

CG 04 CODE KO-909-D PKG

NOV 11 80 37807
EST'D WGT 1596 LBS

STANDARD HRS.

TIME 11A M

PROCESSES

() KO-909-D (C)

APPROVED BY

FWP 11/3/80

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TYPED BY: FWP 11/3/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	36039	1150
01	YC016B	93	37371	2450
01	YC016B	93	37336	300

NOV 13 1980

3900

PUNCHED AS YOU GO ALONG
CLEAN UP

TOTAL EST'D WGT 5296

REQ. NO. (1107 2788)

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED			
208	2 WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MINS.	480	983-D	480
1	RECORD: START 6:20 PM LOT 36039	78 2450	YC16B	3700
	FIN 8:00 PM 37371	2450		3900
	ADJUST TO 75" (1275 G) 37336	300		
	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208			
	WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2800-3200 PSI INTO V-208			
	RECORD: V-208 VOL. 42" & ADJUST TO 54" (1890G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 G) WATER INTO V-247, START			
SV	10 AGITATOR & INSTALL TEMP CHART			
2	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 9:00 PM TOTAL MINUTES 150			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3 WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
	WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
384	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F	2500	983-D	2500
	WEIGH INTO V-384 & PUMP TO V-349 2000			3000
	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	RECORD DENSITY: 1.077 G/ML (1.077-1.077)	50	983	50
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
	RECORD: PH 10.6 & ADJ TO 11.1-11.3 USING N-7-D			
4	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	14	7-D	7
	SIPHON N-7-D INTO SV & RECORD: PH 16.1			
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 192°F			
	& RECORD: 192°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

V-247

343	21	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343				
386	22	METER IN FROM V-386	40.7	9.156	40.7	40.7
5	23	STIR 15 MIN OR LONGER				27-D
	24	RECORD: DENSITY 1.020 G/ML (1.018-1.020)				373

SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9				
	26	SET V-343 ACID PUMP AT 69 SETTING (225 MIN)				
	27	SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)				
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE				

29	RECORD:	START	FINISH	MINUTES		
	V-343	2:30A	6:30A	240		
	V-349	2:30A	5:30A	180		
	TIME	V-343	V-349	SV	NORMAL	
		INCHES	INCHES	PH	PH	
	AT 20 MIN	2:50A (46)	(17)	9.7	(9.3-10.0)	
	40 MIN	3:10A (41)	(15)	9.7	(9.3-10.0)	
	1 HR	3:30A (37)	(13)	9.6	(9.3-10.0)	
	2 HRS	3:50A (23)	(6)	9.3	(9.3-10.0)	
	3 HRS	5:30A (10)	(0)	9.4	(9.3-10.0)	
	FINISH	6:15A (0)		7.3	(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%

30	SIFT IN					27-D
						50

385	31	RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140°F				
7	32	DUMP IN & STIR TO DISSOLVE FOR S-61	477		15-A	477

302	33	ADD 38" (465 G) WATER TO V-302				
8	34	ADD & STIR FOR 2 MIN FOR S 64	ASSUME 50%	296	7-D	148

PT	35	DURING STRIKE PUMP INTO PT	482		169-A	482
9	36	PUMP IN	54		155-A	54
	37	PUMP IN	54		160-A	54
	38	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42				

356	39	DURING STRIKE RUN 15" (268 G) WATER INTO V-356				
10	40	TURN ON STEAM				
	41	ADJ TO 21" (366 G) AT 81-82°C				
	42	PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE				
	43	RINSE PT WITH HOT WATER FROM HOT WATER MIXER & PUMP IN				
	44	SHUT OFF PUMP				
	45	STIR 30 MIN AT 81-82°C FOR S 55				
	46	DO NOT SHUT OFF AGITATOR				

V-247

SV 147 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
 SET PUMP AT ZERO SETTING
 11 148 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
 TURN OFF PUMP MOTOR
 149 STIR 60 MIN AT 190-194°F
 150 HEAT TO 198-200°F IN 5-10 MIN
 151 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
 PUMP
 152 OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP
 INLET
 153 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
 THRU HOMOG AT 2900-3100 PSI TO SEWER
 154 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE
 TO SV & CLOSE VALVE TO SEWER
 155 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
 TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100
 PSI. MAINTAIN SV AT 198-200°F.
 156 WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE
 AT STEARATE PUMP ASAP
 157 WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT
 WATER FROM HOT WATER MIXER
 158 TURN OFF HOMOG & STEARATE PUMP
 159 STIR 5 MIN AT 198-200°F
 160 SHUT OFF STEAM
 161 RUN IN V-385 FROM S-32 & STIR 5 MIN
 162 RECORD: PH 3.4 (3.4-3.8)
 163 IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY)
 & RECORD: PH
 164 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
 165 RECORD: PH 4.5 (6.2-6.4) & IF NECESSARY, ADJ
 TO PH 6.2-6.4 & RECORD: PH 6.3 ASSUME 78%
 (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%
 SIPHON N-7-D INTO SV
 166 DO NOT STOP AGITATOR

27-D
 721-D

9:00 PM 11:00 PM 381-201
 11:00 P 7:00 A 126-209
 7:00 AM 11:35 AM 322

WAREHOUSE REQUEST FORM

REQUEST NO. 3602
11/07/80

DELIVER TO MAKING AREA BY 11/11/80 11 AM/PM

FOR: CG 04 CODE KD909D LOT 37807, SCHEDULED 11/07/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
35-B2	01	YC016B	93	36039	1150		23	50	1150	-----
35,B10	01	YC016B	93	37371	2450		49	50	2450	-----
35,B10	01	YC016B	93	37334	300		6	50	300	-----

PICK UP AND RETURN TO STORAGE:

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT
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EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE ____/____/____

COPY-1 PROD. CONTROL
COPY-2 MANUFACTURING
COPY-3 WAREHOUSE
COPY-4 RAW MATERIAL

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35-B10	01	YC016B	93	37371	2450		49	50	2450	-----
35-B10	01	YC016B	93	37338	300		6	50	300	-----

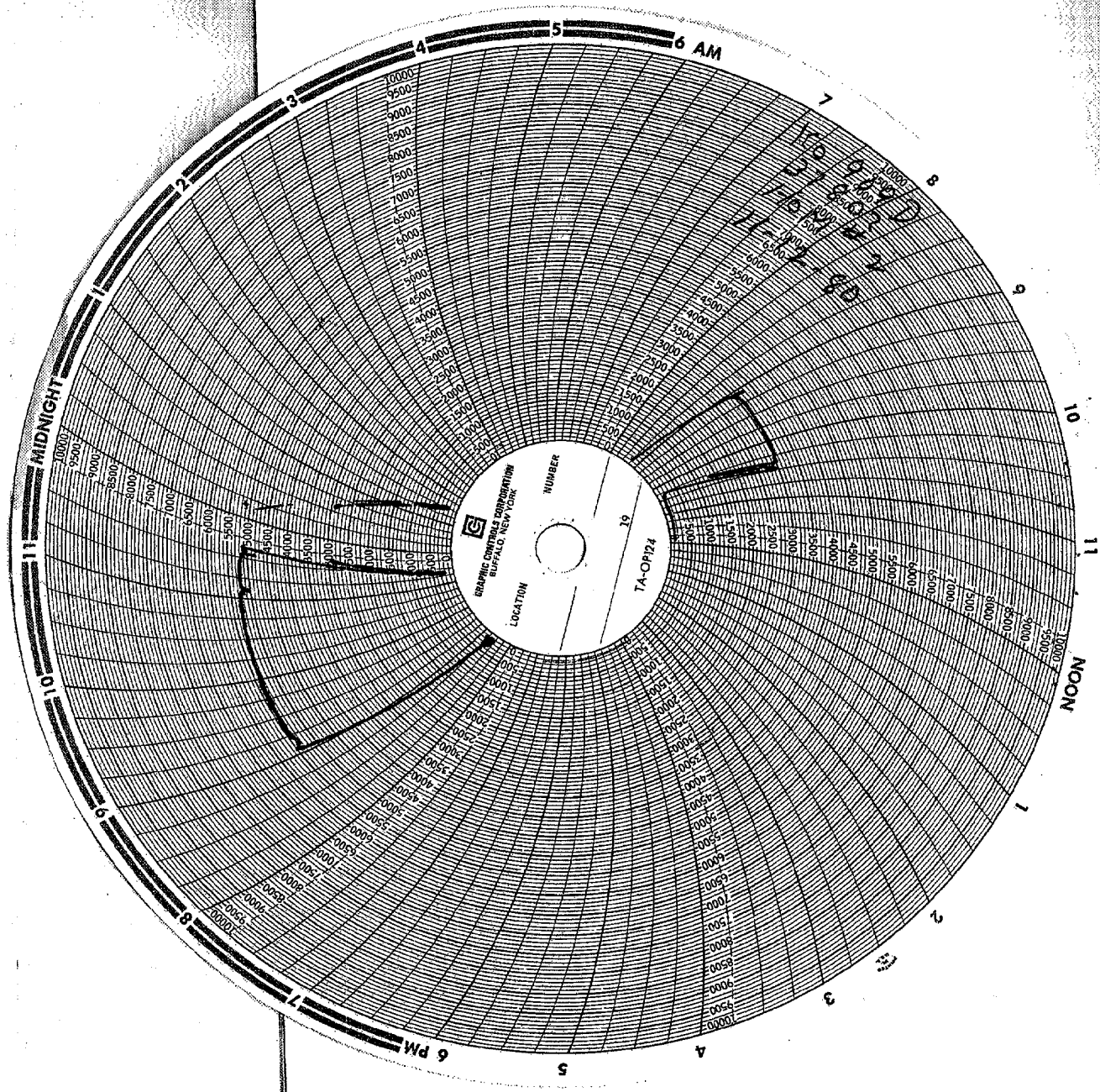
PICK UP AND RETURN TO STORAGE:

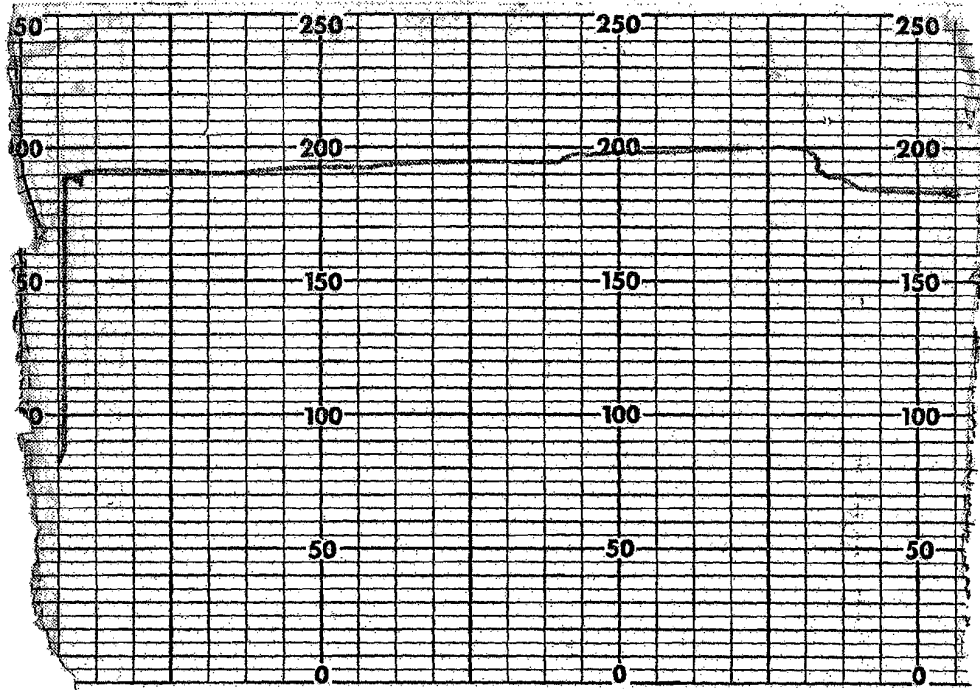
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- COPY-1 PROD. CONTROL
- COPY-2 MANUFACTURING
- COPY-3 WAREHOUSE
- COPY-4 RAW MATERIAL





GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

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