

S.V.

MAY 1 1981

C.V. 901, 903

D.V. 902, 904

CG 32 CODE RT-867-D PKG

PROCESSES

APPROVED BY

MAY -0-81-21477

() RT-867-D (D)

JJG 4/1/81

(DATE) (LOT NUMBER)

() ALTERNATE ()

() ()

TYPED BY: JMH

ESTIMATED WGT 2170 LBS.

STANDARD HRS. _____

TIME _____ M

PREPARATION NOTES: _____

EQUIP MENT		NAME: WATCHUNG RED B	USE LBS	N-CODE	ACGT LBS
		NOTE: DO NOT START IF PRESS WILL NOT BE AVAILABLE WITHIN 3 HRS AFTER MAKING. MAKING SUPVR TO REVIEW WITH P.R. SUPV & RECORD: PRESS WILL BE READY _____ M _____ PR SUPVR START MAKING _____ M _____ MAKING SUPV _____			
		NOTE: NOTIFY PRESS ROOM BEFORE ROPING OFF AREA UNDER V-922			
PREP 1	1	IF NECESSARY, CLEAN, DRESS SPARKLER & PRE- COAT WITH 15#		777-A	
	2	OBTAIN FOR S7		740-C	
	3	OBTAIN FOR S24		82-C	
	4	INSTALL DV & CV RECORDER & CONTROLLER CHART			
922 2	5	RUN 35: (722G) WATER INTO V-922			
	6	WEIGH IN V-926 & RUN IN M _____ %		7-D	206
	7	TURN ON AGITATOR & STEAM & PUMP IN FROM S2 LOT 100% %		740-C	1054

	8	DUMP IN	25	113-A	25
	9	DUMP IN	10	777-A	10
	10	HEAT TO 212-214 DEG F WATCH FOAM			
	11	RECORD: BY _____, MUST BE + ASSUME 50%		7-D	
	12	STIR 30 MIN AT 212-214 DEG F, THEN SHUT OFF STEAM WATCH FOAM			
		RECORD: SPARKLER PRESSURE _____ PSI. IF NOT ZERO, NOTIFY SUPERVISOR			
	13	CIRCULATE 15 MIN OR LONGER THRU SPARKLER UNTIL SOL'N IS CLEAR. MAINTAIN AT 190-195 F FOR S18 RECORD: START _____ TOTAL MIN _____ CLARITY _____			
	14	RECORD: HT _____ DEG F & REC _____ DEG F			

DUPLICATE 7772

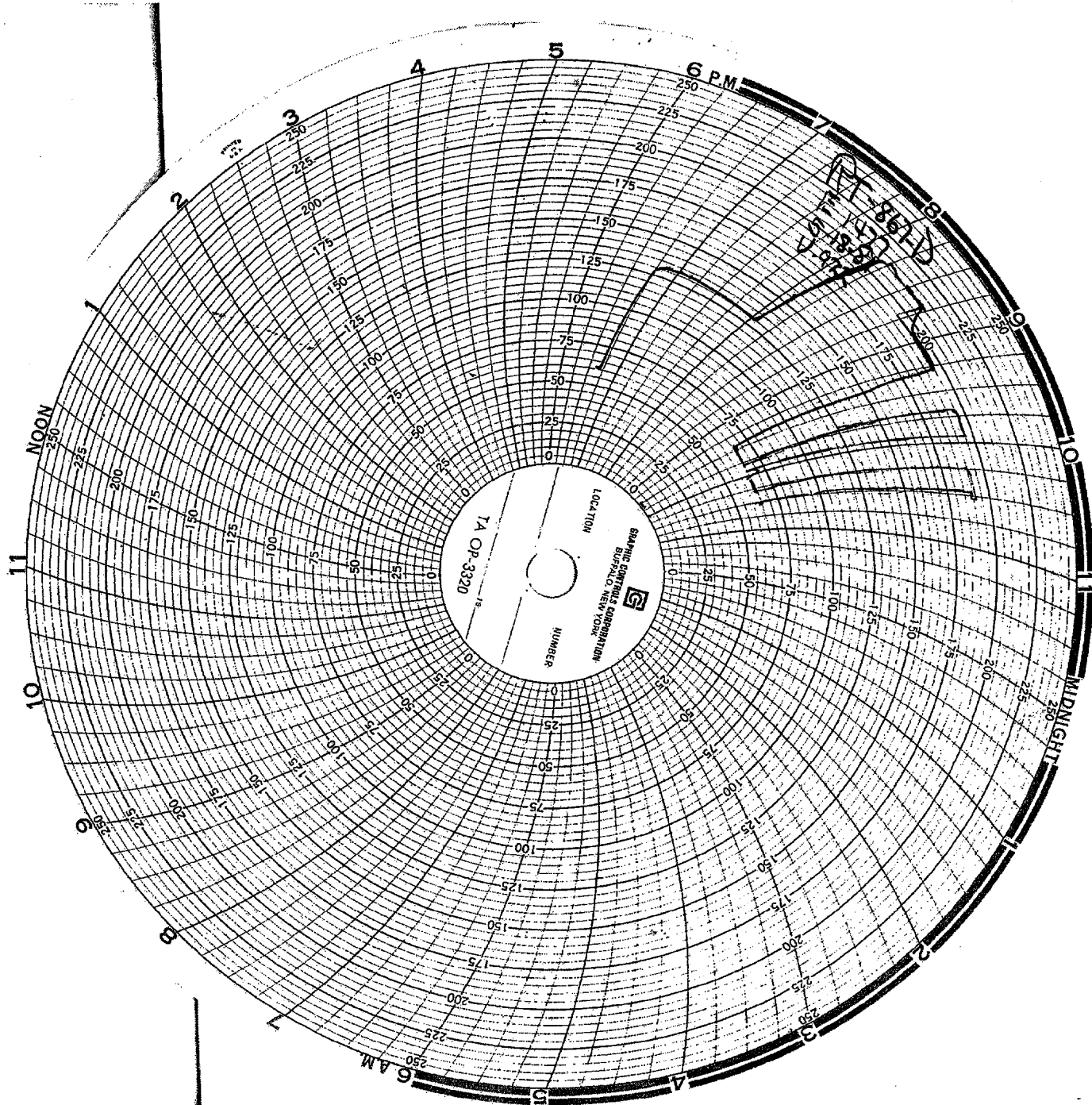
MAKING INSTRUCTIONS: BATCH UNIT

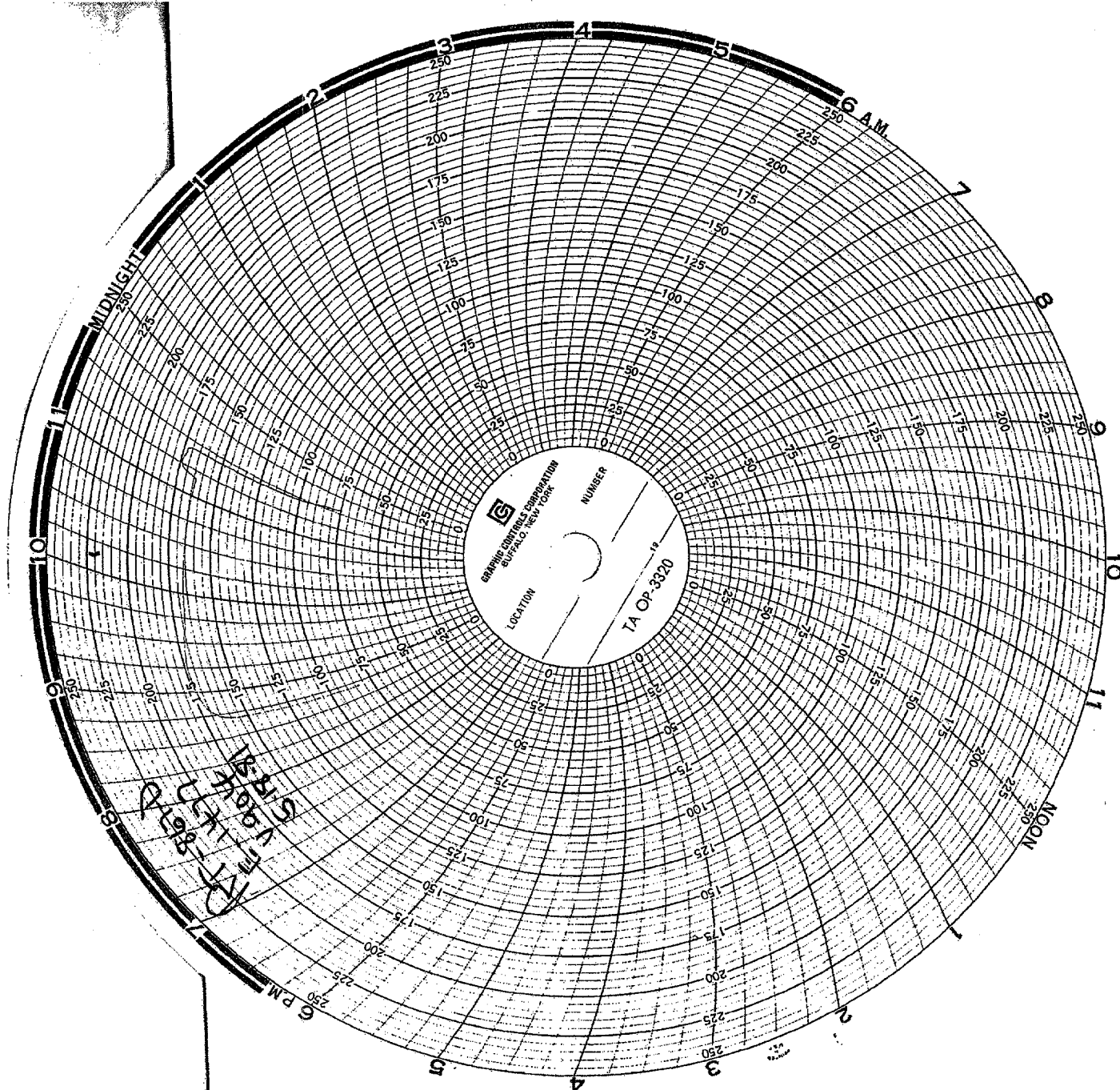
EQUIP MENT		PAGE 2 OF 3 CG 32 CODE RT-867-D (D)	USE LBS	N-CODE	ACCT LBS
CV 3	15 16	RUN 6" (569G) WATER INTO V- MEASURE _____ UNITS IN V-928 & RUN IN M _____ %		28-D	508
904 4	17 18	RUN 2" (58G) INTO V-904 WHEN S13 COMPLETE, PUMP IN V-922 THRU SPARKLER MAINTAIN V-922 AT 190-195 DEG F RECORD: START _____ TOTAL MIN _____			
MISC 5	19 20 21	WEIGH IN PT FOR S33 M _____ % WEIGH IN DRUM FOR S38 M _____ % WEIGH IN DRUM FOR S39 M _____ %		725-A 725-A 725-A	342 30 -30
DV 6	22 23 24	RUN 56" (1566G) WATER INTO V- WEIGH IN V-926 & RUN IN M _____ % DUMP IN FROM S3 _____ LOT		7-D 82-C	495 964
	25	ADJ TO 70-90 DEG F & STIR 10 MIN OR LONGER TO DISSOLVE FOR S39			
922 7	126 127A	WHEN S18 COMPLETE, STOP PUMP & INSERT V-922 FOOT PLUG RUN IN 10" (209G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904 8	127B	PUMP THRU SPARKLER INTO V-904			
922 9	128A	RUN IN 5" (104G) WATER & HEAT TO 190-195 F CIRCULATE 15 MIN THRU SPARKLER			
904 10	128B 29 30	PUMP V-922 THRU SPARKLER INTO V-904 WHEN MT BLOW OUT SPARKLER INTO V-904 HEAT TO 165-170 DEG F			
CV 11	31 32 33 34 35 36 37 38	WHEN S30 COMPLETE, PUMP V-904 AT 165-170 F THRU UNDERSURFACE DISTRIBUTOR INTO CV AFAP (12-15 MIN) RECORD: START _____ TOTAL MIN _____ ADJ TO 43" (4080G) AT 32-38 DEG F RUN IN N-725-A FROM S19 AFAP (5-10 MIN) & STIR 20 MIN AT 32-38 F MAINTAINING +KI M _____ % RECORD: KI _____ (+) DUMP IN DUMP IN ADJ TO 90" (8532G) & ADD TO MAINTAIN CV AT 32-38 DEG F POUR IN N-725-A FROM S20	46X330 714 50 30X330	57-A 57-A 725-A 20-A 65-A 57-A	 714 50

MAKING INSTRUCTIONS: BATCH UNIT

EQUIP MENT		PAGE 3 OF 3 CG 32 CODE RT-867-D (D)	USE LBS	N-CODE	ACCT LBS
DV 12	39 40	POUR N-725-A FROM S21 INTO DV WEIGH IN FROM DRUM	238	122-D	238
CV 13	41 42 43 44	IMMEDIATELY COUPLE DV THRU UNDERSURFACE DISTRIBUTOR INTO CV IN 18-22 MIN. MAINTAIN CV - 32-38 DEG F. RECORD: START _____ TOTAL MIN _____ STIR 30 MIN RECORD: BASE _____ (+) DIAZO _____ (-) PH _____ (9.0-9.8) ADJ TO PH 9.0-9.2 RECORD PH _____ ASSUME 50% M _____ %	•	57-A 7-D 28-D	
PT 14	45 46 47	RUN +/- 70G WATER INTO PT DUMP IN HEAT TO 155-160 DEG F & STIR TO DISSOLVE FOR S48	182	16-B	182
CV 15	48 49 50 51 52 53 54	WHEN S47 COMPLETE, RUN PT INTO CV MEASURE IN CALIBRATED CONTAINER & POUR IN HEAT TO 193-195 DEG F IN 75-80 MIN RECORD: HT _____ DEG F & REC _____ DEG F STIR 60 MIN AT 193-195 DEG F AFTER 20 MIN S52 STIR RECORD: PH _____ (8.2-8.6) WHEN S52 COMPLETE, FLOOD TO 180-190° (+/- 18,000G) & STOP AGITATOR START FIN OPTR _____ _____ _____	35	588-A	35

INSTRUMENT	PAGE 2	CG 32 CODE RT-867-D (D)	EST. WGT. 2250	LBS.	USE LBS.	N CODE	ASCT. LBS.
9021	22	Run 36" (1566 G) water into V-902	M 8	4983	% 1090	7-D	543
6	23	Weigh in V-926 & run in		Lot 6198	1000	82-C	1058
	24	Dump in from S 3		6179	58		
	25	Adj to 20-90°F & stir 10 min or longer to dissolve for S 39					
9022	26	When S 18 complete, stop pump & insert V-922 foot plug					
7	27	Run in 15" (309 G) water & heat to 190-195°F. CIRCULATE 15 min THRU SPARKLER					
904	28	Run in 10" (205 G) WATER IN V-922 & HEAT TO 190-195°F. CIRCULATE 15 min THRU SPARKLER					
8	29	Pump V-922 thru Sparkler into V-904					
	30	When MI blow out Sparkler into V-904					
	31	Heat to 165-170°F					
CV	32	When S 30 complete, pump V-904 at 165-170°F thru under-surface distributor into CV AFAP (12-15 min)					
9	33	Adj to 43" (4080 G) at 32-38°F	Record: Start 1120 Total Min 20		50 X 330	57-A	1650
	34	Run in N-725-A from S 19 AFAP (5-10 min) and				57-A	
	35	Stir 10 min at 32-38°F maintaining +KLM			%	725-A	
	36	Record: KI + (+)					
	37	Dump in			784	20-A	784
	38	Dump in			550	65-A	550
	39	Adj to 90" (8532 G) & add to maintain CV at 32-38°F			33 X 330	57-A	10890
	40	Pour in N-725-A from S 20					
902	41	Pour N-725-A from S 21 into DV			261	122-D	261
10	42	Weigh in from drum					
CV	43	Immediately couple DV thru undersurface distributor into CV in 18-22 min. Maintain CV - 32-38°F				57-A	
11	44	Record: Start 3:30 Total min 30					
	45	Stir 30 min					
	46	Record: Base + (+), Diazo - (-), pH 9.9 (9.0-9.8)					
	47	Adj to pH 9.0-9.2 Record: pH 9.2 Assume 50%				7-D	
		M N. 2 32.00 %			20	28-D	6
PT	48	Run ±70 G water into PT					
12	49	Dump in			200	16-B	200
	50	Heat to 155-160°F & stir to dissolve for S 48					
CV	51	When S 47 complete, run PT into CV					
13	52	Measure in calibrated container & pour in			35	588-A	35
	53	Heat to 193-195°F in 75-80 min					
	54	Record: HT 193 °F & Rec 193 °F					
	55	Stir 60 min at 193-195°F					
	56	After 20 min S 52 stir Record: pH 8.5 (8.2-8.6)					
	57	When S 52 complete, flood to 180-190" (±18,000 G) & stop agitator					
		START 6:50 P.M. - FIN 11:00 P.M. - OPTB 381					
		11:00 P.M. - 6:30 P.M. - 12:30					





$$\begin{array}{r} 94 \\ 30 \\ \hline 64 \end{array}$$

$$\begin{array}{r} 261 \\ 64 \\ \hline 197 \end{array}$$

$$\begin{array}{r} 430 \\ 197 \\ \hline 233 \end{array}$$

$$\begin{array}{r} 330 \\ 5 \\ \hline 1650 \end{array}$$

$$\begin{array}{r} 100 \\ 84 \\ \hline 16 \\ 330 \\ 33 \\ \hline 990 \\ 990 \\ \hline 10890 \end{array}$$

