

CG 04 CODE KO-789-D PKG

OCT-24 80 37602
EST'D WGT 1032 LBS

PROCESSES

() KO-789-D (I)

APPROVED BY

FWF 9/18/80

STANDARD HRS. 10.8 TIME 7A M

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TYPED BY: FWF 9/18/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	36119	2050
01	YC016B	93	36344	2150
01	YC016B	93		

CLEAN UP

AS YOU GO ALONG

TOTAL EST'D WGT 5232

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KRODOR" ORANGE Y	USE LBS	NCOE	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	530	32-D	530
	3 DUMP IN AND STIR 5 MIN. LOT	84X50	YC16B	4200
	RECORD: START <u>8:00</u>	<u>41</u>		
1	FIN <u>10:00</u>	<u>36119</u>		
		<u>36344</u>		
	4 ADJUST TO 75" (1275 G)			
	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 <u>56</u> & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	1 RUN 10" (514 G) WATER INTO V- <u>217</u> , START			
	AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START <u>7:40A</u> TOTAL MINUTES <u>120</u>			
2	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			
	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	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: <u>1.085</u> (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19 RECORD: PH <u>10.2</u> & ADJ TO 11.1-11.3 USING N-7-D			
4	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	<u>10</u>	<u>724</u>	<u>10</u>
	SIPHON N-7-D INTO SV & RECORD: PH <u>11.3</u>			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT <u>190</u> °F			
	& RECORD: <u>190</u> °F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

V-247

343	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343			
&	22	METER IN FROM V-386 M 8.97 #/GAL, 13.7 GAL	27-D	390	
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1.020 G/ML (1.018-1.020)			

SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.2			
	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			
	29	RECORD: START FINISH MINUTES			
		V-343 12:00 4:20 PM 310			
		V-349 12:00 3:45 PM 225			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 12:20 (49) (20) 9.9 (9.3-10.0)			
		40 MIN 12:40 (45) 44 (18) 17 9.9 (9.3-10.0)			
		1 HR 1:00 (41) (16) 9.9 (9.3-10.0)			
		2 1/4 HR 2:15 (25) (8) 9.8 (9.3-10.0)			
		3 1/2 HR 3:30 (9) 12 (0) 2 9.8 (9.3-10.0)			
		FINISH 4:15 (0) 2 6.8 (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	30	RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140°F			
7	31	DUMP IN & STIR TO DISSOLVE	530	15-A	530

302	32	ADD 42" (514 G) WATER TO V-302	165	N-721-0	
8	33	ADD & STIR 2 MIN	165		

SV	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
9	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	36	STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM			
		RECORD: START 4:20 PM			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.0 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH	15-A		
		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140°F IN DRUM, USE 30 GAL WATER TO 50# N-15-A. STIR SV 5 MIN AFTER EACH ADDITION			
	39	RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN			
	40	RECORD: PH 5.4 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH 6.4	27-D		
		DELUCE N-7-D 10 TO 1 WITH WATER ASSUME 77%	50		50
		SIPHON N-7-D INTO SV ASSUME 50%	50	721-D	50
	41	POUR IN STIR 15 MIN	50	978-A	50
	42	STOP AGITATOR			

START	FINISH	OPERATOR
7:00 A	3:00 P	259-301
4:00 PM	4:45 PM	37-244

WAREHOUSE REQUEST FORM

REQUEST NO. 3584
10/23/80DELIVER TO MAKING AREA BY 102480 7 AM/PM

FOR: CG 04 CODE KD789D LOT 37602 SCHEDULED 10/22/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
35BLD	01	YC016B	93	36119	2050		41	50	2050	
BAY 2	01	YC016B	93	36344	2150		43	50	2150	

PICK UP AND RETURN TO STORAGE:

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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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