CG 04 CODE KO-789-D PKG

PROCESSES ( ) KO-789-D (I) COMTYP JOB NAME: 04KO789DMI

APPROVED BY: FWP 11/04/82

11/18/82 (DATE) 12386 (LOT) 5179* (EST WGT) 3Pm

WAREHOUSE REQUEST NO. _____

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC016B	93	_____	_____	100.00	___	50	_____	_____
	01	YC016B	93	_____	_____	100.00	___	50	_____	_____
	01	YC016B	93	_____	_____	100.00	___	50	_____	_____
	01	YC016B	93	_____	_____	100.00	___	50	_____	_____
	01	YC016B	93	_____	_____	100.00	___	50	_____	_____
	__	______	__	______	______	___.__	___	___	_____	_____

EQUIP		NAME : "KROLOR" ORANGE Y NON-BLEEDING	USE LBS	N-CODE	ACCT LBS
		"BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO CHLORIC ACID) IF ANY IS BLANKED OFF."			
211 & 208	1	RUN 60"(990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)	530	32-D	530
	3	DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE) LOT	84X50	YC16B	4200
1		RECORD: START _____ _____ FIN _____ _____			
	4	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD. RECORD PH: _____ (9.0-10.5)			
	5	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208			
	6	WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2800-3200 PSI INTO V-208			
	7	RECORD: V-208 VOL._____" & ADJUST TO 54"(1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 10" (514 G) WATER INTO V-___ , START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START _____ TOTAL MINUTES ____			
2		NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
	11	WHEN V-208 MT, RUN IN 5"(240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349 & 384	12	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	13	RUN 1000# WATER INTO V-384 & HEAT TO 110-120*F			
	14	WEIGH INTO V-384 & PUMP TO V-349	2545	32-D	2545
	15	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17	RECORD DENSITY: _____G/ML (1.082-1.086)			
SV	18	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45"(2300 G)			
	19	RECORD: PH ____ & ADJ TO 11.1-11.3 USING N-7-D (CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	____	7-D	_____
4		SIPHON N-7-D INTO SV & RECORD: PH ____			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC:HT ____*F & RECORD: ____*F. STRIKE MUST START IMMEDIATELY			

Cancelled 11/19/82

EQUIPMENT		PAGE 2 CG 04 KO-789-D	USE LBS	N-CODE	ACCT LBS
	21	WHILE HEATING SV, RUN 52* (1430 G) WATER INTO V-343			
343 & 386 5	22	METER IN (SULFURIC ACID 60%) FROM V-386 M____, ____#/GAL, ____GAL	_____	27-D	390
	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY _____G/ML (1.018-1.020)			
		NOTE: THIS PROCESS CALLS FOR N-27-D ON SURFACE. BE SURE HOSE IS NOT IN UNDERSURFACE STRIKE LINE			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH____			
	26	SET V-343 ACID PUMP AT 65 SETTING (255 MIN)			
	27	SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194*F DURING STRIKE			
SV 6	29	RECORD: START / FINISH / MINUTES			
		V-343 _____ _____ _____			
		V-349 _____ _____ _____			
		TIME V-343 INCHES / V-349 INCHES / SV PH / NORMAL PH			
		AT 20 MIN ____ (49)___ (20)___ ____(9.3-10.0)			
		40 MIN ____ (45)___ (18)___ ____(9.3-10.0)			
		1 HR ____ (41)___ (16)___ ____(9.3-10.0)			
		2 1/4 HR ____ (25)___ (8)___ ____(9.3-10.0)			
		3 1/2 HR ____ (9)___ (0)___ ____(9.3-10.0)			
		FINISH ____ (0)___ ____(7.5-8.5)			
		NOTE: IF PH DROPS BELOW 9.3 IN FIRST HOUR, STOP PUMPS & SEE SUPV. IF FINAL PH IS ABOVE 8.5, ADJ TO 7.5-8.5 & RECORD: ____PH			
		ASSUME 77%	_____	27-D	_____
385 7	30	ADD 67* (514 G) WATER TO V-385			
	31	ADD & STIR 2 MIN	330	7-D	165
SV 8	32	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
	33	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	34	STIR 30 MIN AT 190-194*F, THEN TURN OFF STEAM RECORD: START _____			
	35	RUN IN LIQUID ALUM USING BADGER METER	1060	115-D	530
	36	FLUSH ALM LINE WITH WATER			
	37	RECORD: PH____ (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH____ NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION. ASSUME 50%	_____	115-D	_____
	38	RUN IN N-7-D FROM S31 IN 10-12 MIN & STIR 5 MIN			
	39	RECORD: PH____ (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH____ ASSUME 77%	_____	27-D	_____
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	_____	7-D	_____
		SIPHON N-7-D INTO SV			
	40	POUR IN (PLASTOLEIN 9746A) & STIR 15 MIN	50	978-A	50
	41	STOP AGITATOR			
		START _____ FINISH _____ OPERATOR _____			
		_____ _____ _____			
		_____ _____ _____			

PRODUCT NAME: KROLOR ORANGE Y

NON-BLEEDING

DATE PRINTED: 10/07/82

CG 04 CODE KO-789-D PKG ____

PROCESSES KO-789-D (I)

APPROVED BY: FWP 01/29/82

LOT L2J86

MAKING NOTES _____

EST. WT. 5179* LBS.

JOB NAME: 04KO789DPI

INSTRUCTIONS					= PRESSING =	RECORD				
VAT					PRESSLOAD	1ST	2ND	3RD	4TH	5TH
DATE					STARTED					
TIME					CAKES USED					
RELEASED BY					WATER ON					
PRESS	22	23	24	25	93	HRS. WASHED					
NO.OF CAKES	40	40	48	48		M MHOS					
PRESS WITH AGITATION						HRS. WASHED					
WASH TO 200 M MHOS WITH 35-75* WATER						M MHOS					
TEST AFTER 6 HOURS						HRS. WASHED					
LOAD ON 5 CARS						M MHOS					
						CAKE CONDITION					
						NO CARS LOADED					
						EXPLAIN LOSSES					
SAMPLES						SAMPLED BY					
DELIVER TO						RELEASED BY					

= DRYING =

DRY 18 HOURS AT 220 DEG F	LUMP: - OK - WET - SALTS - CONTAMINATD
	ADDITIONAL DRYING HOURS REQUIRED
SAMPLES	NO CARS PULLED NO DRUMS
DELIVER TO	LUMP WGT
	SAMPLED BY
	RELEASED BY

= GRINDING =

MILL 938 HSP 3/32" SCREEN 3500 RPM	SCREEN RPM
MAX. TEMP 210 DEG F	MAX. TEMP. F
SAMPLE W/O MIXING 1 ENV & 2 PT CANS	EXPLAIN LOSSES
IF PACKED IN BAGS SAMPLE AS FOLLOWS:	
FIRST BAG: 1 ENV.	DATE MIXED
40TH BAG: 1 ENV. & 2 PINT CANS	
LAST BAG: 1 ENV.	SAMPLED BY
DELIVER TO CTL	RELEASED BY

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