

S.V.

JAN 15 1981

C.V. 901.003

MAKING INSTRUCTIONS: BATCH UNIT

D.V. 904

CG 32 CODE RT-618-D PKG.

JAN 20 81 38712

EST. WGT. 2902 LBS.

STD. HRS. 10.4 TIME M

PROCESSES		APPROVED BY	
() RT-618-D	(S)	JJG	08-15-78
() RT-657-P	(F)	AMJ	09-19-78
()	()		
()	()		
TYPED BY			
emw092078			

2 Je
Per coat Mark.
OXED V-932

NON-BLEEDING

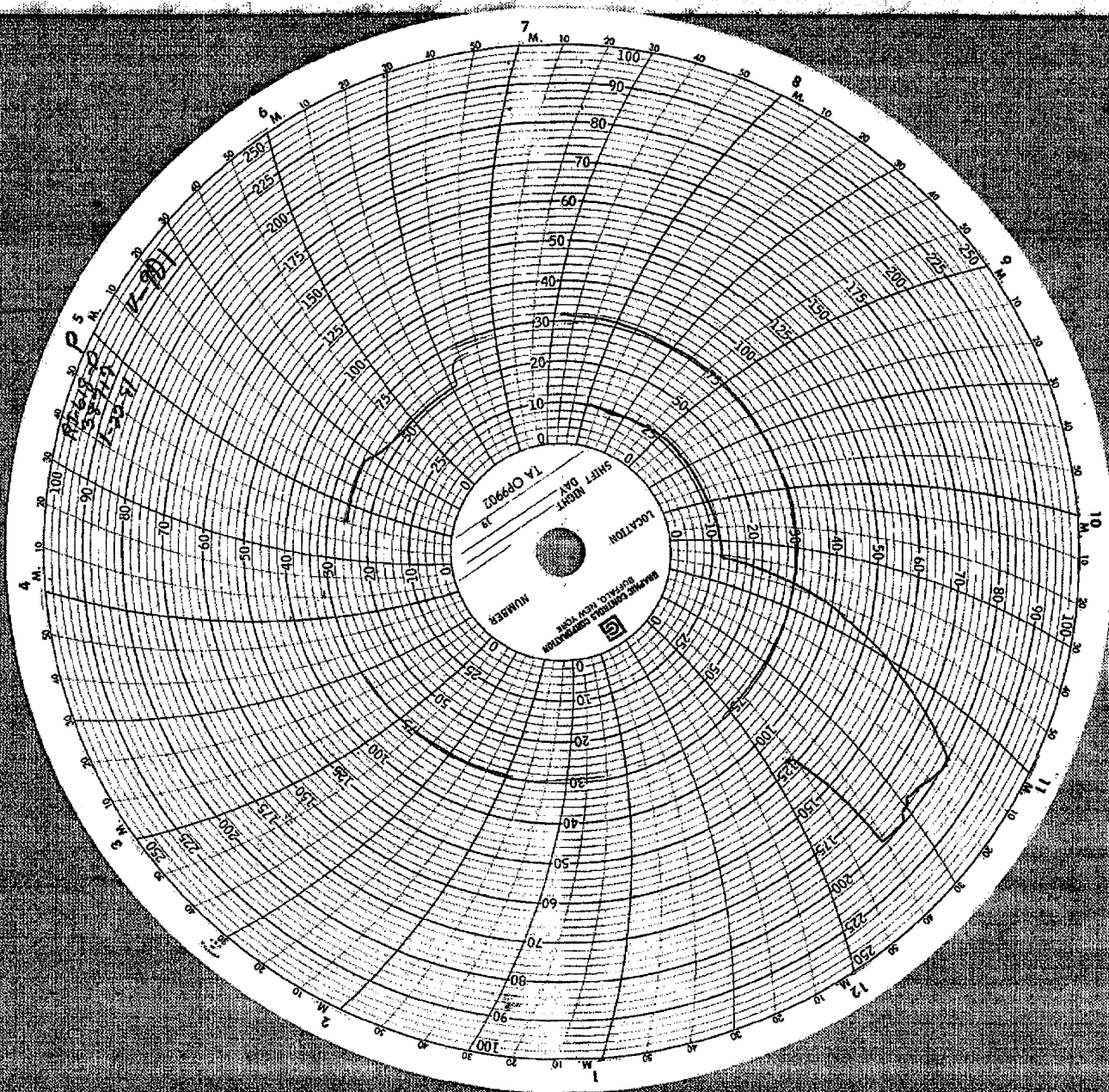
EQUIPMENT	NAME: WATCHUNG® RED Y	USE LBS.	N CODE	ACCT. LBS.
Prep 1	1 Record: Batches since Sparkler last cleaned. After 5 batches, clean, dress Sparkler & pre-coat with 15#	15	777-A	15
	2 Obtain for S 11		740-C	
	3 Obtain for S 24		253-C	
	4 Install DV & CV Recorder & Controller charts			
921/931 2	5 Run 10" (100 G) water into V-921 & adj to 80-100°F			
	6 Add in 1-2 min	63	530-A	63
	7 Stir 2 min & Record: pH 10.0 (9.5-10.5)			
	8 Stir 20 min or longer for S 27			
922 3	9 Run 34" (700 G) water into V-922			
	10 Weigh in V-926 & run in M 2, 50.0% 402		7-D	201
	11 Turn on agitator & steam & dump in from S 2		740-C	1035
	Lot 100% 98.71 1049			
	12 Dump in	50	113-B	50
	13 Dump in	10	777-A	10
	14 Heat to 212-214°F. Record: HT 212°F; 2/3 OF 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 19 & Record: HT 190°F & Recorder 191°F			
	Record: Start 1.30A Total Min 40 Clarity 0.2			
	NOTE: Sample from hose - show to Supervisor for OK			
904 4	18 Run 1" (50 G) water into V-904			
	19 When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 5.30A Total Min 12			
Misc 5	20 Weigh in PT for S 35 M 1, 32.83% 1047		725-A	332
	21 Measure 85/4 units in V-928 for S 33 M 1, 30.61% 1306		28-D	419
CV 6	22 Run 16" (1530 G) water into V-901			
	23 Weigh in V-926 & run in M 2, 50.0% 1014		7-D	507
	24 Dump in from S 3 Lot 300 905		253-C	507
	25 Weigh on postal scale & dump in Lot 00316 7 180C 7			
	26 Adjust to 70-90°F & stir to dissolve			
	27 Steam eject V-921/931 into CV			

EQUIPMENT	PAGE	CG	CODE	RT-618-D (S)	EST. WGT.	2902 LBS.	USE LBS.	N CODE	ACCT. LBS.
922 7	28			When S 19 complete, shut off pump & insert V-922 foot plug					
	29			Run in 12" (247 G) water & heat to 180-190°F See attached sheet for S29730					
904 8	30			Pump V-922 thru Sparkler into V-904					
	31			When MTY blow out Sparkler into V-904					
	32			Heat to 165-170°F (Sample & show to Supervisor for OK)					
	33			Run in N-28-D from S 21 in 12-15 min & stir 5 min at 165-170°F			35		
	34			Adj to 129" (3409 G) at 28-30°F & Record: Temp 30 °F			48x330	57-A	18150
	35			Run in N-725-A from S 20 AFAP (5-10 min)					
	36			Stir 20 min at 28-35°F maintain +CR, +KI for S 41					
				Record: Time Start 8 ⁰⁰ , 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 (+) Temp °F					
CV 9	37			Dump into CV			180	65-A	180
	38			Adj to 37" (3496 G) at 28-32°F			30x330	57-A	9900
				Record: Temp 25 °F Volume 39 "					
	39			Weigh in from drum			239	165-A	239
	40			Stir 2-3 min					
	41			Immediately couple DV thru undersurface distributor into CV in 45-60 min. Maintain CV at 28-32°F				57-A	
				Record: Start 8:20 A Total Min 50					
	42			Stir 30 min & Record: Base + (+), Diazo - (-), Final Temp 30 °F, pH 9.4 (9.0-9.8)					
	43			If necessary, adj to pH 9.0-9.8 Assume 50% 7-D					
				& Record: pH Assume 32% 28-D					
	44			Heat to 198-202°F in 65-70 min & TURN ON WATER SPRINKLER AT 175°F					
				Record: HT 200 °F & Recorder 200 °F					
DV 10	45			Run 24" (600 G) water into DV					
	46			Turn on agitator & steam & dump in			1620	16-B	1620
	47			Heat to 155-160°F & stir to dissolve					
CV 11	48			When S 44 complete, immediately strike DV thru undersurface distributor into CV in 7-10 min. Maintain CV at 174-176°F					
				Record: Start 11:15 A Total Min 15 & Turn on Water Sprinkler					
	49			Heat CV to 198-202°F in 10-12 min					
	50			Stir 5 min at 198-202°F					
	51			Flood to 180-190" (±18,000 G)					
	52			Record: pH 8.9 (9.0-9.4) & stop agitator & Turn off Water Sprinkler					
				SAMPLE					
				START 3:00 P.M. 70° F					
				FIN 12:00 P.M. 120° F					
				OPTR 126					
				When instructed by Processing Area half way thru pressing, dump in & stir 5 min & stop agitator. Resume pressing			10	588-A	10

1/4 TURN
ON WATER
SPRING
ST
170°F

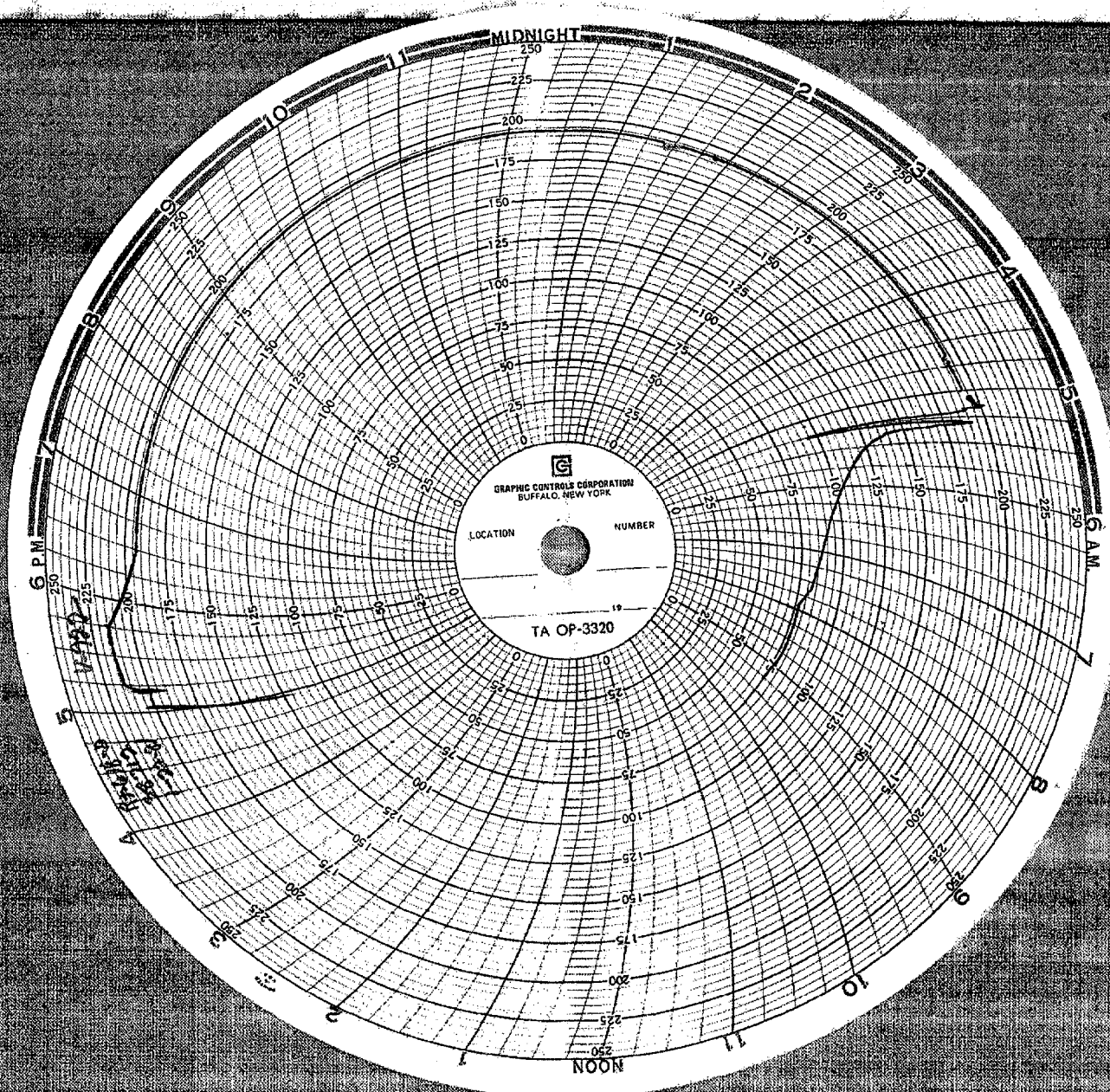
START	FIN	OPTR
3.006.10	11.11.11	37
702	12.11.11	126

EQUIPMENT	PAGE	CG	CODE	EST. WGT.	LBS.	USE LBS.	N CODE	ACCT. LBS.
V922	30							
RUN IN 8 " (206 G) WATER INTO V922 & HEAT TO 190-195°F. CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR. MAINTAIN 190-195°F DURING S- 30 30.								
V904	30							
PUMP V922 THRU SPARKLER INTO V-904								
V922	30							
RUN 8 " (165 GAL) WATER INTO V922 & HEAT TO 190-195°F CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR. MAINTAIN 190-195°F THRU S- 30 30								
V904	30							
PUMP V-922 THRU SPARKLER INTO V-904								
CONTINUE WITH S- 30 31								



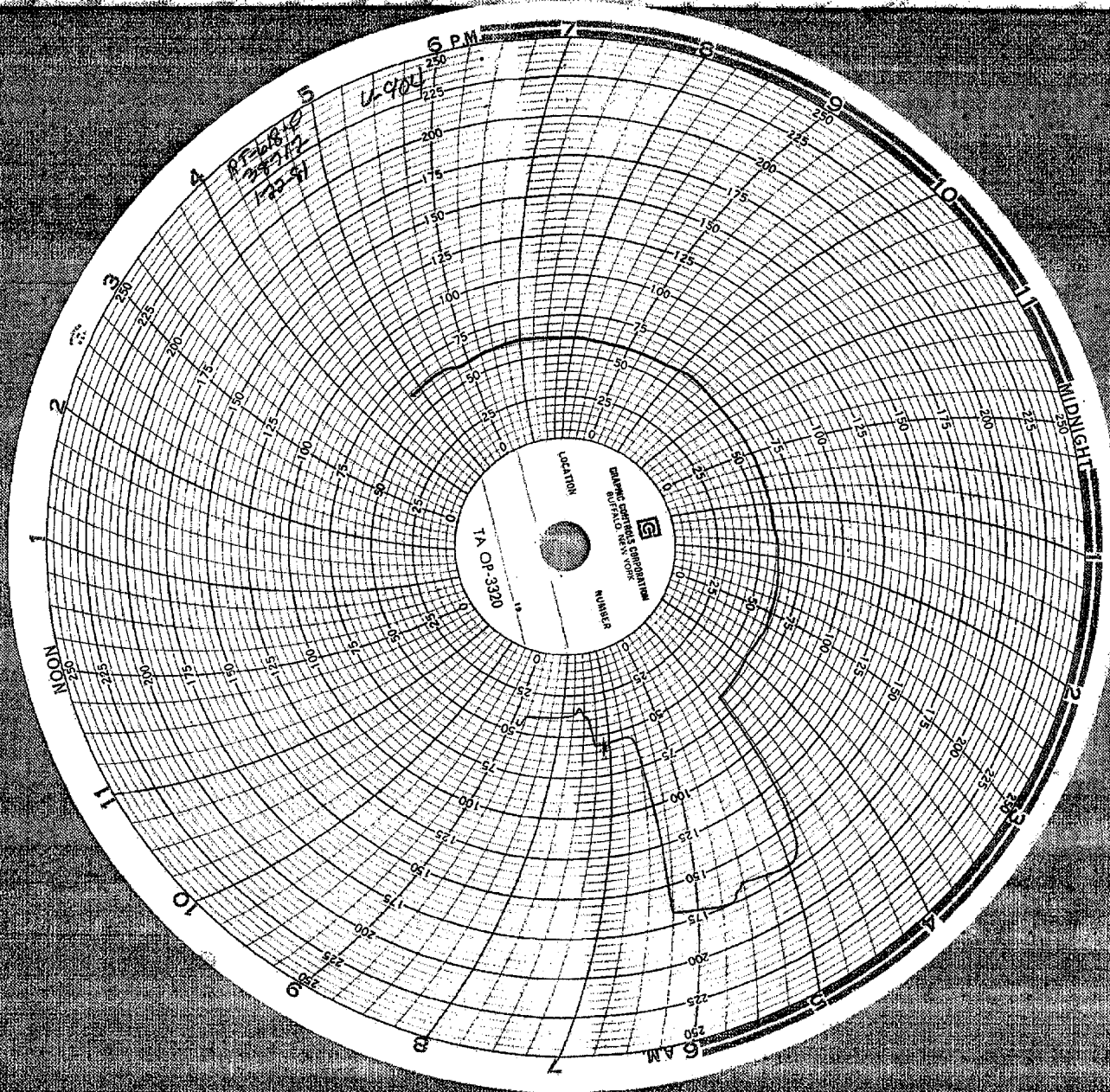
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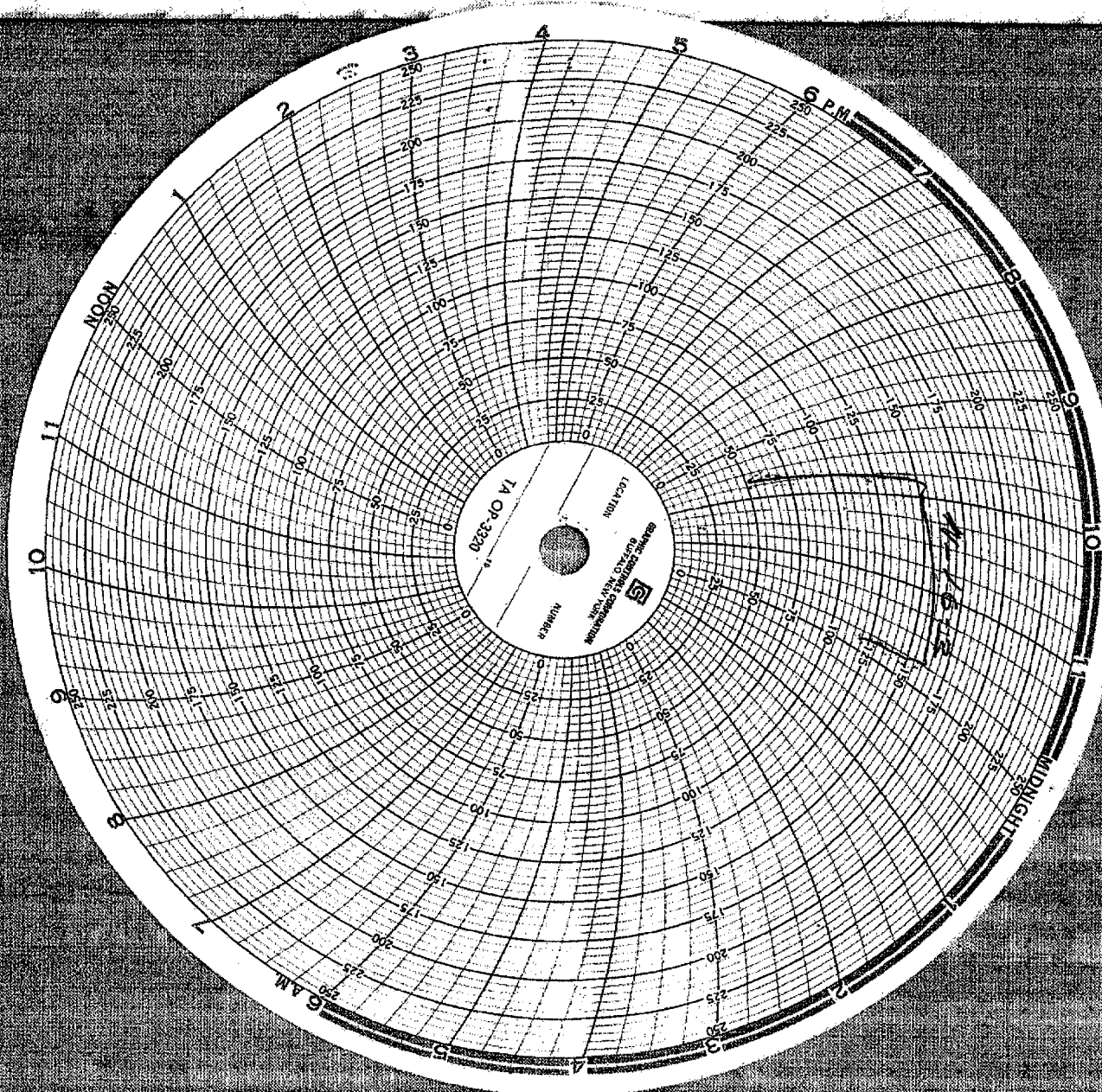
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DUP050292161

N 31806.04



DUP050292162

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