

CG 32 CODE RT-761-D PKG.

→ RT-0-81-21086

EST. WGT. 2790 LBS.

STD. HRS. TIME M

PROCESSES		APP. MOVED BY
() RT-761-D	() JJC 4-4-78	
() RT-838-D	() DCG 4-5-78	
()	() MTW 4-13-78	
()	()	
TYPED BY		
NSA 4-19-78		

NON-BLEEDING

IP/AGENT	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.			
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 12		740-C	
	3 Obtain for S 27		82-C	
	4 Install DV & CV Recorder & Controller charts			
921/931	5 Run 16" (160 G) water into V- & adi to 80-100°F			
	6 Add in 2-3 min	110	99-A	110
	7 Add in 1-2 min	50	530-A	50
	8 Stir 5 min & Record: pH (9.5-10.5)			
	9 Stir 20 min or longer to dissolve for S 30			
922 3	10 Run 35" (722 G) water into V-922			
	11 Weigh in V-926 & run in M %		7-0	216
	12 Turn on agitator & steam & dump in from S 2		740-C	1105
	Lot #100% %			
	13 Dump in	25	113-A	25
	14 Dump in	10	777-A	10
	15 Heat to 212-214°F Watch Foam			
	16 Record: BY must be +, Adi if needed Assume 50%		7-0	
	17 Stir 15 min at 212-214°F, then shut off steam. Watch Foam			
	18 Record: HT F & Rec F			
	19 Circulate 15 min or longer thru Sparkler until sol'n is clear. Maintain at 190-195°F for S 24			
Misc. 1	20 Measure units in V-928 for S 39 M %		28-0	533
	21 Weigh in PT for S 42 M %		725-A	401
	22 Weigh in drum for S 48		725-A	40
934/CV 5	23 Run 1" (G) water into V- Note: Use CV if MTY. If CV is not MTY, use V-904			
	24 When S 19 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start Total Min.			

EQUIPMENT		PAGE 2 CG 32 CODE KI-761-D (3)	LBS.	USE LBS.	N CODE	ACCT. LBS.
902	25	Run 56" (1566 G) water into V-902				
6	26	Weigh in V-926 & run in M	%		7-D	682
	27	Dump in from S 3 Lot			82-C	1012
	28	Adj to 70-90°F & stir 10 min to dissolve				
	29	Slurry in 30 Gal water & pour into V-902		100	39-A	100
	30	Steam eject in V-921-931 from S 9				
922 & 904/CV	31	When S 24 complete, stop pump & insert V-922 foot plug				
7	32	Run in 12" (247 G) water & heat to 180-190°F				
	33	Pump V-922 thru sparkler into V-904/CV				
	34	When V-922 MIY blow out sparkler into V-904/CV				
	35	Weigh & add to V- Lot		18 oz	749-C	1
	36	Heat V-904/CV to 165-170°F for S 39				
		NOTE: If N-740-C solution was pumped directly from sparkler to CV at S's 23 & 24 omit S's 37 & 38				
CV	37	Run in 1" (95 G) water into V-				
8	38	If V-904 is used, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min) maintain CV at 165-170°F				
	39	Run in N-28-D from S 21 in 12-15 min				
	40	Stir 5 min				
	41	Adj to 43" (4080 G) at 32-38°F		45 x 350	57-A	
	42	Run in N-725-A from S 21 AFAP (5-10 min)				
	43	Stir 10 min at 32-38°F maintaining + CR. + KI				
		Record: Time Start 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 (+)				
	44	Dump in		1116	20-A	1116
	45	Dump in		244	243-B	244
	46	Dump in		130	65-A	130
	47	Add for maintaining 32-38°F during coupling		36x330	57-A	
902	48	Pour N-725-A from S 22 into V-902				
9	49	Dump in		189	165-A	189
CV	50	Immediately couple V-902 thru undersurface distributor into CV in 18-22 min. Maintain CV at 32-38°F				
10		Record: Start Total Min				
	51	Stir 5 min & Record: Base (+), Diazo (-)				
		pH (9.0-9.8)				
	52	If necessary, adj to pH 9.0-9.8 Record: pH Assume 50%			7-D	
		Assume 32%			28-D	
	53	Weigh in drum & pour in		45	588-A	45
	54	Heat to 184-186°F in 70-75 min				
	55	Record: HT °F & Rec °F				
	56	Stir 30 min at 184-186°F				
	57	After 10 min S 56 stir, record: pH (8.0-9.3)				
	58	If necessary, adj to pH 8.8-9.3 Assume 50%			7-D	
		Record: pH If pH above 9.3 do not adjust				
	59	When S 56 complete, flood to 180-190" (± 18000 G) & stop agitator				

EQUIPMENT		PAGE 2 CG 32 CODE RT-761-D (J), RT-836-D (H)	LBS.	USE LBS.	N CODE	ACCT. LBS.
902	25	Run 56" (1566 G) water into V-902				
6	26	Weigh in V-926 & run in	M 8	49.83%	7-D	735
	27	Dump in from S 3	Lot 10079	1000	82-C	1003
			6131	75		
			6014	75		
	28	Adj to 70-90°F & stir 10 min to dissolve				
	29	Slurry in 30 Gal water & pour into V-902		105	39-A	105
	30	Steam eject in V-902-931 from S 9				
922 & 904/CV	31	When S 24 complete, stop pump & insert V-922 foot plug				
7	32	Run in 10" (247 G) water & heat to 180-190°F - Circulate 15 min thru Sparkler				
	33	Pump V-922 thru sparkler into V-904/CV (See Below For S 33)				
	34	When V-922 MIV blow out sparkler into V-904/CV				
	35	Weigh & add to V- 903	Lot 8907	4	118-C	4
	36	Heat V-904/CV to 165-170°F for S 39				
		NOTE: If N-740-C solution was pumped directly from sparkler to CV at S's 23 & 24 omit S's 37 & 38				
CV	37	Run in 1" (95 G) water into V-				
8	38	If V-904 is used, pump V-904 at 165-170°F thru undersurface distributor into CV AFAP (12-15 min) maintain CV at 165-170°F				
	39	Run in N-28-D from S 21 in 12-15 min				
	40	Stir 5 min				
	41	Adj to 43" (4080 G) at 32-38°F		50 x 330	57-A	16500
	42	Run in N-725-A from S 21 AFAP (5-10 min)				
	43	Stir 30 min at 32-38°F maintaining + CR. + KI				
		Record: Time Start 2:32/PCR + (+) 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 (+)				
	44	Dump in		1166	20-A	1166
	45	Dump in		255	246-B	255
	46	Dump in		135	60-A	135
	47	Add for maintaining 32-38°F during coupling		36x330	57-A	11812
902	48	Pour N-725-A from S 22 into V-902				
9	49	Dump in		189	168-A	189
CV	50	Immediately couple V-902 thru undersurface distributor into CV in 18-22 min. Maintain CV at 32-38°F				
10		Record: Start 3:50/PCR Total Min 25				
	51	Stir 30 min & Record: Base + (+), Diazo - (-)				
		pH 10.0-10.5				
	52	If necessary, adj to pH 10.0-10.5 Record: pH			7-D	
		Assume 50%			28-D	
		Assume 32%			50-A	45
	53	Weigh in drum & pour in		45		
	54	Heat to 184-186°F in 70-75 min (AT 150°F, OPEN WATER SPRAYS 1 1/2 HOURS)				
	55	Record: HT / 3.0°F & Rec / 3.0°F				
	56	Stir 30 min at 184-186°F				
	57	After 10 min S 56 stir, record: pH 9.7 (9.5-10.0)				
	58	If necessary, adj to pH 9.5-10.0 Assume 50%			7-D	
		Record: pH If pH above 10.0 do not adjust				
	59	When S 56 complete, flood to 180-190" (± 18000 G) & stop agitator				
		SHUT OFF WATER SPRAYS				
922/904/CV	60	RUN IN 5" (1000 G) WATER INTO V922. HEAT TO 190-195°F. CIRCULATE 15 MIN THRU SPARKLER PUMP V922 THRU SPARKLER INTO V904/CV				

[illegible]

EQUIPMENT

PAGE 3 CG 32 CODE 31-791-0 (9)

USE
LBS.

M
CODE

ACCT.
LBS.

When instructed by Processing Area half-way thru pressing.

1. Dump In

10

588-A

10

2. Stir 5 min

3. Advise processing to resume pressing

START

FIN

OPTR

FORM A

CODE _____ LOT _____ VATS _____ EQUIP. _____
DATE _____ OPER _____ SUPERVISOR _____

1. Used all stumps, leave 1 stump identified.
2. Clean shovel.
3. Chute washed & top replaced.
4. Water hose coiled.
5. Steam ejector turned off after finished in vat.
6. Scale left clean.
7. Added ice to vat only when volume reaches agitator.
8. Floor cleaned around vats used.
9. Hoses coiled or on rack on diazo press.
10. Hoses not crossing walkway after finished.
11. Pump shut off after removing hose from intake.
12. Ice blower shut off after using.
13. All spills in area worked clean.
14. Door on instruments closed.
15. All empty drums removed from area & discarded.
16. Corrosive containers properly covered.
17. Top of vats cleaned of color, paper cups, strings, etc.
18. Vat door after finished - hatches on abbe's.
19. All tools cleaned & placed in rack or proper place.
20. Ice house clean - tools on racks.
21. Revolver cleaned - platform & pit.

ATTACH TO MAKE CARD

1701-89







