

OCT 14 1982
(DATE)

K2K63

(LOT)

(EST WGT)

PROCESSES APPROVED BY
() RT-870-D (H) EWK 1-11-82
COMTYP JOB NAME: 32RT870DMH
TYPED BY: JMH

STANDARD HRS.

TIME 7 A.M.

PREPARATION NOTES:

~~RUN NOT N-979 Solution Then Sparkler Done~~

~~NOTE Pre Coat Sparkler Done~~

NON-BLEEDING

EQUIP MENT	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. SUPV TO REVIEW WITH P.R. SUPV & RECORD: PRESS WILL BE READY M / PR SUPV START MAKING M / MAKING SUPV NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V-922 NOTE: RUN 15" WATER INTO V-904. PUMP WATER FROM V-904 THRU DISTRIBUTOR. IF WATER DOES NOT COME OUT OF ALL DISTRIBUTOR HOLES WITH FULL FORCE, NOTIFY SUPERVISOR.			
PREP 1	RECORD: BATCHES SINCE SPARKLER LAST CLEANED. AFTER 4 BATCHES, CLEAN, DRESS SPARKLER & PRE-COAT WITH 15# DICALITE, FILTER AID.	15	777-A	15
	2 OBTAIN FOR S11 2-CHLORO-4-AMINOTOLUENE-5-SULFONIC ACID.		740-C	
	3 OBTAIN FOR S27 3-HYDROXY-2-NAPHTHOIC ACID		82-C	
	4 INSTALL DV & DV RECORDER & CONTROLLER CHART			
921/ 2	5 RUN 11" (100G) WATER INTO V-921 & ADJ TO 80-100 DEG F 6 ADD IN 2-3 MIN DRESINATE X 7 STIR 5 MIN & RECORD PH 10.2 (9.5-10.5) 8 STIR 20 MIN OR LONGER TO DISSOLVE FOR S49	108	530-A	108
922 3	9 RUN 35" (722G) WATER INTO V-922 10 WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M 12 50.16 % 11 TURN ON AGITATOR & STEAM & DUMP IN FROM S2 2-CHLORO-4-AMINOTOLUENE LOT #100% 322 1086 9852 12 5-SULFONIC ACID	422 1102	7-D 740-C	212 1086
	13 DUMP IN ACTIVATED CARBON	25		25
	14 DUMP IN FILTER AID	10		10
	15 HEAT TO 212-214 DEG F WATCH FOAM!! RECORD: BY 1 (+) IF NECESSARY ADJ TO +BY SODIUM HYDROXIDE ASSUME 50%		7-D	
	16 STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM! NOTE: RECORD SPARKLER PRESSURE 0 PSI. IF NOT ZERO NOTIFY SUPERVISOR.			

Chk Weigh
&
Record
in back page

OCT 18 1982

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EQUIP MENT		PAGE 2 OF 4 CG 32 CODE RT-870-D (H)	USE LBS	N-CODE	ACCT LBS
922 3 CONT	17	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 DEG F FOR S22. RECORD: START <u>5:15 AM</u> TOTAL MIN <u>15</u> CLARITY <u>clear</u> HT <u>120</u> F & REC <u>195</u> F			
MISC 4	18	MEASURE <u>38 1/2</u> * UNITS IN V-928 FOR S39 HYDROCHLORIC ACID M <u>2</u> <u>31.01</u> %	<u>1412</u>	28-D	438
	19	WEIGH SODIUM NITRITE IN PT FOR S42 M <u>9</u> <u>33.36</u> %	<u>1190</u>	725-A	397
	20	WEIGH SODIUM NITRITE IN DRUM FOR S50 M <u>9</u> <u>33.36</u> %	<u>129</u>	725-A	43
904/CV 5	21	RUN 2" (58G) WATER INTO V-904			
	22	WHEN S17 IS COMPLETE, PUMP IN V-922 THRU SPARKLER, MAINTAIN V-922 AT 190-195 DEG F. RECORD: START <u>5:30 AM</u> TOTAL MIN <u>60</u>			
922 6	23	WHEN S22 COMPLETE, SHUT OFF PUMP AND INSERT V-922 FOOT PLUG			
	24A	RUN IN 10" (209G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904/CV 7	24B	AND PUMP V-922 THRU SPARKLER INTO V-904/CV			
902 8	25	RUN 65" (1696G) WATER INTO V-902			
	26	WEIGH SODIUM HYDROXIDE IN V-926 & RUN IN M <u>12</u> <u>50.16</u> %	<u>795</u>	7-D	399
	27	DUMP IN FROM S3 3-HYDROXY- 2-NAPHTHOIC ACID <u>LOT 8293</u>	<u>994</u>	82-C	994
	28A	ADJ TO 70-90 DEG F & STIR TO DISSOLVE			
922 9	28B	RUN IN 5" (104G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904/CV 10	29	PUMP V-922 THRU SPARKLER INTO V-904/CV			
	30	WHEN MTY BLOW OUT SPARKLER INTO V-904/CV			
	31	DISSOLVE ALKANOL XC IN 20G WATER AT 150-160 F FROM HOT WATER MIXER IN DRUM & POUR IN.	32	133-B	32
	32	HEAT TO 165-170 F FOR S38			
922 11	33	RUN <u>34</u> (328G) WATER INTO V-922 & ADJ TO 80-100 DEG F.	<u>921</u>		
	34	ADD IN 6-7 MIN DRESINATE X			
	35	STIR 5 MIN & RECORD PH. <u>10.0</u> (9.5-10.5)	<u>300</u>	530-A	<u>300</u>
	36	STIR 20 MIN OR LONGER TO DISSOLVE FOR S59			

EQUIP MENT	PAGE 3 OF 4 CG 32 CODE RT-870-D (H)	USE LBS	N-CODE	ACCT LBS
CV 12	NOTE: IF N-740-C SOL. WAS PUMPED DIRECTLY FROM SPARKLER TO CV S21, 24B, 29 OMIT S37 & 38 37 RUN 1" (95G) WATER INTO V-902 38 PUMP V-904 AT 165-170 DEG F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP. (12-15 MIN) 39 RUN IN N-28-D HYDROCHLORIC ACID FROM S18 IN 12-15 MIN. MAINTAIN 165-170°F IN CV. 40 STIR 15 MIN AT 165-170 DEG F 41 ADJ TO 46° (4347G) AT 32-38 DEG F 42 RECORD: TEMP 30 DEG F, VOLUME 48 43 RUN IN N-725-A SODIUM NITRITE FROM S19 AFAP (5-10 MIN) & RINSE IN PT NOTE: PROCESS HAS A VERY LOW N-28-D EXCESS CHECK CR VERY CAREFULLY 44 STIR 20 MIN AT 32-38 DEG F MAINTAINING +CR, +KI FOR S44. RECORD: TIME START 12:55 PM CR 5, KI 1 NOTE: 1) IF CR-, KI- ADD 20# "AS IS" INCREMENTS RECORD CR (+) KI (+) HYDROCHLORIC ACID ASSUME 32% 2) IF CR+, KI- ADD 20# "AS IS" INCREMENTS RECORD CR (+) KI (+) SODIUM NITRITE ASSUME 33% 45 DUMP IN CALCIUM CHLORIDE 1026 46 ADD FOR MAINTAINING 32-38 DEG F THRU S55 32X330	54X330	57-A	18150
PT 13	47 DUMP IN STRONTIUM NITRATE 68 48 STIR 30 MIN OR LONGER WITH LIGHTNIN MIXER TO SOLUTION FOR S58	246-B, E	68	
902 14	49 WHEN S28A COMPLETE, STEAM EJECT V-921/931 FROM S8 INTO V-902 50 POUR IN N-725-A SODIUM NITRITE FROM S20 51 ADD AMMONIUM CHLORIDE 213	165-A	213	
CV 15	52 IMMEDIATELY COUPLE V-902 THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN. RECORD: START 1:50 PM TOTAL MIN 20			
PT 16	53 DURING S52 WEIGH SODIUM HYDROXIDE IN PT M 12 50.16 % 54 DILUTE TO MAXIMUM VOLUME (+/-100G) FOR S56	7-D	140	
CV 17	55 WHEN S52 COMPLETE, STIR 30 MIN & RECORD: DIAZO (+) BASE (+) PH 9.8 (5.0-6.0) TEMP 38 (32-38 F) 56 RUN SODIUM HYDROXIDE IN PT FROM S54 THRU UNDERSURFACE LINE, RINSE IN PT & STIR 15 MN 57 RECORD: DIAZO (-) BASE (+) PH 9.8 (9.0-9.8) 58 RUN IN STRONTIUM NITRATE N-246-B, E SOL'N FROM S48 & RINSE IN PT 921 59 STEAM EJECT IN V-902 FROM S36 60 STIR 5 MIN & RECORD: PH 9.8 (9.0-9.8)			

EQUIP MENT		PAGE 4 OF 4 CG 32 CODE RT-870-D (H)	USE LBS	N-CODE	ACCT LBS
17 CONT	41	IF PH BELOW 9.0 ADJ TO PH 9.0-9.8 WITH N-7-D ONLY. RECORD PH <u>✓</u>			
	42	SODIUM HYDROXIDE ASSUME 50%		7-D	
	43	POUR IN 1 OCTANOL	38	588-A	38
	63	HEAT TO 193-195 DEG F IN 70-75 MIN & RECORD HT <u>195</u> DEG F AND REC <u>195</u> DEG F			
	64	STIR 60 MIN AT 193-195 DEG F. RECORD: START <u>5:10 PM</u>			
	65	AFTER 20 MIN S64 STIR RECORD PH <u>8.5</u> (8.8-9.3)			
	66	IF PH BELOW 8.8, ADJ TO PH 8.8-9.3 WITH N-7-D ONLY. RECORD PH <u>9.0</u> ASSUME 50%	64	7-D	32
		AFTER S64 STIR, FLOOD TO 180-190" (+/-18,000G) AND STOP AGITATOR			
		<i>1st Sample</i>			

WHEN INSTRUCTED BY PROCESSING AREA HALFWAY
THRU PRESSING, DUMP IN, STIR 5 MIN & STOP
AGITATOR. RESUME PRESSING.

10 588-A 10

START	FIN	OPTR
<u>2:30 AM</u>	<u>7:00 AM</u>	<u>237</u>
<u>2 PM</u>	<u>6:30 PM</u>	<u>120</u>

CODE: RT-870 D LOT K2K63

N- 740 - C CHECK-WEIGH & CALCULATE

DRUM STENCILED					NEWARK CHECK-WEIGH				
LOT	GROSS	TARE	Net	%	GROSS	TARE	NET	X%AS DECIMAL	#/100%
325			325	98.52	343	18	325		
325			325	98.52	343	18	325		
325			325	98.52	343	18	325		
Stump					Stump		127		
N28	276#	84	192						
	354	84	270						
	390	84	306						
	375	84	291						
	373	84	289						
	148	84	64						
Total			1412						
N- 82 - C									
8295	266	16	250		266	16	250		
11	266	16	250		266	16	250		
11	266	16	250		266	16	250		
							244		
							994		





