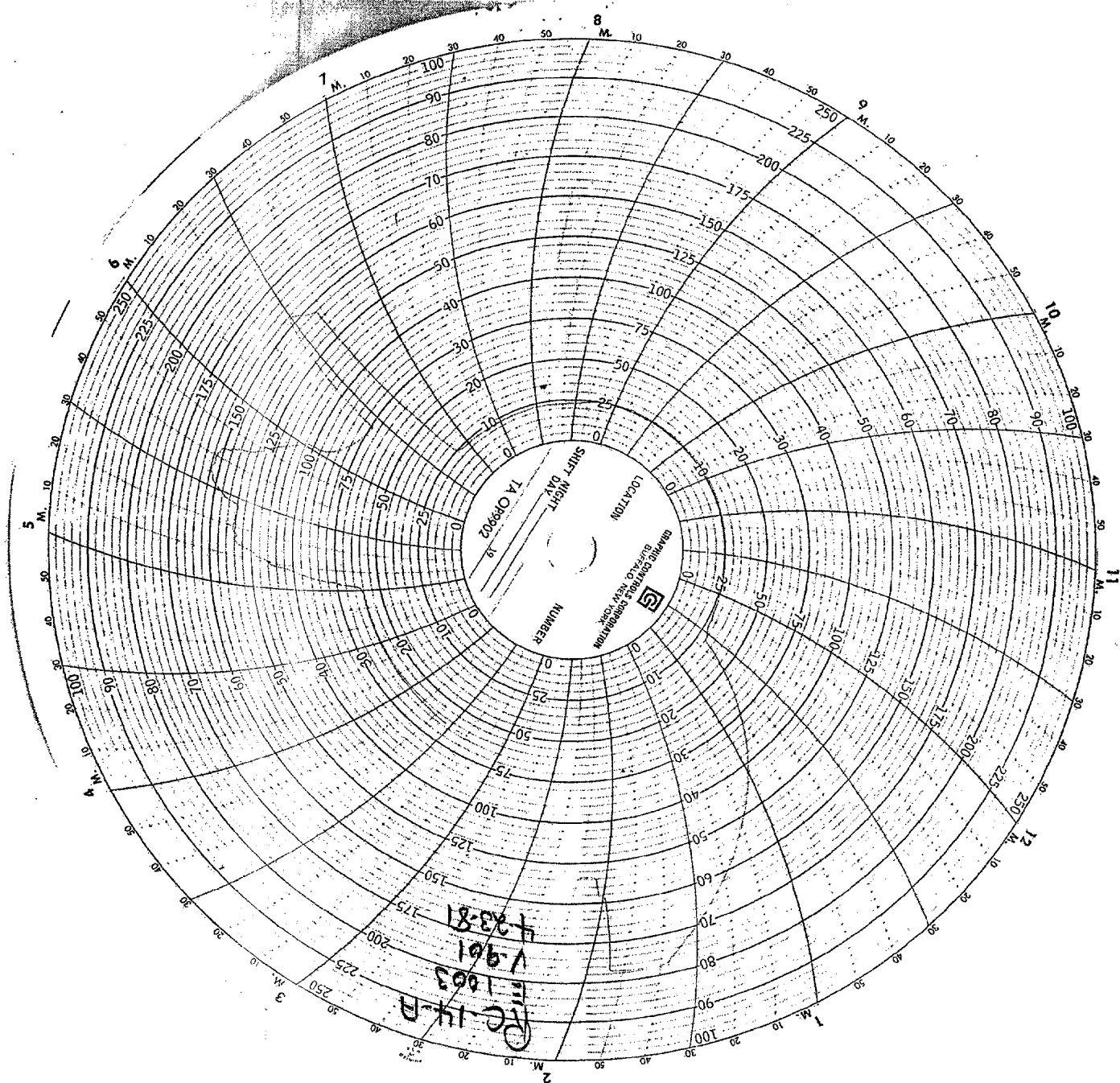
922 3	9 RUN 35" (722G) WATER INTO V-922			
	10 WEIGH IN V-926 & RUN IN M 9.48.79 % 443		7-D	216
	(CAUSTIC SOLUTION)			
	11 TURN ON AGITATOR & STEAM & DUMP IN FROM S2		740-C	1107
	LOT #100% % 163 110.7 99.9 1108			
	12 DUMP IN (ACTIVATED CARBON)	25	113-A	25
	13 DUMP IN	10	777-A	10
	14 HEAT TO 212-214 DEG F RECORD: HT DEG F			
	REC 212 DEG F WATCH FOAM.			
	15 RECORD: BY (+) IF NECESSARY ADJ TO +BY ASSUME 50%		7-D	

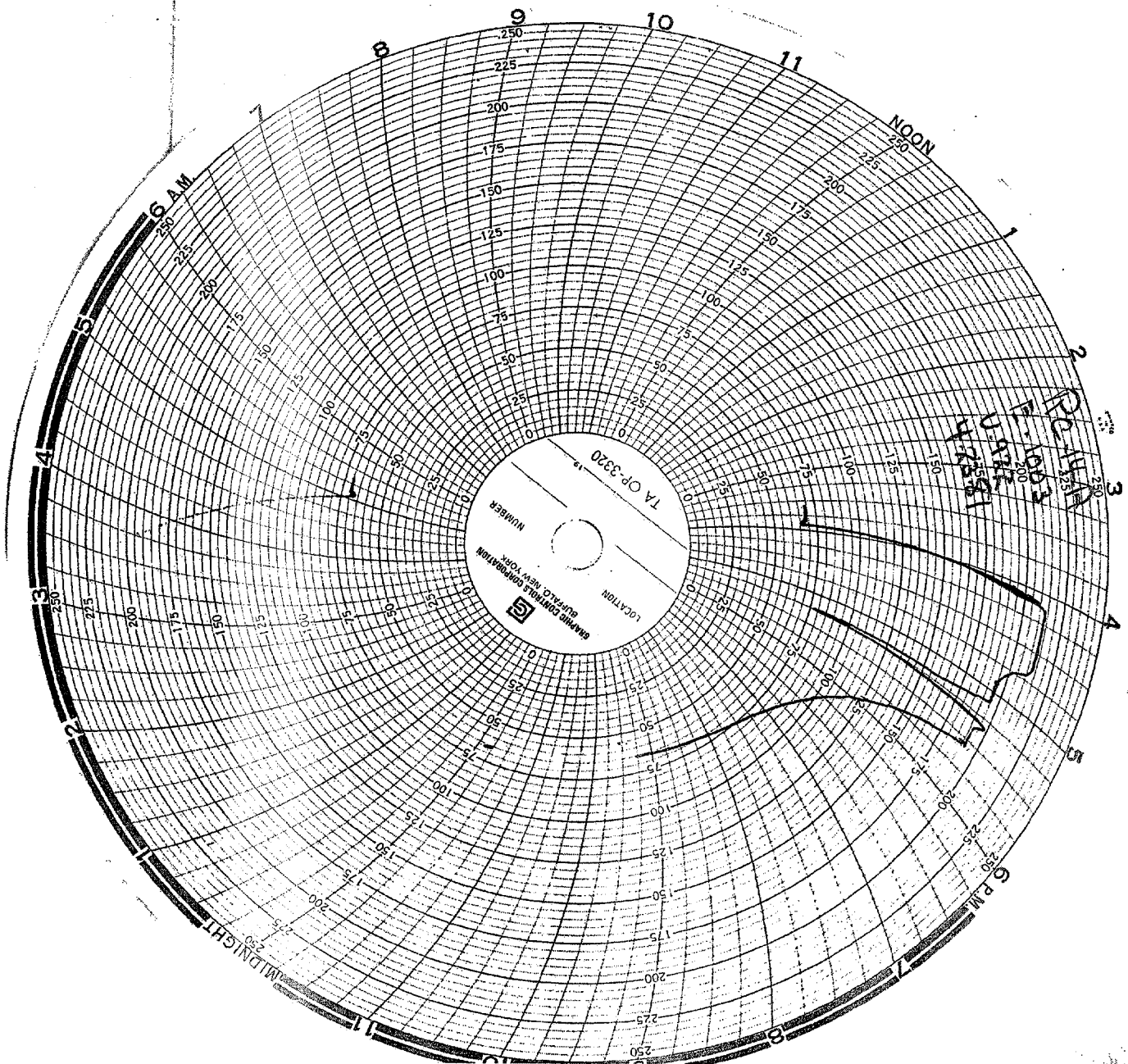
MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 2 OF 3 CG 32 CODE RC-14-A (G)	USE LBS	N-CODE	ACCT LBS
922 3 CONT	16	STIR 30 MIN AT 212-214 DEG F THEN SHUT OFF STEAM. WATCH FOAM. RECORD: SPARKLER PRESSURE <u>0</u> PSI, IF NOT ZERO NOTIFY SUPVR 17 CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 F FOR S20. RECORD: START <u>2408</u> , TOTAL MIN <u>15</u> , CLARITY <u>OK</u> HT <u>188</u> DEG F, REC <u>200</u> DEG F			
MISC 4	18	MEASURE <u>9234</u> UNITS IN V-928 FOR S30 (HYDROCHLORIC ACID) M <u>2</u> , <u>32.00</u> %	<u>1666</u>	28-D	533
CV 5	19 20	RUN 6" (669G) WATER INTO V- <u>901</u> WHEN S17 COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 F. RECORD: START <u>4351</u> TOTAL MIN <u>25</u>			
904 6	21 22	RUN 90" (2600G) WATER INTO V-904 DUMP IN AND STIR TO SMOOTH SLURRY (LIME HYDRATED)	525	542-A	525
	22A	ADD AND STIR FOR S39 ASSUME 50%	52	7-D	26
MISC 7	23	WEIGH IN PT FOR S32 (SODIUM NITRITE) M <u>6</u> , <u>33.68</u> %	<u>1045</u>	725-A	352
922/CV 8	24 25	WHEN S20 COMPLETE, STOP PUMP & INSERT V-922 FOOT PLUG RUN IN 10" (209G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER PUMP V-922 THRU SPARKLER INTO CV			
CV/922 9	26A 26B 27 28 29 30 31 32 33	RUN IN 5" (104G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER PUMP V-922 THRU SPARKLER INTO CV WHEN HT BLOW OUT SPARKLER INTO CV POUR IN (IGEPAL CO-630) HEAT TO 165-170 DEG F RUN IN N-28-D FROM S18 IN 12-15 MIN ADJ TO 43" (4080G) AT 32-38 DEG F USING MANO (ICE) RECORD: MANO _____ STICK _____ RUN IN N-725-D FROM S23 AFAP (5-10 MIN) STIR 20 MIN AT 32-38 DEG F MAINTAINING +CR, +KI. RECORD: CR <u>+</u> (+) KI <u>+</u> (+) NOTE: (1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS ASSUME 32% RECORD: CR _____ (+) KI _____ (+) (2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS ASSUME 33% RECORD: CR _____ (+) KI _____ (+)	60 50X330	979-A 57-A 28-D 725-A	60 <u>6500</u>

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 3 OF 3 CG 32 CODE RC-14-A (G)	USE LBS	N-CODE	ACCT LBS
CV 9	34	DUMP IN (BLANC - FIXE F)	450	65-A	450
CONT	35	DUMP IN FROM S3 & STIR 10 MIN LOT <u>534</u>	<u>1010</u>	253-C	1010
	36	ADD FOR MAINTAINING 32-38 DEG F THRU S40 & RECORD VOL	30X330	57-A	<u>9900</u>
932 10	37	RUN <u>17</u> (343G) WATER INTO V-932 & ADJ TO 90-110 DEG F			
932	38	ADD & STIR 20 MIN OR LONGER TO DISSOLVE FOR S44 (STRONTIUM NITRATE)	681	246-B	681
904 11	39	POUR INTO V-904 (AQUA AMMONIA)	250	122-D	250
CV 12	40	IMMEDIATELY COUPLE V-904 THRU UNDERSURFACE DISTRIBUTOR INTO CV (38-44 MIN). MAINTAIN CV AT 32-38 DEG F. NOTE: OPEN VALVE 1 1/4 TURN. RECORD: START <u>825 P</u> , TOTAL MIN <u>40</u>			
	41	STIR 15 MIN & RCRD: BASE <u>+</u> (+) DIAZO <u>-</u> (-) PH <u>10.2</u> (10.0-10.5)			
	42	IF PH IS BELOW 10.0 ADJ TO PH 10.0-10.5 & RECORD: PH		7-D	
	43	STIR 3 HRS. ASSUME 50%		28-D	
	44	STEAM EJECT V-932 INTO CV FROM S38			
	45	RCRD PH <u>10.1</u> (10.0-10.5), IF PH IS BELOW 10.0 ASSUME 50%		7-D	
		ADJ TO PH 10.0-10.5 & RECORD PH		28-D	
	46	STEAM EJECT V-932 FROM S8 INTO CV			
	47	WEIGH IN DRUM & POUR IN (OCTANOL)	25	588-A	25
	48	HEAT TO 193-195 DEG F IN 70-75 MIN & RECORD HT <u>127</u> DEG F, REC <u>192</u> DEG F			
	49	STIR 15 MIN AT 193-195 DEG F. RECORD: START <u>145 A</u>			
	50	FLOOD TO 180-190° (+/-18,000G)			
	51	RECORD: PH <u>9.2</u> (9.5-10.0) IF BELOW 9.5, ADJ TO PH 9.5-10.0 RECORD PH <u>9.2</u> ASSUME 50%	<u>30</u>	7-D	<u>15</u>
	52	IF PH IS ABOVE 10.0, DO NOT ADJUST STOP AGITATOR			
		WHEN INSTRUCTED BY PROCESSING HALFWAY THRU PRESSING DUMP IN & STIR 5 MIN STOP AGITATOR AND RESUME PRESSING.	10	588-A	10
		START <u>200 P M</u> FTY <u>230 P M</u> OPTR <u>381</u>			
		<u>300 P</u> <u>220 A</u> <u>259</u>			





V 43446 11111 CV 901, 903 (FOR SOFRAMES) 1.423

CG CODE RC-14-A PKG

EST WGT 3256 LBS

STD HRS TIME M

PROCESSES		APPROVED BY
() RC-14-A ()	JJG	
() ()		
() ()		
() ()		
Re-TYPED BY		
INM		

		NON-BLEEDING		
EQUIPMENT	NAME:	USE LBS	N CODE	ACCT CBS
	"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: 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# (FLEX A10)		777-A	
	2 Obtain for S 11 (RED AB ACID DURENT)		740-D	
	3 Obtain for S 35 (BON CYANAMID)		253-C	
	4 Install DV & CV Recorder & Controller charts			
921 2 V931	5 Run 10" (100 G) water into V-921 & heat to 80-100°F			
	6 Add in 2-3 min (DREGINATE A)	142	533-A	142
	7 Stir 5 min & Record: pH 9.8 (9.5-10.5)			
	8 Stir 20 min or longer to dissolve for S 45			
922 3	9 NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V-922			
	10 Run 35" (721 G) water into V-922			
	11 Weigh in V-926 & run in M 7. 48.79 % (CAUSTIC 48.79)		7-D	235
	Turn on agitator & steam & dump in from S 2		740-C	1200
	Lot # 100% 171 1200 - 98.4 - 1220			
	12 Dump in (ACTIVATED CARBON)	25	113-A	25
	13 Dump in	10	777-A	10
	14 Heat to 212-214°F Record: HT °F; Rec °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 20			
	Record: Start 9:50 PM Total Min 15 Clarity OK			
	HT 192 °F & Rec 195 °F			
MISC 4	18 Measure units in V-928 for S 30 M 2. 3200 (Hydrocarbon)			
			740-D	578
CV 5	19 Run 6" (669g) water into V-901			
	20 When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 5:05 PM Total Min 35			
301 6	21 Run 90" (2600g) water into V-901			
	22 Dump in & stir to smooth slurry (LIME HYDRATED)	569	542-A	569
	22A Add and stir for S 39 Assume 50%	58	7-D	29

3828-REV.

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