MAKING INSTRUCTIONS: BATCH UNIT

S.V. C.V. 901 903 D.V. 904

CG 32 CODE RT-618-D PKG

→ NOV 11 80 37814

EST. WGT. 2902 LBS.

STD. HRS. 10.4 TIME 3 PM

3 Pm

NOV 13 1980

2 25

± 25 lbs. lost when V-903 foamed over.

PROCESSES	APPROVED BY
( ) RT-618-D (S)	JJG 08-15-78
( ) RT-657-P (F)	AMJ 09-19-78
( ) ( )	
( ) ( )	
TYPED BY	
emw092078	

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	1	Record: 4 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 24		253-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 1-2 min	63	530-A	63
	7	Stir 2 min & Record: pH 103 (9.5-10.5)			
	8	Stir 20 min or longer for S 27			
922 3	9	Run 34" (700 G) water into V-922			
	10	Weigh in V-926 & run in M 12 , 49.92%	403	7-D	201
	11	Turn on agitator & steam & dump in from S 2		740-C	1035
		Lot 111 100% 1035 % 98.82	1047		
	12	Dump in	50	113-B	50
	13	Dump in	10	777-A	10
	14	Heat to 212-214°F. Record: HT °F; °F WATCH FOAM			
	15	Record: BY + (+), if necessary, adj to +BY Assume 50%		7-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	Sparkler Pressure		
		Maintain at 190-195°F for S 19 & Record: HT 194 °F	0 PSI		
		& Recorder 195 °F	If not zero		
		Record: Start 7:15 Pm Total Min 80 Clarity 0.15.			
		NOTE: Sample from hose - show to Supervisor for OK	notify Supervisor		
904 4	18	Run 1" (50 G) water into V-904			
	19	When S 17 complete, pump in V-922 thru Sparkler. Maintain V-922 at 190-195°F. Record: Start 8:40 Pm Total Min 20			
Misc 5	20	Weigh in PT for S 35 M 12 , 33.16%	1001	725-A	332
	21	Measure 853/4 units in V-928 for S 33 M 10 , 31.35%	1337	28-D	419
CV 6	22	Run 16" (1530 G) water into V-903			
	23	Weigh in V-926 & run in M 12 , 49.92%	1016	7-D	507
	24	Dump in from S 3 Lot		253-C	~~905~~ 912
		504	450		
		500	450		
		499	12		
	25	Weigh on postal scale & dump in Lot	~~7~~	~~190-C~~	~~7~~
	26	Adjust to 70-90°F & stir to dissolve			
	27	Steam eject V-921/931 into CV			

K 13829 REV.

EQUIPMENT		PAGE 2 CG 32 CODE RT-618-D (S) EST. WGT. 2902 LBS.	USE LBS.	N CODE	ACCT. 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~~ 190-195F & REGULATE			15 MIN
		FROM Sparkler — Pump V-922 thru Sparkler into V-904			
904	30	~~Pump V-922 thru Sparkler into V-904~~ See attached page for S30			
8	31	When MTY blow out Sparkler into V-904			
	32	Heat to 165-170°F (Sample & show to Supervisor for O K)			
	33	Run in N-28-D from S 21 in 12-15 min & stir 5 min at 165-170°F	45		
	34	Adj to 129" (3409 G) at 28-30°F & Record: Temp 30 °F	42 x 330	57-A	15180
	35	Run in N-725-A from S 20 AFAP (5-10 min)			
	36	Stir 10 min at 28-35°F maintain +CR, +KI for S 41			
		Record: Time Start 17', 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
9	38	Adj to 37" (3496 G) at 28-32°F	~~4725~~ x 330	57-A	15510
H.I.		Record: Temp 28 °F Volume 68"			
	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	7 X 330	57-A	2310
		Record: Start 10 Total Min			
	42	Stir 5 min & Record: Base + (+), Diazo — (-),			
		Final Temp 32 °F, pH 9.4 (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 ~~180-182~~°F in 65-70 min &			
		Record: HT 167 °F & Recorder 166 °F			
DV	45	Run 10" (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			
11		distributor into CV in 7-10 min. Maintain CV at ~~175-176°F~~	180-182F		
		Record: Start 425 Total Min 17			
	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 8.6 (9.0-9.4) & stop agitator SAMPLE			
		START FIN OPTR			
		3100 lbs 11100 lbs 20			
		11 in 5 Min 120			
		When instructed by Processing Area half way thru pressing,			
		dump in & stir 5 min & stop agitator. Resume pressing	10	588-A	10
					1

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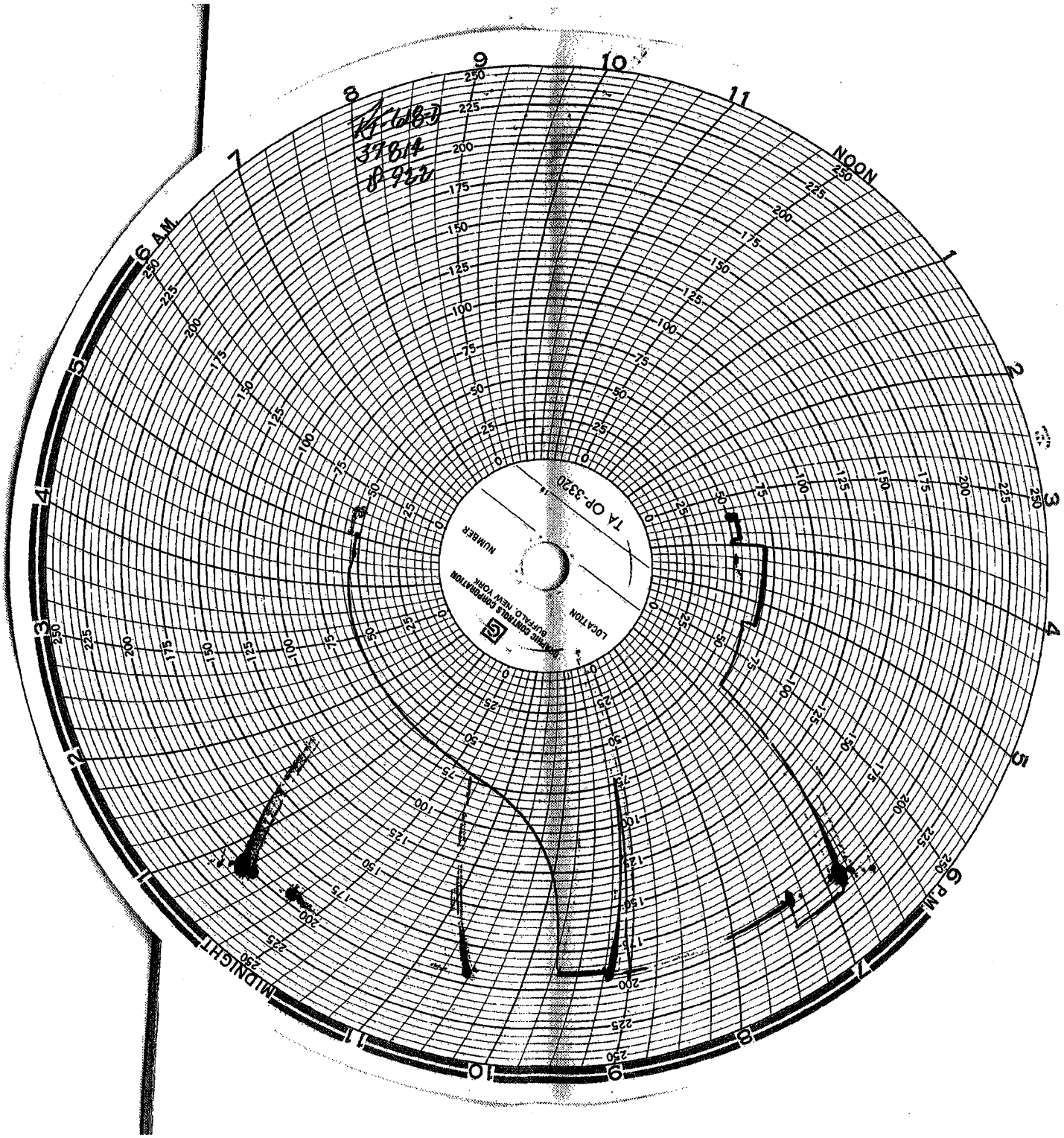
V922	30A	RUN 8" (165 GAL) WATER INTO V922 & HEAT TO 190-195°F CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOLUTION IS CLEAR. MAINTAIN 190-195F THRU S-30[redacted]		
V904	30B	PUMP V-922 THRU SPARKLER INTO V-904		
		CONTINUE WITH S-3[redacted]		



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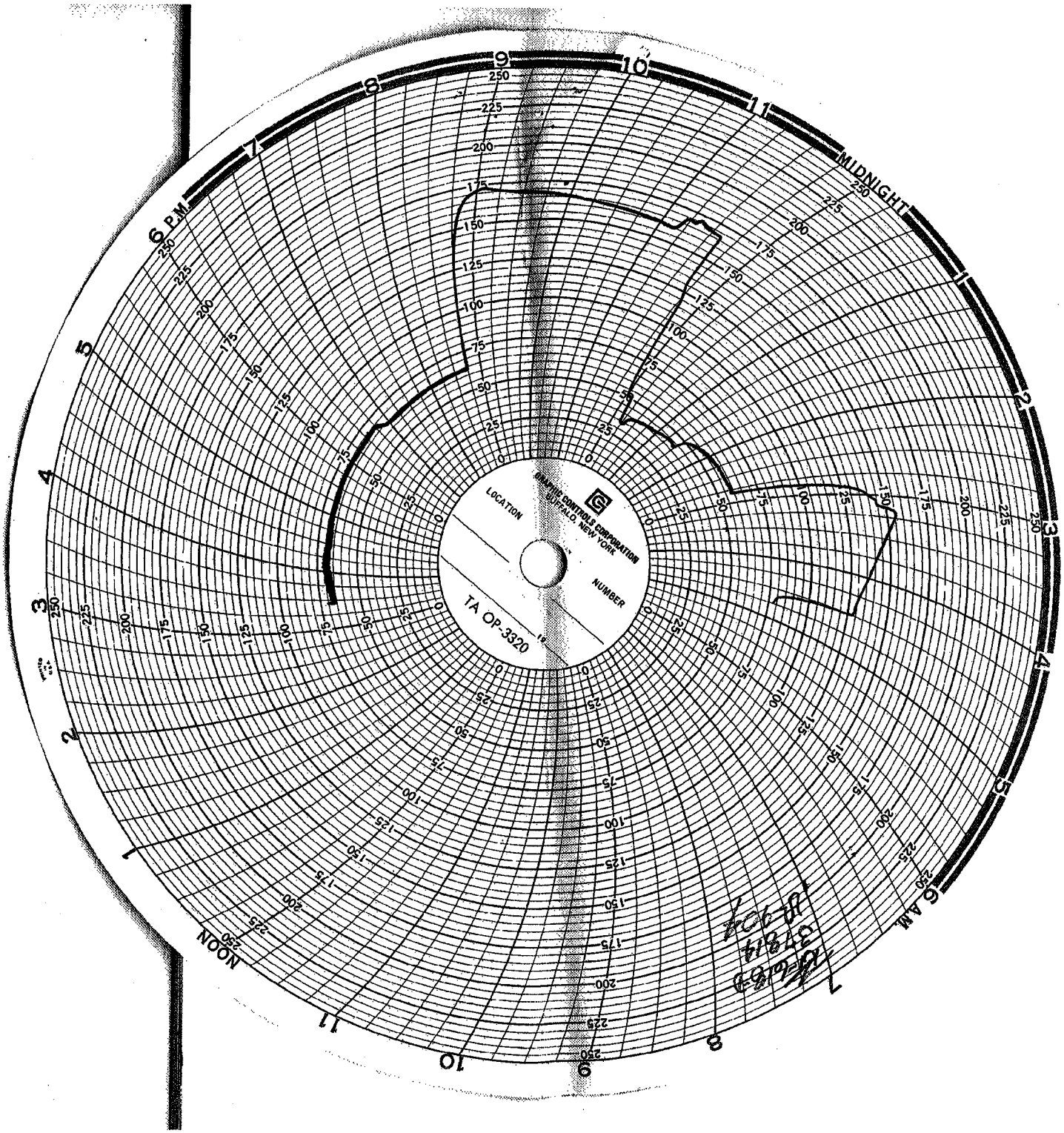

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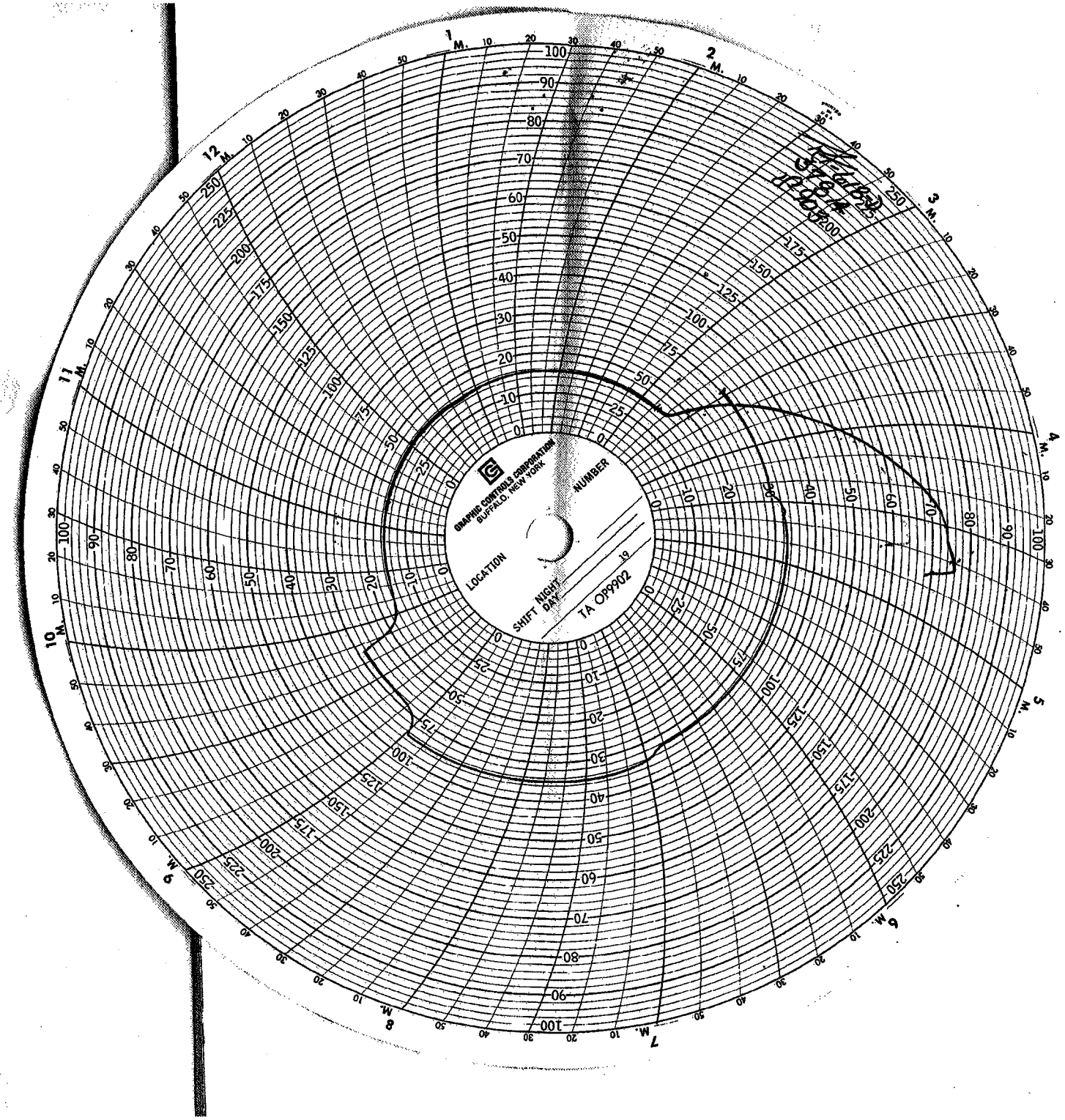

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