S.V. 761 C.V. 901, 903 D.V. 902, 904

CG 32 CODE RT-880-D PKG.

→ SEP-15-80 3747

EST. WGT. 2516 LBS.

STD. HRS. 9.3 TIME 3P M

2 Je

PROCESSES		APPROVED BY
( ) RT-880-D	(D)	JJG 08-16-78
( )	( )	AMJ 01-22-79
( )	( )	
( )	( )	
TYPED BY		
emw012979		

Use N740C Lot 100 only

PUNCHED & CHECKED

SEP 19 1979

NON-BLEEDING

EQUIPMENT		NAME: WATCHUNG® 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: 3 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 27	82	-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 2-3 min	100	99-A	100
	7	Stir 5 min & Record: pH 10.2 (9.5-10.5)			
	8	Stir 20 min or longer to dissolve for S 36			
922 3	9	Run 35" (722 G) water into V-922			
	10	Weigh in V-926 & run in M , 28.6 %	216	721-D	216
	11	Turn on agitator & steam & dump in from S 2		740-C	1107
		Lot 100 #100% 1107 % 98.6	1123		
	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 + Must be + (Adj if Necessary) 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 24			
		Record: Start 10:50 PM Total Min 20 Clarity OK			
	18	Record: HT 195°F & Rec 195°F			
Misc 4	19	Weigh in PT-1 for S 45 M , 32.1 %	10	725-A	359
	20	Weigh in drum for S 51 M , 32.1 %	12	725-A	42
	21	Weigh in drum for S 52 M , 32.1 %	12	725-A	42
	22	Measure 78½ units in V-928 for S 42 M , 31.2 %	12	28-D	533
904/CV 5	23	Run 1" (G) water into V-904			
		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 1115 Tot Min 45			

EQUIPMENT		PAGE 2 CG 32 CODE RT-880-D (D) EST. WGT. 2516 LBS.	USE LBS.	N CODE	ACCT. LBS.
902	25	Run 60" (1566 G) water into V-902		721-D	
6	26	Weigh in V-926 & run in M Flake %	453	7-D	453
	27	Dump in from S 3 Lot		82-C	1012
		4873	250	82C	
		4950	262		
		4996	600		
	28	Adj to 70-90°F & stir to dissolve			
922	29	When S 24 complete, shut off pump & insert V-922 foot-plug			
7	30	Run in 15" (309 G) water & heat to 180-190°F			
904/CV	31	Pump V-922 thru Sparkler into V-904/CV			
8	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	35	When S 28 complete, measure in calibrated container,	✓ 100	39-A	100
9		slurry with 46 G water in drum & pour into V-902			
	36	Steam eject in V-921/931 from S 8			
PT-2	37	Run into PT-2 M , %	126	721 7-D	126
10	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	40	Run 1" (95 G) water into V- 903			
11	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 3:40 Total Min 20			
	42	Run in N-28-D from S 22 in 12-15 min			
	43	Stir 5 min			
	44	Adj to 43" (4080 G) at 32-38°F 50-45 x 330		57-A	
		Record: Temp 32 °F Stick 43 "			
	45	Run in N-725-A from S 19 AFAP (5-10 min)			
	46	Stir 10 min at 32-38°F maintaining +CR, +KI for S 54		57-A	
		Record: Time Start 4:35 PM 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	50	65-A	50
	50	Add for maintaining at 32-38°F during coupling 90 36 x 330		57-A	
	51	Pour in N-725-A from S 20			
902	52	Pour N-725-A from S 21 into V-902			
12	53	Dump in & stir 2-3 min	218	165-A	218
CV	54	Immediately couple 902 thru undersurface distributor into CV			
13		in 18-22 min. Maintain CV at 32-38°F			
		Record: Start 4:45 PM Total Min 22			
	55	Install 5/16" orifice in undersurface addition line			
	56	When S 54 complete, stir 5 min &			
		Record: Base + (+), Diazo + (+), pH 5.6 (5.0-6.0)			

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EQUIPMENT		PAGE 3 CG 32 CODE RT-880-D (D) EST. WGT. 2516 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV	57	Run in N-7-D from S 39 thru 5/16" orifice			
13		Record: 40 Min (40-50 min)			
cont'd	58	Stir 10 min & Record: pH 6.6 (7.0-8.5)			
	59	If pH below 7.0 adj to pH 7.0-8.5 with N-7-D only Assume 50%	100	7-D	50
		Record: pH 8.1			
	60	Weigh in V-926 & run in Assume 50%	106	7-D	53
	61	Stir 5 min & Record: Base + (+), Diazo — (-), pH 9.5 (9.0-9.8)			
	62	If pH below 9.0, adj to pH 9.0-9.8 with N-7-D only Assume 50%		7-D	
		& Record: pH			
	63	Measure in calibrated container & pour in	35	588-A	35
	64	Heat to 193-195°F in 75-80 min Start 8:15 PM			
	65	Record: HT 192 °F & Rec 195 °F			
	66	Stir 60 min at 193-195°F Record: Start 9:30 PM			
	67	After 20 min S 66 stir Record: pH 8.0 (8.8-9.3)			
	68	If pH 8.8, adj to pH 8.8-9.3 with N-7-D only Assume 50%	100	7-D	50
		Record: pH 9.1			
	69	When S 66 complete, flood to 180-190" (±18,000 G)			
	70	Stop agitator			
		Open Cap on Top of Distributor			
		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
9.30 PM	11.00 PM	144
100 P	300 P	126
3:00 P.M	10:45 P.M	37

DELAYED WAITING FOR 740 C

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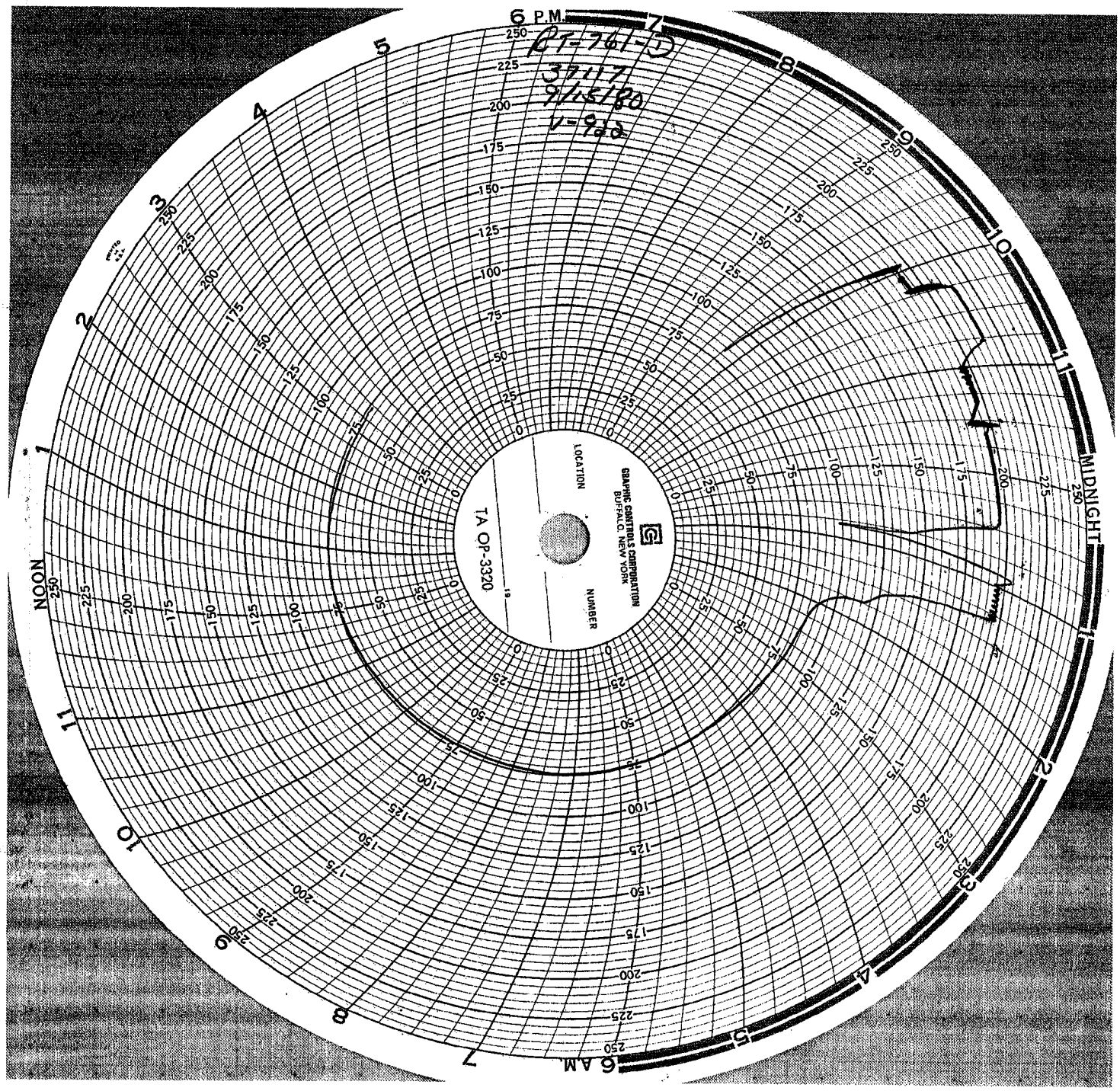

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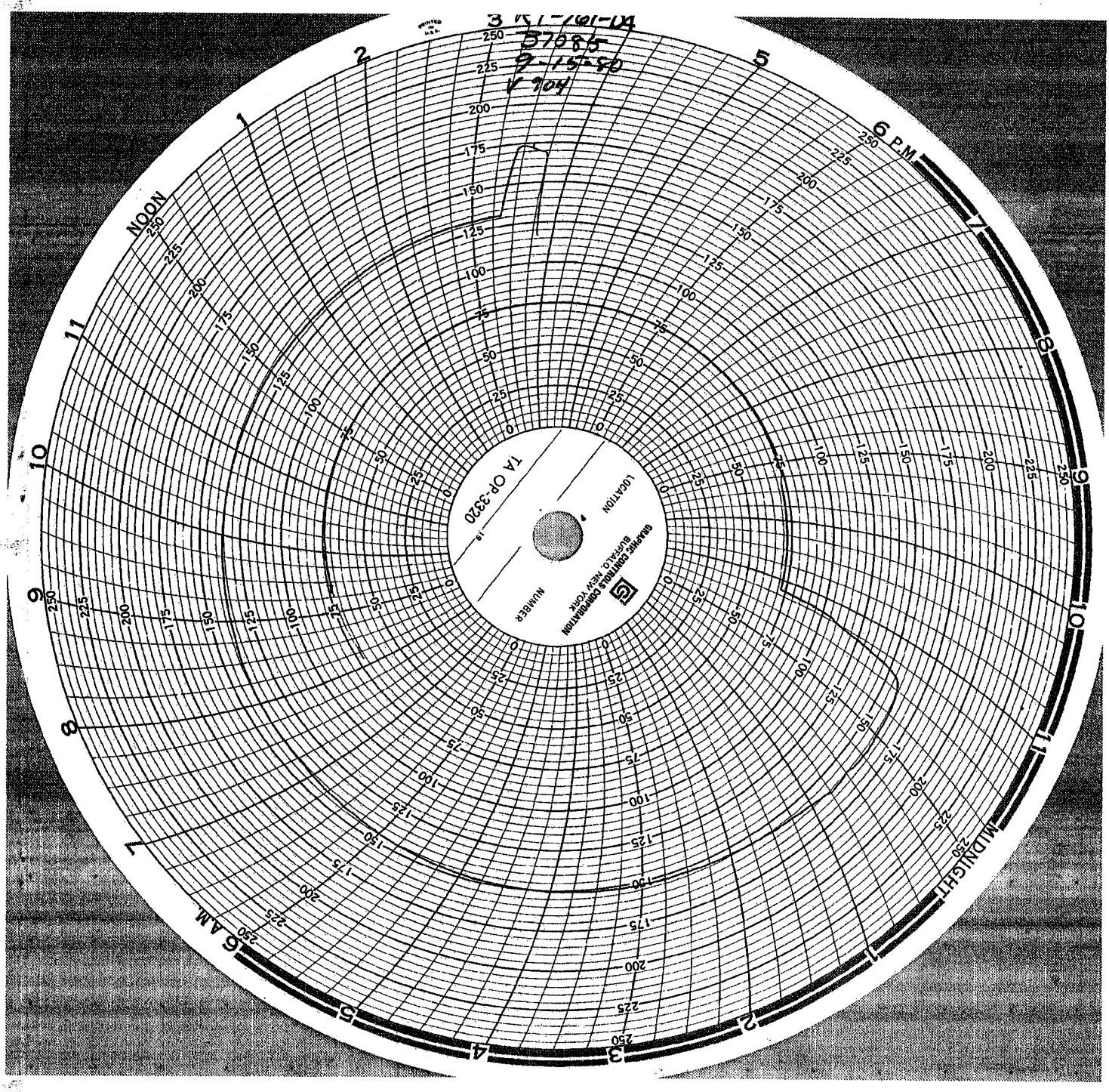

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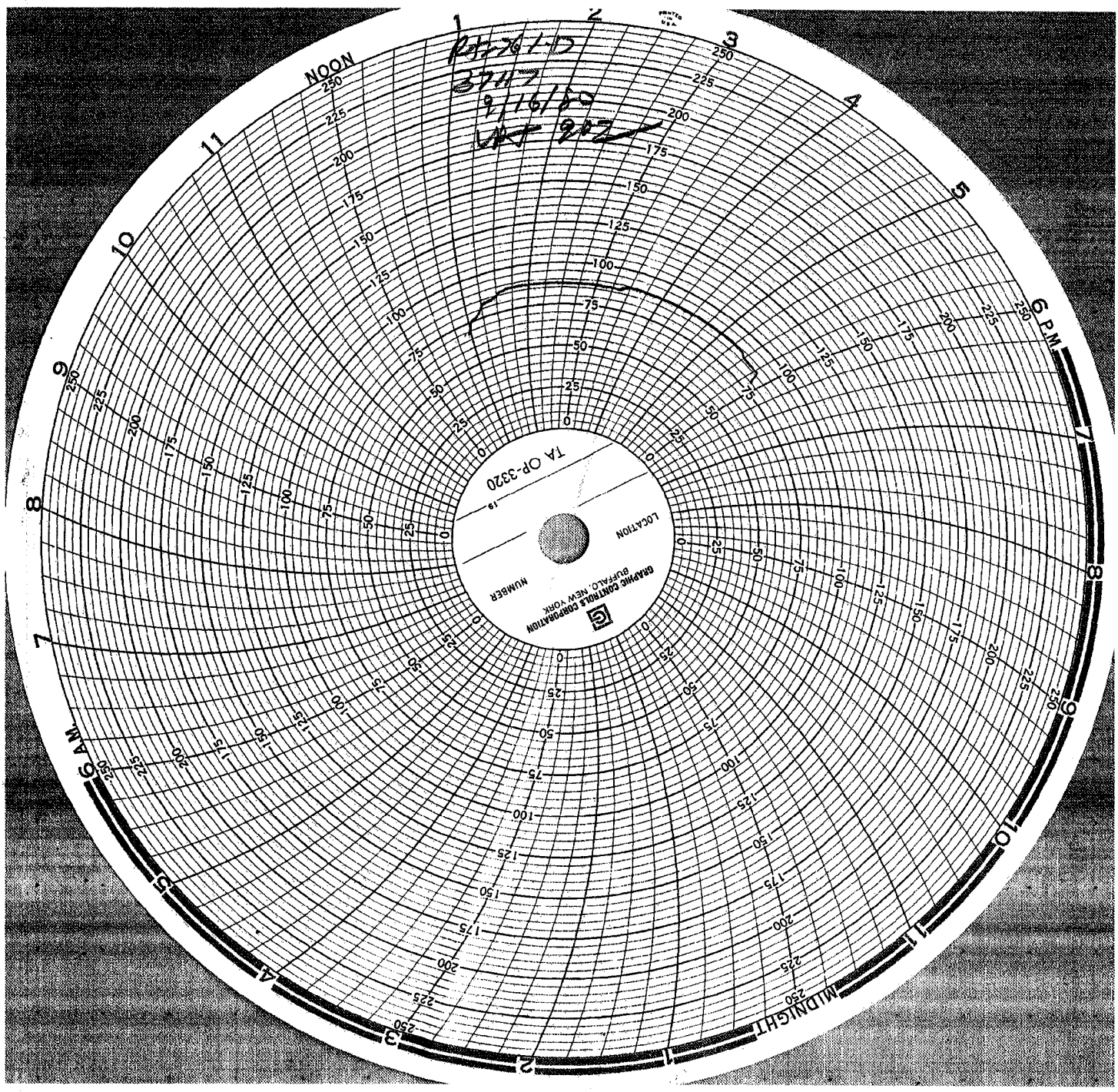

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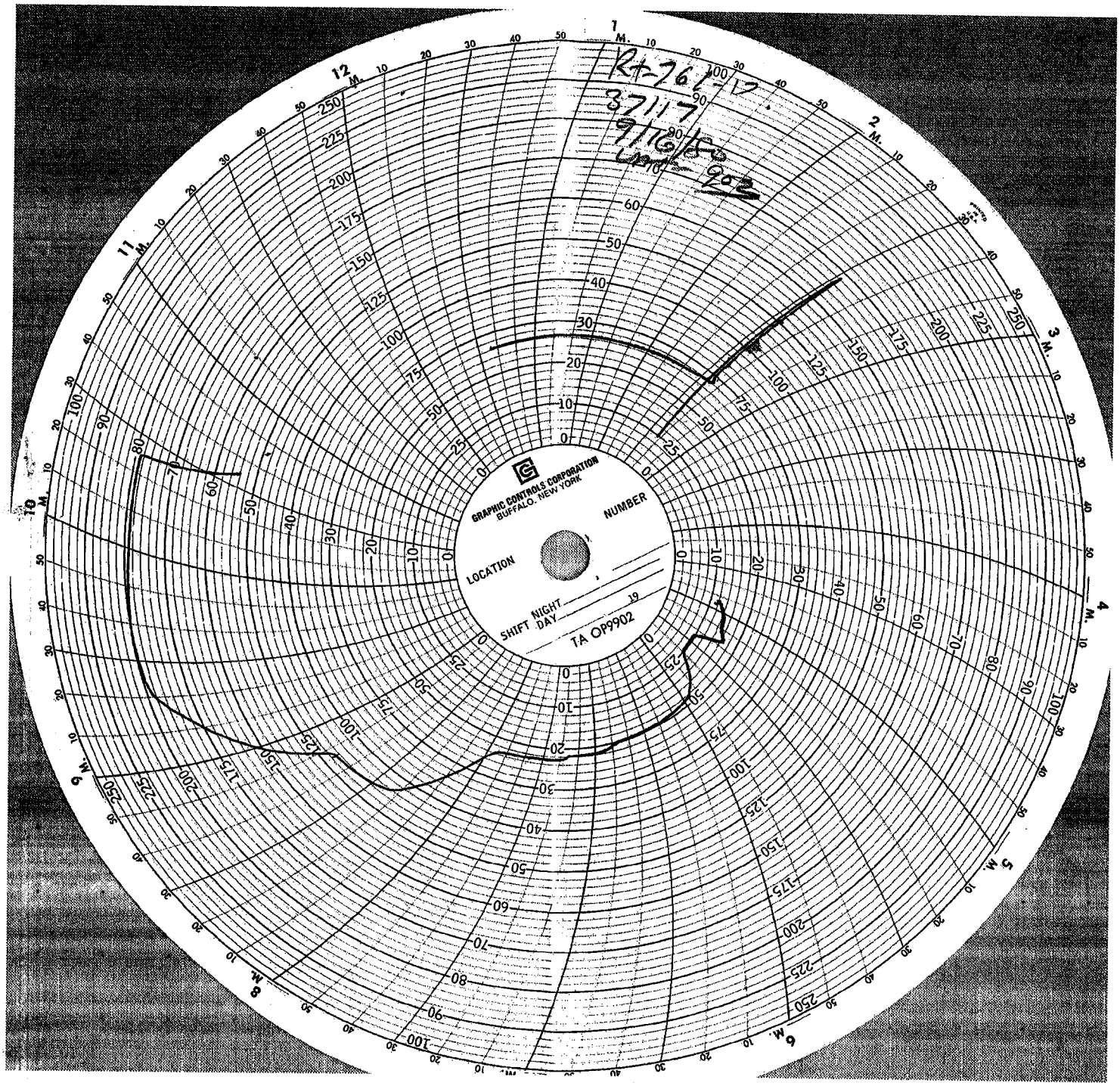

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