S.V. C.V. 901, 903 MAKING INSTRUCTIONS: BATCH UNIT D.V 902, 904

CO 32 CODE RT-880-D PKG.

→ OCT 22 80 37600

EST. WGT. 2515 LBS.

STD. HRS. 9.3 TIME ~~2:30~~ 3:P.M.

PROCESSES	APPROVED BY
( ) RT-880-D (D)	JJG 08-16-78
( ) ( )	AMJ 01-22-79
( ) ( )	
( ) ( )	
TYPED BY	
emm012979	

9 97

OCT 22 1980

NON-BLEEDING

EQUIPMENT		NAME: MATCHUNG® RED B	USE LBS.	N CODE	ACCT. LBS.
		NOTE: Batch must be pressed promptly to control color. Do not start if press will not be available within 3 hrs after making. Record:			
		Press will be ready M P R Supv			
		Start making M Making Supv			
Prep 1	1	Record: 0 batches since Sparkler last cleaned. After 5	30	227A	30
	2	batches, clean, dress Sparkler & pre-coat with 15#	15	777-A	15
	2	Obtain for S 11		740-C	
	3	Obtain for S 27		82-C	
	4	Install DV & CV recorder & Controller charts			
921/941 2	5	Run 10" (100 G) water into V-927 & adj to 80-100°F			
	6	Add in 2-3 min	100	99-A	100
	7	Stir 5 min & Record: pH 7.7 (9.5-10.5)			
	8	Stir 20 min or longer to dissolve for S 36			
		32°			
922 3	9	Run 38" (722 G) water into V-922			
	10	Weigh in V-926 & run in M Flake %	216	721-D	216
	11	Turn on agitator & steam & dump in from S 2		740-C	1107
		Lot #100% %			
		103 963 98.2F	975		
		54 104 98.5	146		
	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 T Must be + (Adj if Necessary) Assume 50%		721-D	
	16	Stir 30 min at 212-214°F, then shut off steam WATCH FOAM		16A-Record:	
	17	Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 28		Sparkler Press ready 731 psi 90 mat zero, mat dry Supervisor	
		Record: Start 5:30 Total Min 30 Clarity OK			
	18	Record: HT 210 °F & Rec 205 °F			
Misc 4	19	Weigh in PT-1 for S 45 M 12 , 33.16 %	1023	725-A	359
	20	Weigh in drum for S 51 M 12 , 33.16 %	123	725-A	42
	21	Weigh in drum for S 52 M 12 , 33.16 %	123	725-A	42
	22	Measure & dump units in V-928 for S 42 M 9 , 32.60 %	1625	28-D	533
903/CV 5	23	Run 1" (G) water into V-903			
		NOTE: Use CV if MTY, if CV is not MTY use V-904			
	24	When S 18 is complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 6:30 Tot Min 12		28-D	

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EQUIPMENT		PAGE 2 CG 32 CODE RT-880-D (D) EST. WGT. 2516 LBS.	USE LBS.	N CODE	ACCT. LBS.
902 6	25	Run 60" (1566 G) water into V-902			
	26	Weigh in V-926 & run in M Flake %	453	721-D	453
	27	Dump in from S 3 Lot 4808	247	82-C	997
		4829	750		
	27A	WEIGH ON POSTAL SCALE & DUMP IN	1.5	180C	1.5
	28	Adj to 70-90°F & stir to dissolve			
922 7	29	When S 24 complete, shut off pump & insert V-922 foot-plug			
	30	Run in MT (209 G) water & heat to 180-185°F	See Attached Page for S-30 & 31		
904/CV 8	31	Pump V-922 thru Sparkler into V-904/CV			
	32	When MT blow out Sparkler into V-904/CV			
	33	Dissolve in 20 G water at 150-160°F in drum & pour in	31	133-B	31
	34	Heat V-904/CV to 165-170°F for S 40			
902 9	35	When S 28 complete, measure in calibrated container, slurry with 46 G water in drum & pour into V-902	100	39-A	100
	36	Steam eject in V-921/ from S 8			
PT-2 10	37	Run into PT-2 M Flake %	126	721-D	126
	38	Adj to 19" (68 G)			
	39	Stir 5 min or longer for S 57			
		NOTE: If N-740-C solution was pumped directly from Sparkler to CV at S's 23 & 24, omit S's 40 & 41			
CV 11	40	Run 1" (95 G) water into V-903			
	41	If V-904 is used, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min) Maintain 165-170°F			
		Record: Start Total Min			
	42	Run in N-28-D from S 22 in 12-15 min			
	43	Stir 5 min	6		
	44	Adj to 43" (4080 G) at 32-38°F	6 x 330	57-A	20460
		Record: Temp 37 °F Stick 38 "			
	45	Run in N-725-A from S 19 AFAP (5-10 min)			
	46	Stir 20 min at 32-38°F maintaining +CR, +KI for S 54		57-A	
		Record: Time Start 1130 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 (+)			
	47	Dump in	1116	20-A	1116
	48	Dump in	244	246-E	244
	49	Dump in	17 50	65-A	50
	50	Add for maintaining at 32-38°F during coupling	36 x 330	57-A	5610
	52	Pour in N-725-A from S 20			
902 12	52	Pour N-725-A from S 21 into V-902			
	53	Dump in & stir 2-3 min	218	165-A	218
CV 13	54	Immediately couple 902 thru undersurface distributor into CV in 18-22 min. Maintain CV at 32-38°F			
		Record: Start 1220 Total Min 25			
	55	Install 5/16" orifice in undersurface addition line			
	56	When S 54 complete, stir 30 min &			
		Record: Base 5+ (+), Diazo 5+ (+), pH 3.6 (5.0-6.0)			

EQUIPMENT		PAGE 3 CG 32 CODE RT-880-D (D) EST. WGT. 2516 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 13 cont'd	57	Run in N-7-D from S 39 thru 5/16" orifice			
		Record: 45 Min (40-50 min)			
	58	Stir 20 min & Record: pH 7.3 (7.0-8.5)			
	59	If pH below 7.0 adj to pH 7.0-8.5 with N-7-D only Assume 50%		721-D	
		Record: pH ✓			
	60	Weigh in V-926 & run in Assume 50%	53 ~~106~~	721-D	53
	61	Stir 5 min & Record: Base 5+ (+), Diazo — (-),			
		pH 9.0 (9.0-9.8)			
	62	If pH below 9.0, adj to pH 9.0-9.8 with N-7-D only Assume 50%		721-D	
		& Record: pH ✓			
	63	Measure in calibrated container & pour in 2.55	35	588-A	35
	64	Heat to 193-195°F in 75-80 min Start 2			
	65	Record: HT 195 °F & Rec 195 °F			
	66	Stir 60 min at 193-195°F Record: Start 3.50			
	67	After 20 min S 66 stir Record: pH 8.1 (8.8-9.3)			
	68	If pH 8.8, adj to pH 8.8-9.3 with N-7-D only Assume 50%	60	721-D	60
		Record: pH 8.85			
	69	When S 66 complete, flood to 180-190" (±18,000 G)			
	70	Stop agitator			
		When instructed by Processing Area halfway thru Pressing			
		1. Dump in	10	588-A	10
		2. Stir 5 min			
		3. Advise Processing to resume Pressing			

START	FINISH	OPTR
3.00Pm	11:00Pm	342
11Pm	5:30 A	120

K 13330 REV.

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EQUIPMENT	PAGE ___ CG ___ CODE ___ EST. WGT. ___ LBS.	USE LBS.	N CODE	ACCT. LBS.
V922	30A RUN IN 10" (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-30A&B			
V904 C.J	30B PUMP V922 THRU SPARKLER INTO V-~~207~~ 903			
V922	31A RUN 8" (165 GAL) WATER INTO V922 & HEAT TO 190-195°F CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR. MAINTAIN 190-195F THRU S-31A&B			
V904 C.J	31B PUMP V-922 THRU SPARKLER INTO V-904			
	CONTINUE WITH S-32			

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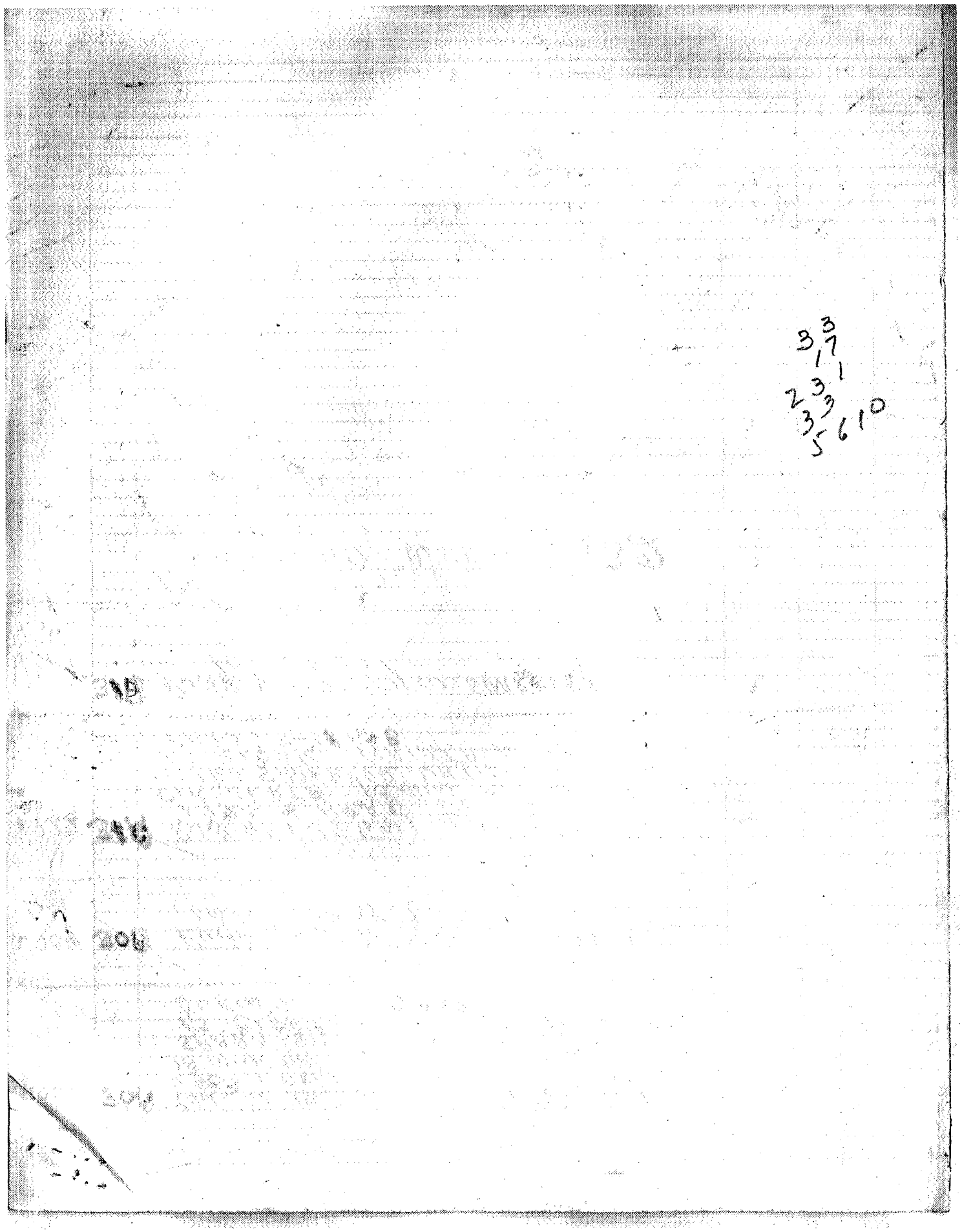

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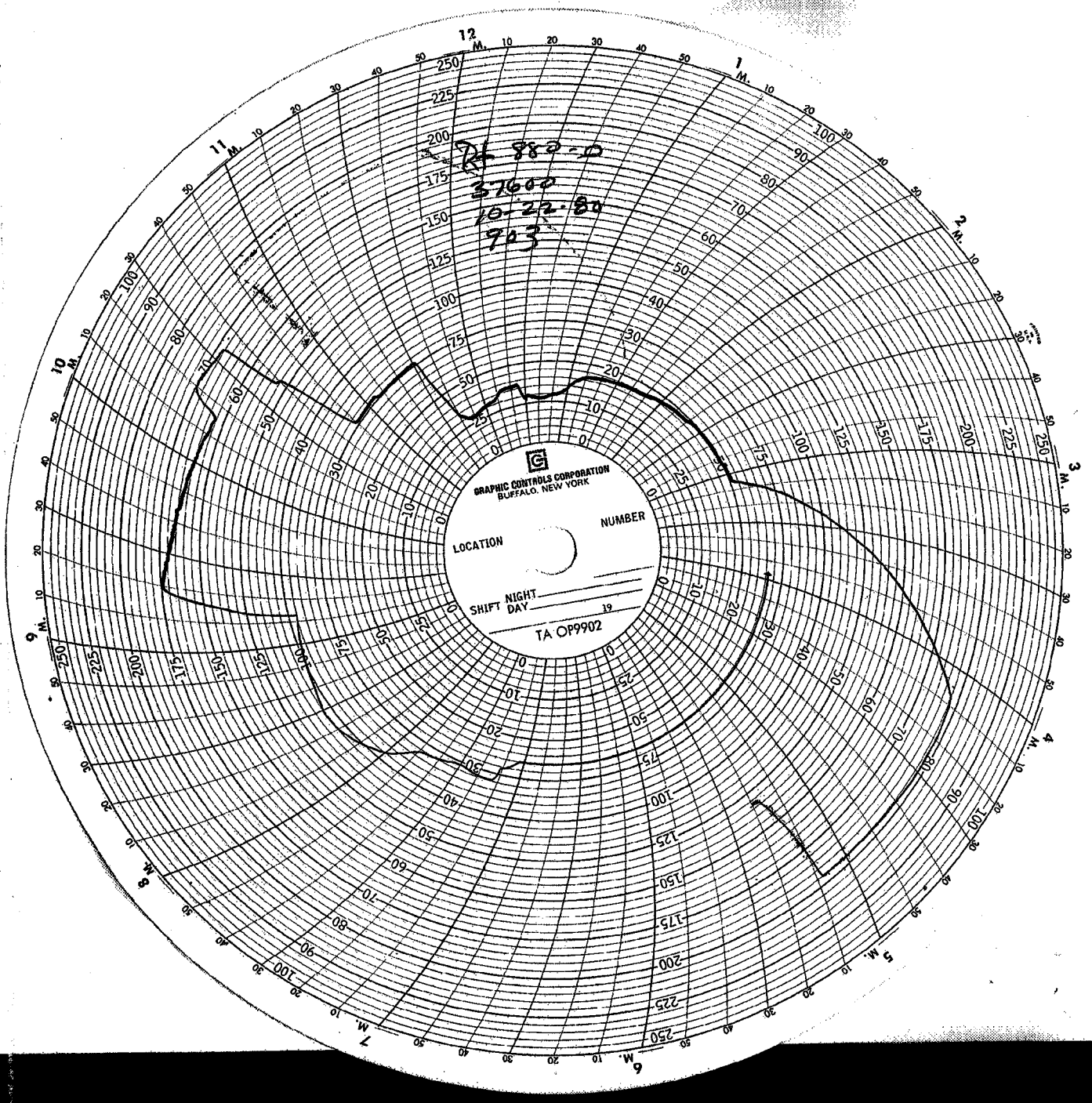

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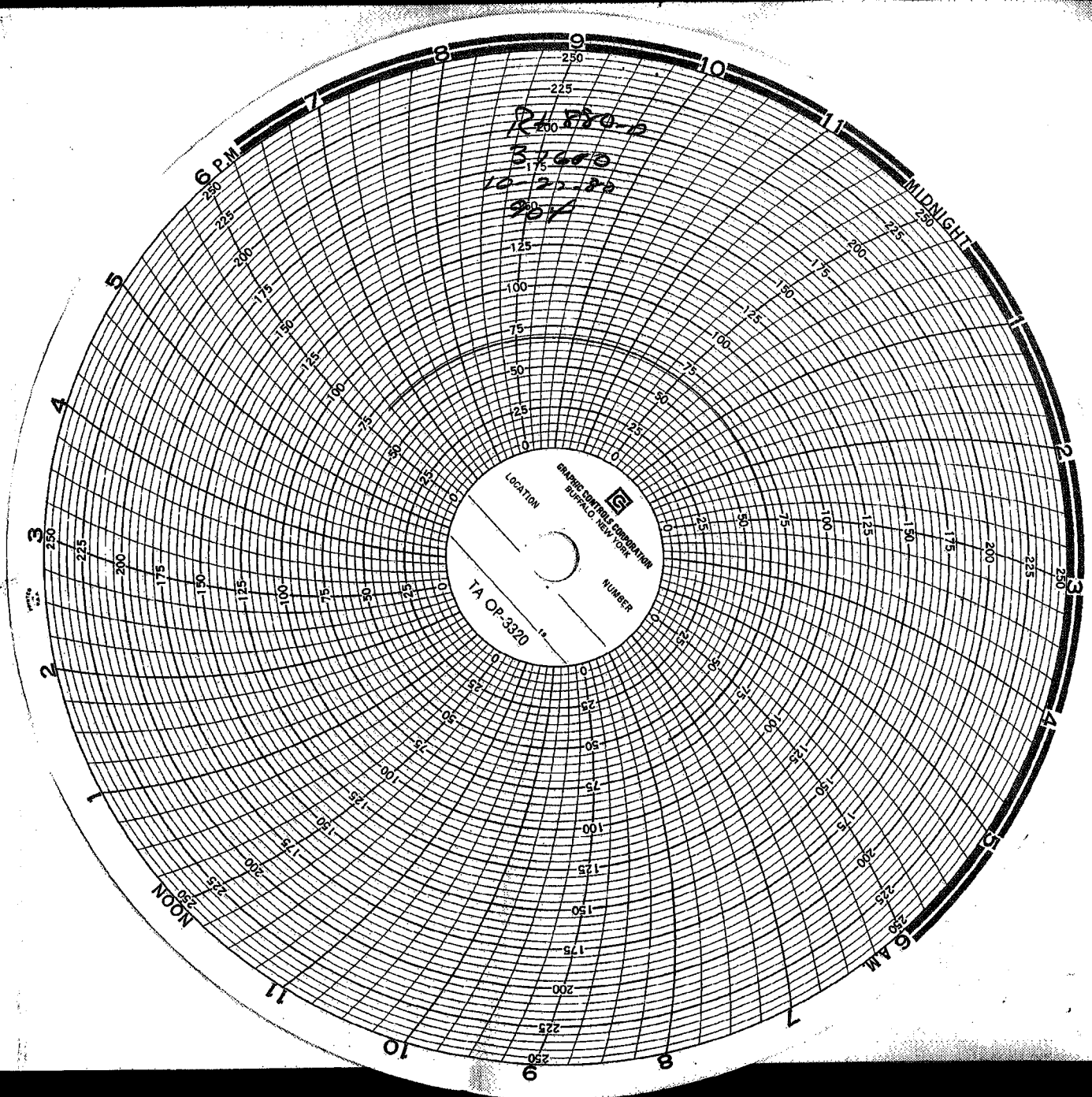

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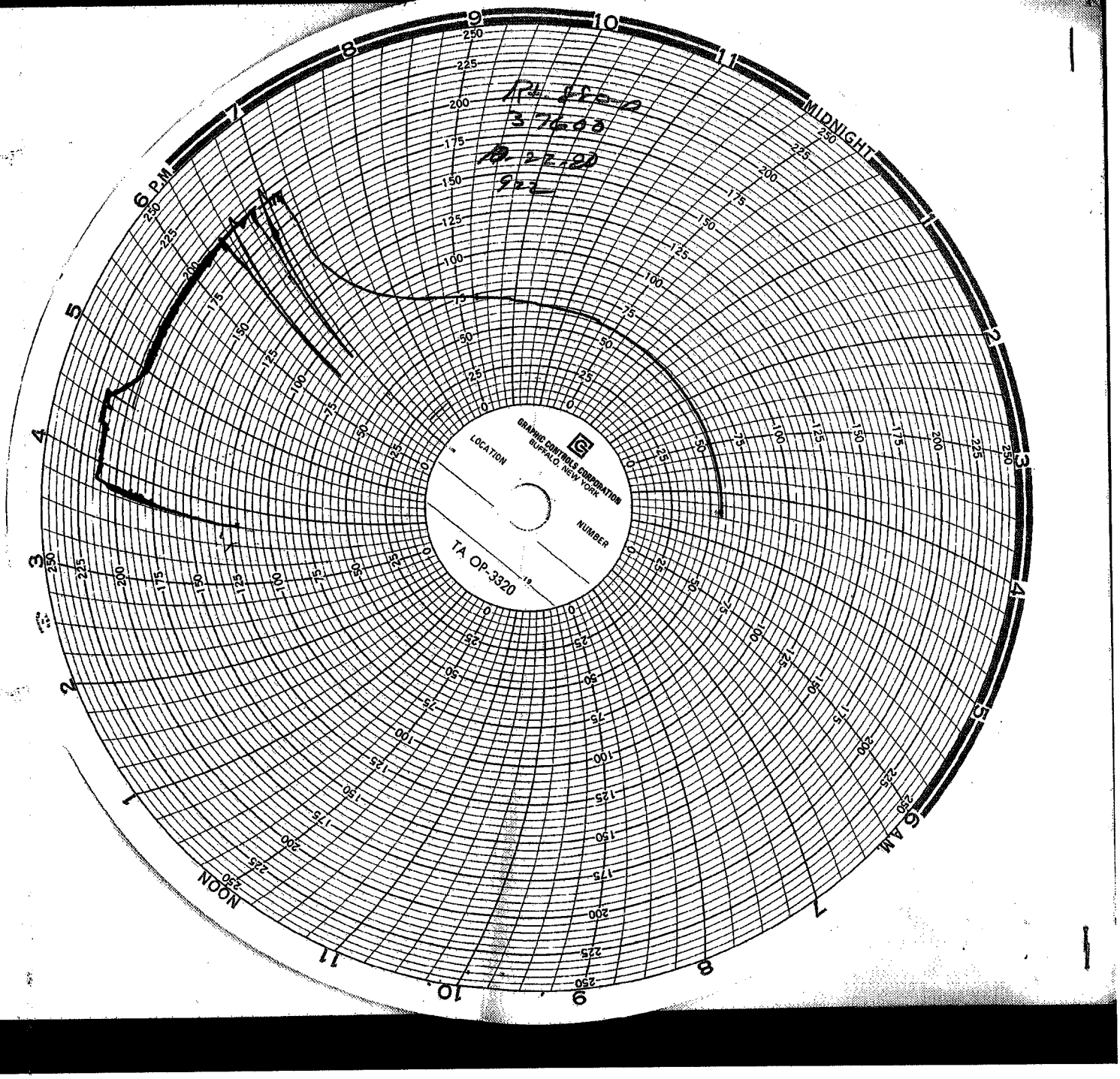

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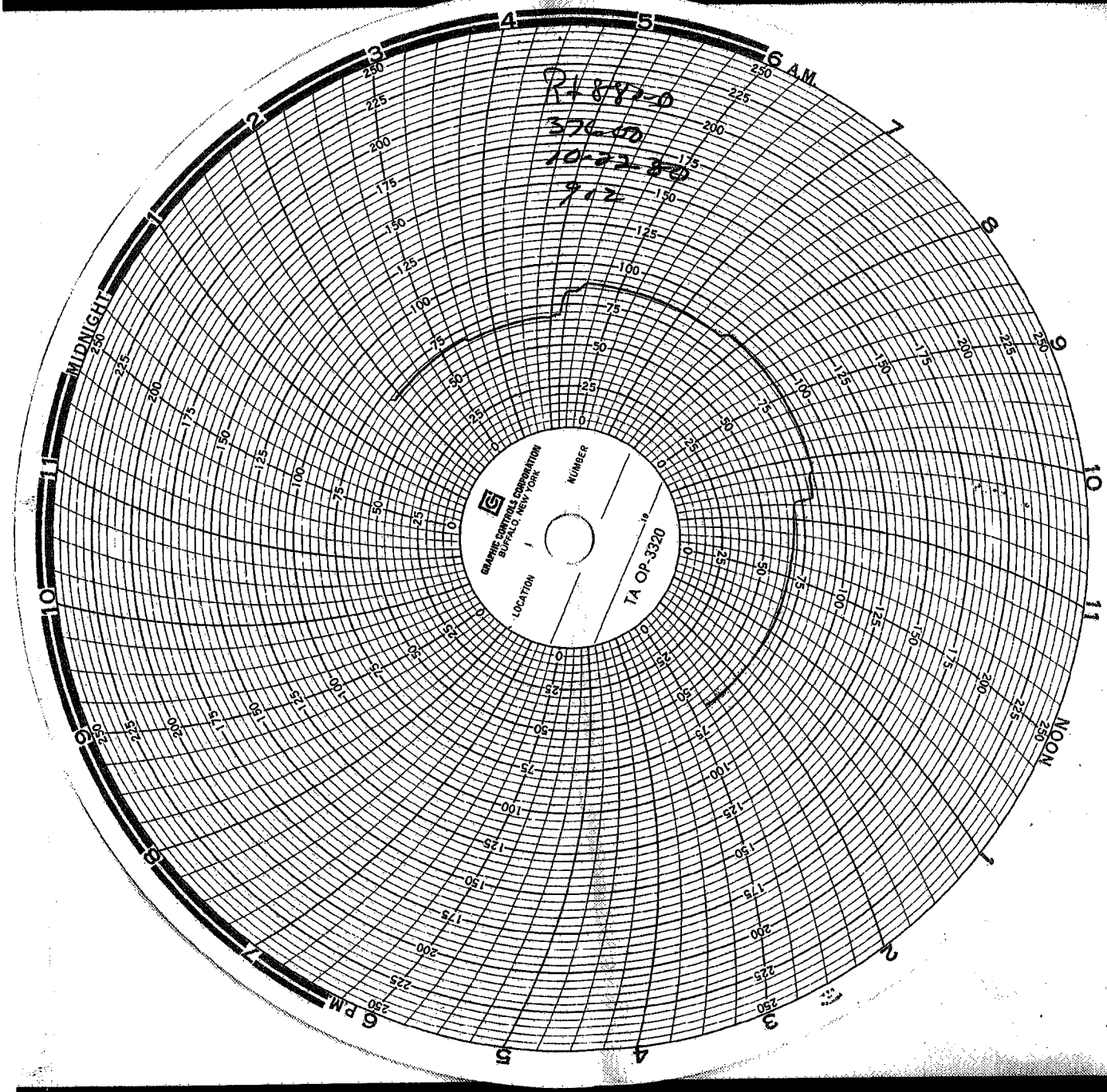

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