

CG 32 CODE RT-618-D

PKG.

NOV 1 1980

NOV 12 80 37835
EST. WGT. 2902 LBS.

STD. HRS. 10.4 TIME

7A M
PRE-COAT-SPARKER

PROCESSES	APPROVED BY
(1) RT-618-D (S)	JJG 08-15-78
() RT-657-P (F)	AMJ 09-19-78
() ()	
() ()	
TYPED BY	
ENW092078	

CLEAN UP
AS YOU GO ALONG

LEAVE ONE STUMP ONLY

NON-BLEEDING

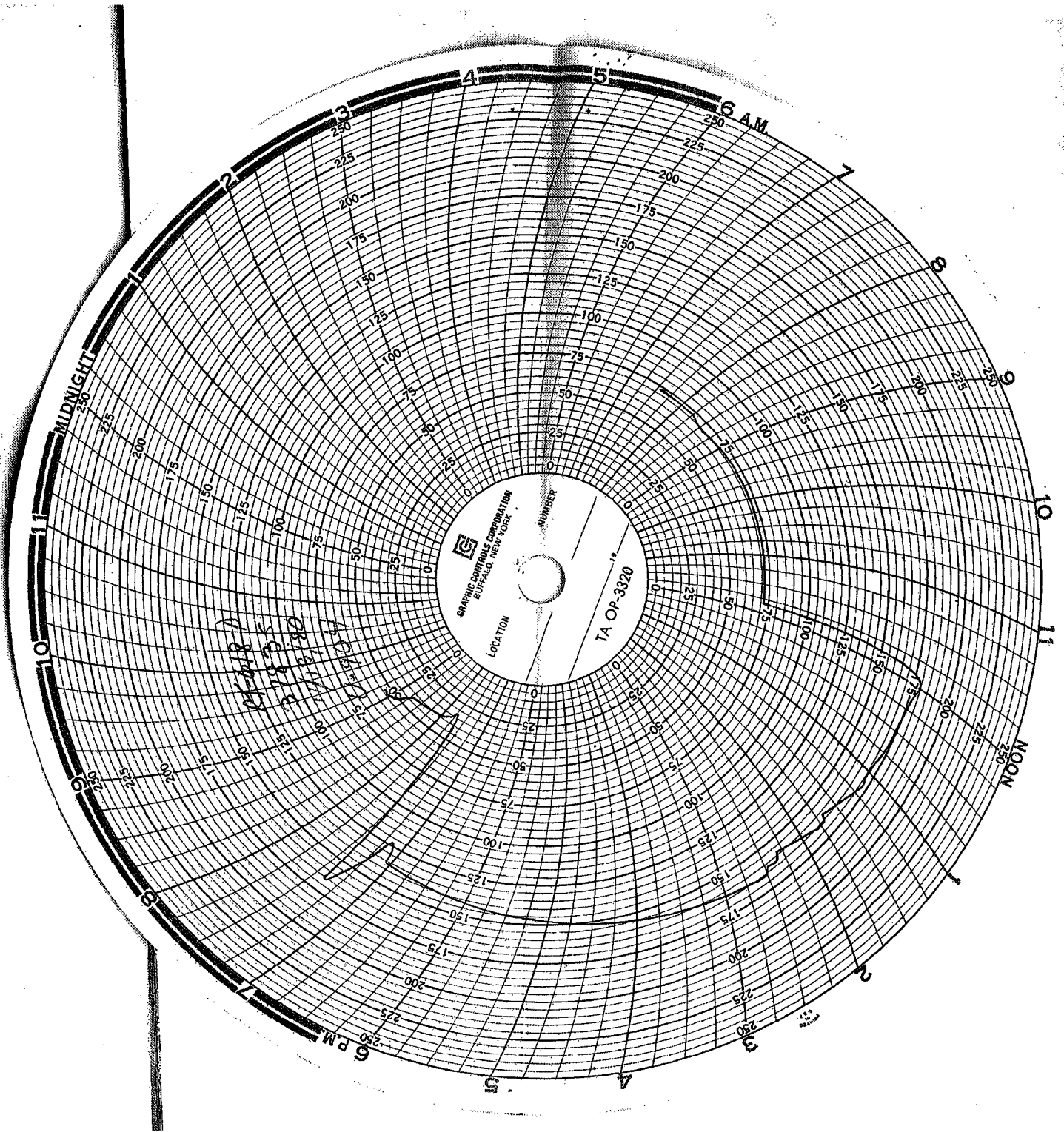
EQUIPMENT	NAME: WATCHUNG® RED Y	USE LBS.	N CODE	ACCT. LBS.
Prep 1	Record: Batches since Sparkler last cleaned. After 5 batches, clean, dress Sparkler & pre-coat with 15#	15	777-A	15
	Obtain for S 11		740-C	
	Obtain for S 24		253-C	
	Install DV & CV Recorder & Controller charts			
921/931 2	Run 10" (100 G) water into V-921 & adj to 80-100°F			
	Add in 1-2 min	63	530-A	63
	Stir 2 min & Record: pH 10.2 (9.5-10.5)			
	Stir 20 min or longer for S 27			
922 3	Run 24" (700 G) water into V-922			
	Weigh in V-926 & run in M 12, 49.92 % 403		7-D	201
	Turn on agitator & steam & dump in from S 2		740-C	1035
	Lot 100% %			
	111 1035 7072 1047			
	Dump in	50	113-B	50
	Dump in	10	777-A	10
	Heat to 212-214°F. Record: HT °F; °F WATCH FOAM			
	Record: BY + (+), if necessary, adj to +BY Assume 50% 7-D			
	Stir 30 min at 212-214°F, then shut off steam WATCH FOAM			
	Circulate 15 min or longer thru Sparkler until sol'n is clear			
	Maintain at 190-195°F for S 19 & Record: HT 200 °F			
	& Recorder 195 °F			
	Record: Start 10:40 Total Min 20 Clarity OK			
	NOTE: Sample from hose - show to Supervisor for OK			
904 4	Run 1" (50 G) water into V-904			
	When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 11:45 Total Min 20			
Misc 5	Weigh in PT for S 35 M 12, 33.16 % 1001		725-A	332
	Measure 524 units in V-928 for S 33 M 10, 31.35 % 1337		28-D	419
CV 6	Run 16" (1530 G) water into V-904			
	Weigh in V-926 & run in M 12, 49.92 % 1016		7-D	507
	Dump in from S 3		253-C	905
	Lot 5017 912			912
	Weigh on postal scale & dump in Lot		180-C	
	Adjust to 70-90°F & stir to dissolve			
	Steam eject V-921/931 into CV			

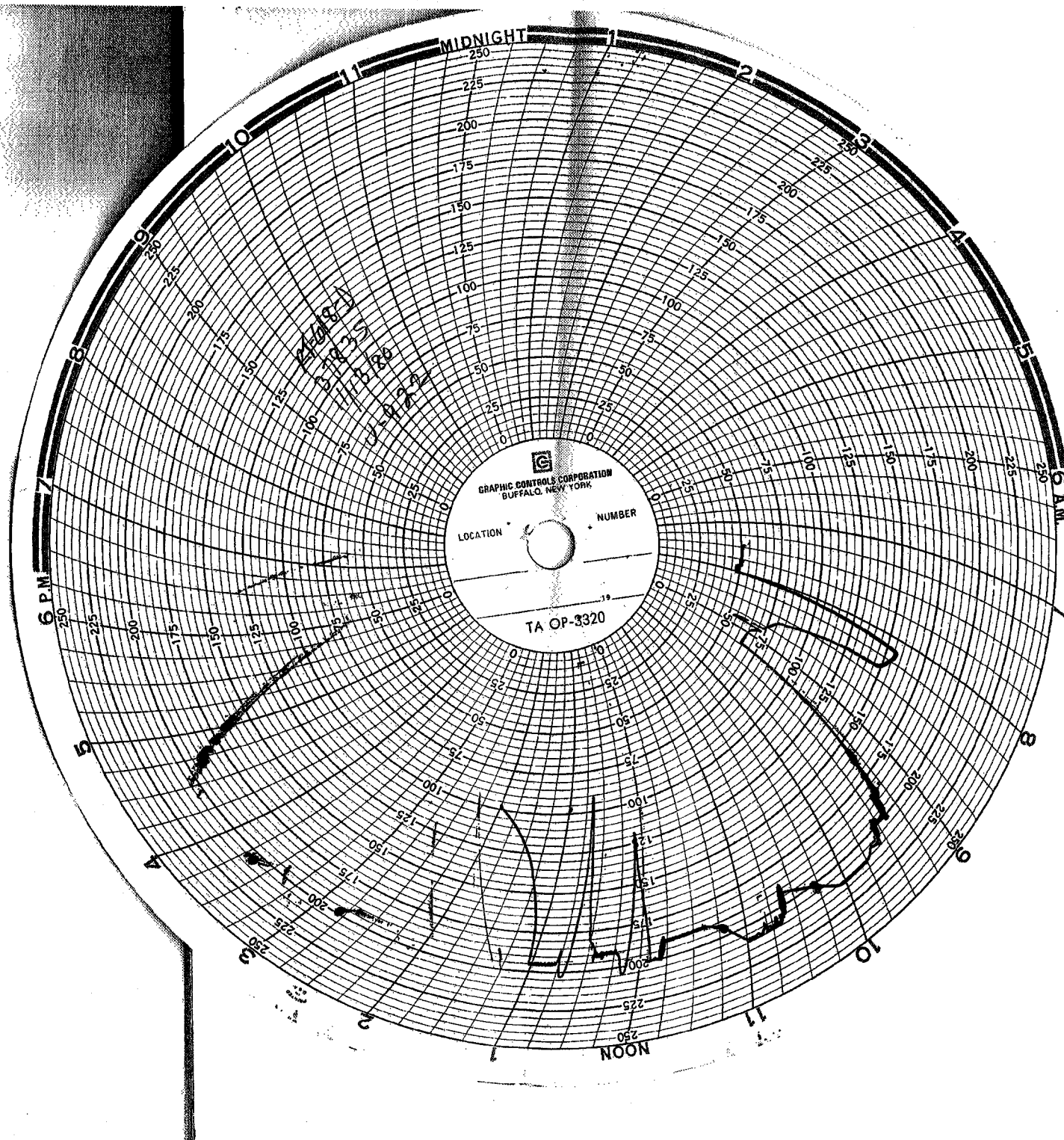
EQUIPMENT	PAGE	CG	32	CODE	RT-618-D (S)	EST. WGT.	2902	LBS.	USE	N	ACCT.
									LBS.	CODE	LBS.
922	28				When S 19 complete, shut off pump & insert V-922 foot plug						
7	29				Run in 10" (247 G) water & heat to 180-190°F 190-195°F - CIRCULATE THRU SPARKLER FOR 15 MIN - PUMP V-922 THRU SPARKLER INTO V-904						
904	30				Pump V-922 thru Sparkler into V-904 See attached page for S-30						
8	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						
	34				Adj to 129" (3409 G) at 28-30°F & Record: Temp. °F			48 x 330		57-A	14850
	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 , 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	37				Dump into CV			180		65-A	180
	38				Adj to 37" (3496 G) at 28-32°F			30 x 330		57-A	9900
					Record: Temp 182°F Volume 37 "						
	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 8:12 Total Min 55						
	42				Stir 30 min & Record: Base + (+), Diazo - (-), Final Temp 32 °F, pH 9.8 (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 184-186°F in 65-70 min & Record: HT 184 °F & Recorder 186 °F						
DV	45				Run 24 " (600 G) water into DV						
10	46				Turn on agitator & steam & dump in			1620		16-B	1620
	47				Heat to 155-160°F & stir to dissolve						
CV	48				When S 44 complete, immediately strike DV thru undersurface distributor into CV in 7-10 min. Maintain CV at 184-186°F						
11					Record: Start 10:30 PM Total Min 12						
	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 9.1 (9.0-9.4) & stop agitator SAMPLE						
					START 7:00 AM 3: PM 11:00 PM						
					FIN 3:00 PM 11: PM 11:30 PM						
					OPTR 322 222 126						
					BATCH DELAYED REC. ICE MASH. 7: 6:45 PM						
					When instructed by Processing Area half way thru pressing, dump in & stir 5 min & stop agitator. Resume pressing			10		588-A	10

1. NAME S-38415

~~308~~ PUMP V-922 THRU SPARKER
V904 AUTO V-904

CONTINUE WITH S-37





U-982

