

C.V. 901, (903)

D.V. 902, 904

CG 32 CODE RT-428-D PKG. _____

NOV 25 80 38041

EST. WGT. 2332 LBS.

STD. HRS. _____ TIME 7:18 M

PROCESSES		APPROVED BY
() RT-428-D (W)		JJG 07-10-78
() RC-14-A ()		DCG 08-10-78
() RT-139-P (P)		MW 08-11-78
()	()	
TYPED BY		
emw082178		

NON-BLEEDING

EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	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 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			
21/931	5 Run 10" (100 G) water into V-931 & heat to 80-100°F			
	6 Add in 2-3 min	100	530-A	100
	7 Stir 5 min & Record: pH 9.7 (9.5-10.5)			
	8 Stir 20 min or longer to dissolve for S 43			
122 3	9 Run 28" (577 G) water into V-922			
	10 Weigh in V-926 & run in M % 165		721-D	165
	11 Turn on agitator & steam & dump in from S 2		740-C	843
	Lot 112 #100% 843 9881 853			
	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% WATCH FOAM		7-D	
	16 Stir 30 min at 212-214°F then shut off steam			
	17 Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 21			
	Record: Start 12:55, Total Min 20, Clarity 0.12			
	HT 192 OF & Rec 195 OF			
Misc 4	18 Measure 8474 units in V-928 for S 33 M 11- 3087 % 1315		28-D	406
	19 Weigh in PT for S 36 M 13- 3347 % 801		725-A	268
5	20 Run 1" (G) water into V-903			
	NOTE: Use CV if MIV. If CV is not available, use V-903			
	21 When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 1:15, Total Min 10			

N35092

EQUIPMENT		PAGE 2 CG 32 CODE RT-428-D (W) EST. WGT. 2332 LBS.	USE LBS.	N CODE	ACCT. LBS.
6	22	Run 45" (1300 G) water into V-902 (SEE ATTACHED PAGE FOR S-27)			
	23	Heat in V-926 & run in			
902	24	Dump in & stir to smooth slurry for S 41	400	542-A	400
922	25	When S 21 complete, stop pump & insert V-922 foot plug			
7	26	Run in 12" (247 G) water & heat to 180-190°F 190-195°F CIRCULATE 15 MIN THRU SPARKLER - PUMP V-922 THRU SPARKLER INTO V-904/CV			
904/CV	27	Run V-922 thru Sparkler into V-904/CV SEE ATTACHED PAGE FOR S-27			
8	28	When MTY blow out Sparkler into V-904/CV	48	979-D	48
	29	Pour in			
	30	Heat to 165-170°F			
CV		NOTE: If N-740-C sol'n (S's 20 & 21) was pumped directly from Sparkler to CV, omit (S's 31 & 32)			
9	31	Run in 1" (98 G) water into V-			
	32	Pump V-904 at 165-170°F thru undersurface distributor into CV (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 34" (3223 G) at 32-38°F	40 x 330	57-A	3200
	36	Run in N-725-D from S 19 AFAP (5-10 min)			
	37	Stir 20 min at 32-38°F maintaining +CR, +KI			
		Record: Time Start 5:15 P, 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	186	246-E	186
	39	Dump in	350	65-A	350
	40	Dump in from S 3 & stir 10 min	Lot 5363 771	82-C	771
		41 Run in 10" (2300 G) water into V-902 & stir 10 min			
		42 Run in 10" (2300 G) water into V-902 & stir 10 min			
		43 Run in 10" (2300 G) water into V-902 & stir 10 min			
902	41	Run in 10" (2300 G) water into V-902 & stir 2-3 min	190	122-A	190
CV	42	Immediately after S 41 complete, run V-902 thru undersurface distributor into CV in 18-22 min. Let CV temp rise freely			
12		Record: Start 6:15, Total Min 19			
	43	Immediately after S 42 complete, steam eject V-921/931 into CV			
	44	Stir 10 min & Record: Diazo - (-), Base + (+)			
		pH 9.0 (9.0-9.8), Temp 0°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 195 °F			
		Rec 195 °F			
	48	Stir 15 min at 193-195°F Record: Start 7:10 PM			
	49	Record: pH 8.9 (8.8-9.3)			
	50	Flow to 180-190° (±18,000 G) & stop agitator			
	51	When instructed by Processing Area halfway thru pressing dump in & stir 5 min. Stop agitator & resume pressing	10	588-A	10
		START 10:40 AM 300P	FIN 3:00 PM 600P	OPTR 381 126	

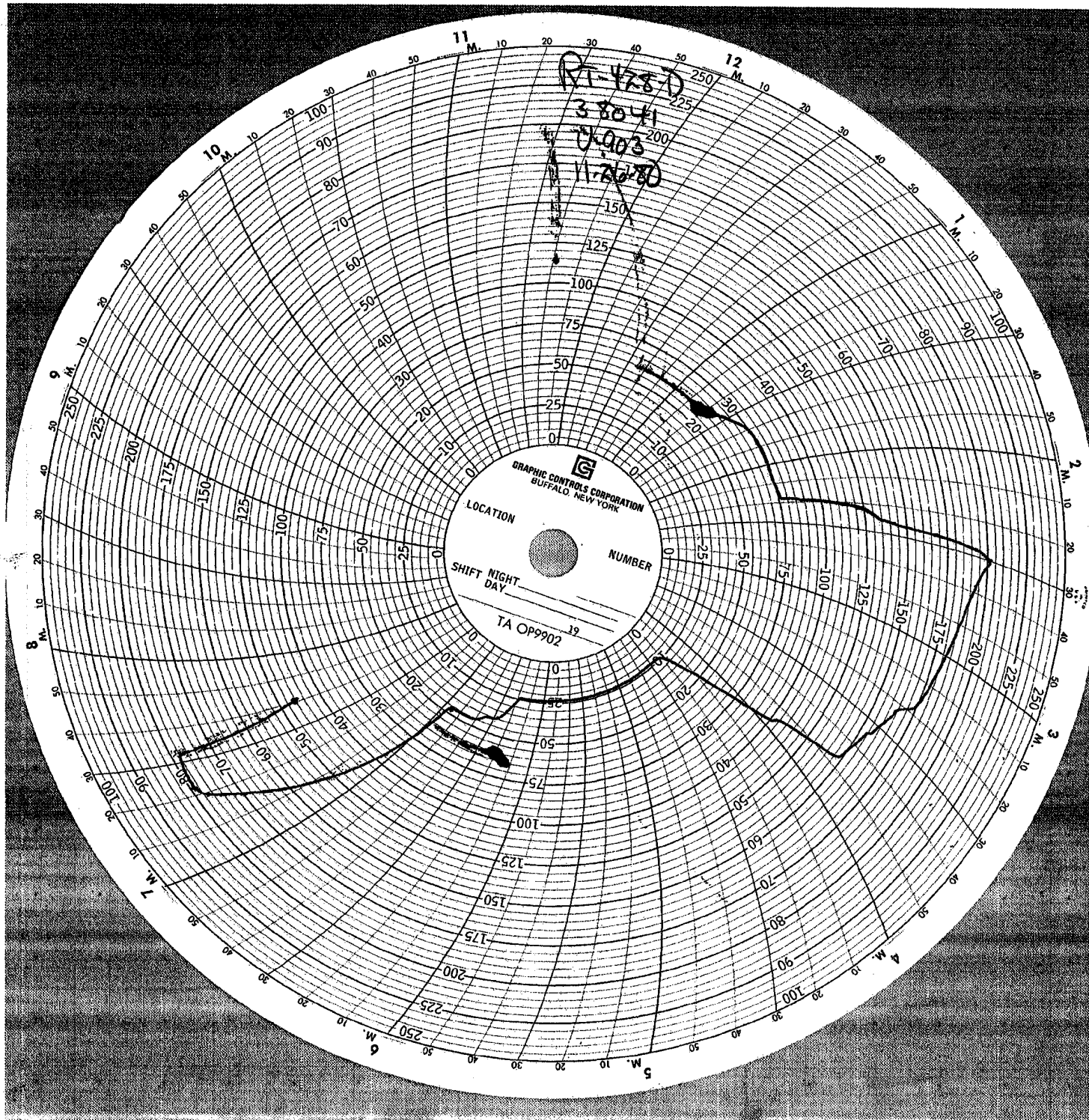
V922

~~30~~ RUN 8" (165 GAL) WATER INTO
V922 & HEAT TO 190-195°F
27 CIRCULATE 15 MIN OR LONGER
A THRU SPARKER UNTIL SOLUTION
IS CLEAR MAINTAIN 190-195°F
THRU S-27A-B

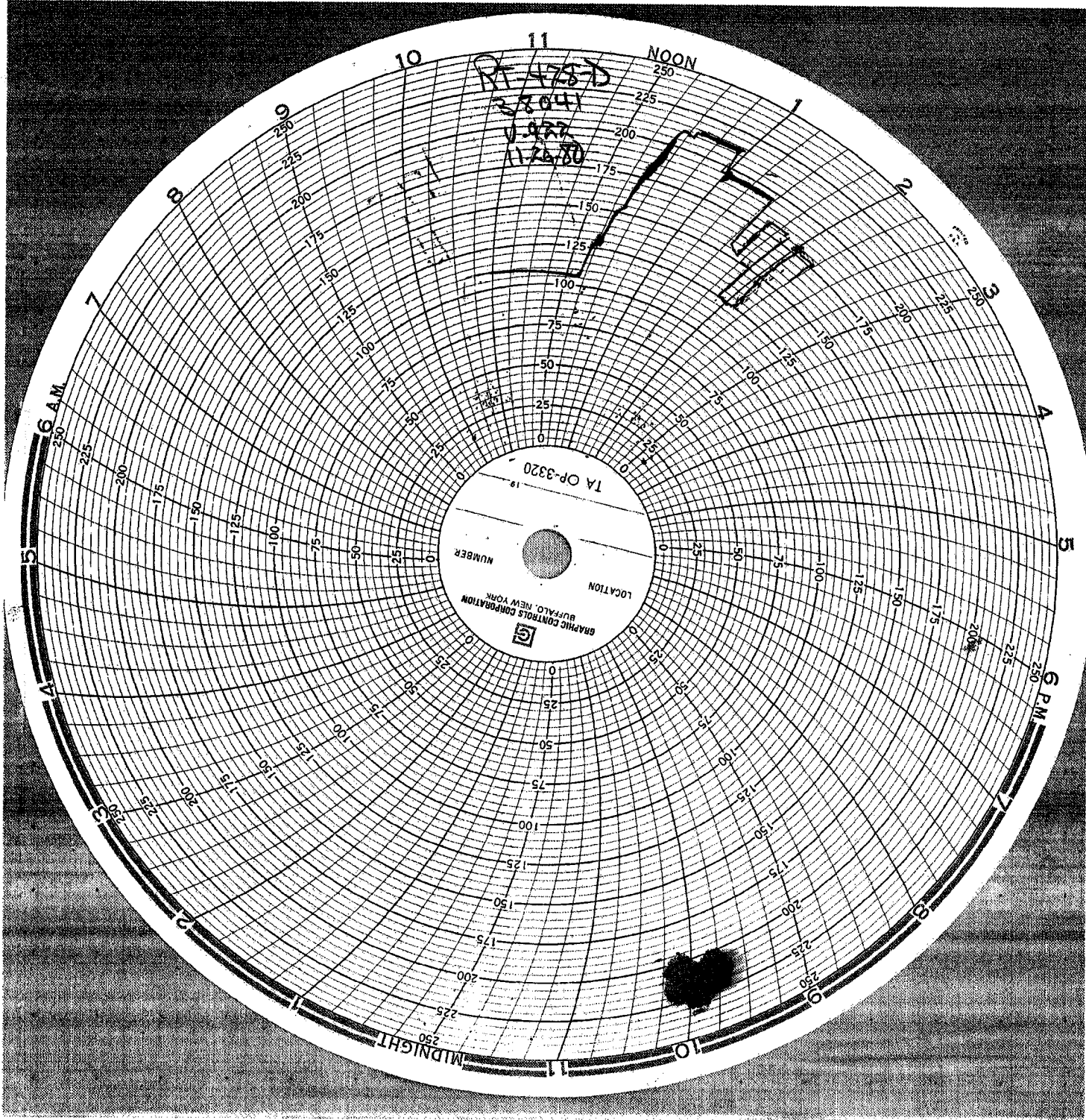
V904

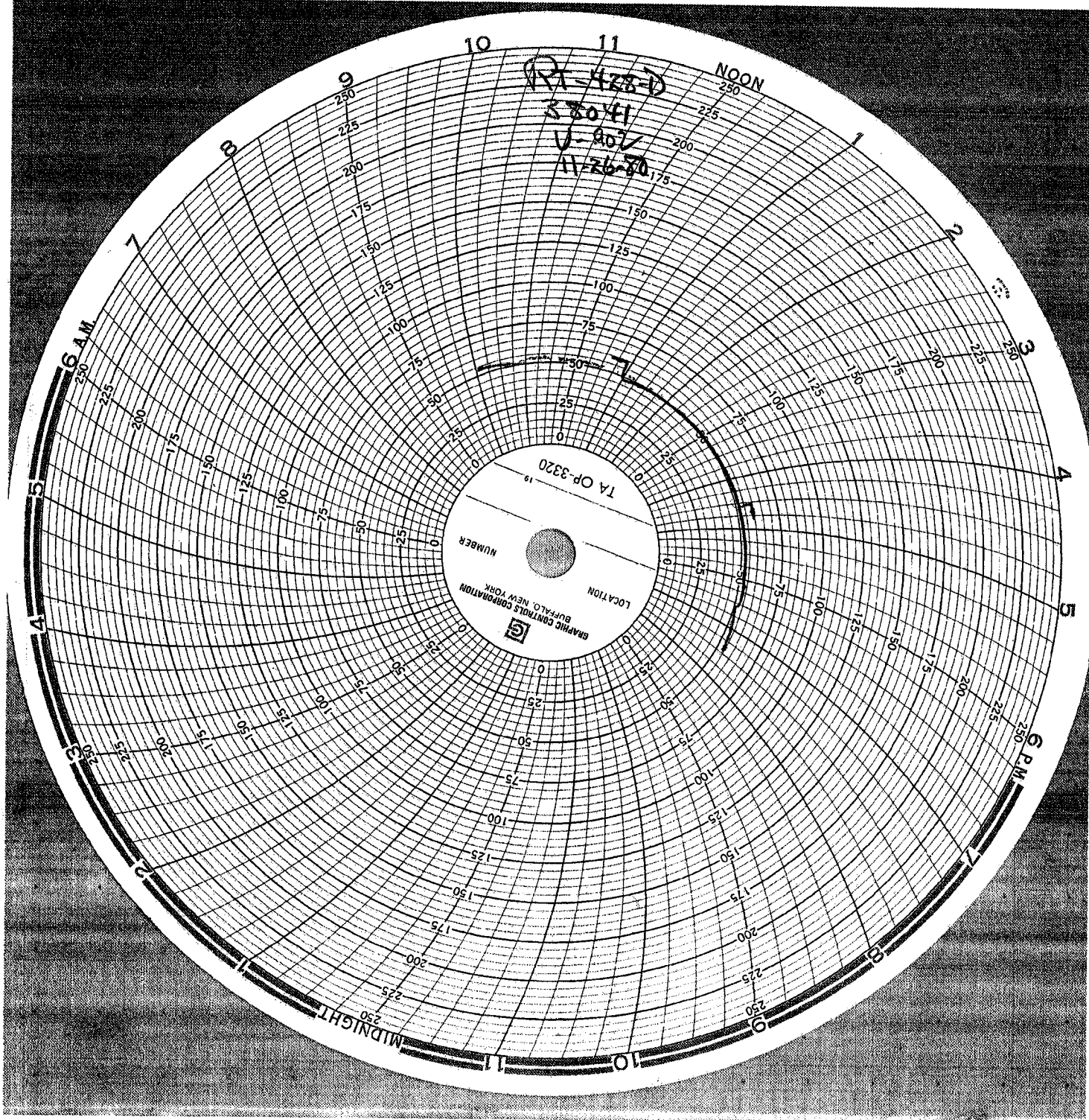
~~30~~ PUMP V-922 THRU SPARKER
27 INTO V-904
B

CONTINUE WITH S-28



DUP050107613





DUP050107615