

CG 04 CODE KD-789-D PKG 38074

PROCESSES

APPROVED BY

EST'D WGT 1032 LBS

() KD-789-D (I)

FWP 11/3/80

STANDARD HRS. 10.8 TIME 9A M

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TYPED BY: FWP 11/3/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	37623	2750
01	YC016B	93	37621	1450
01	YC016B	93		

TOTAL EST'D WGT 5232

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE K: 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	540	983-D	540
	3 DUMP IN AND STIR 5 MIN LOT	84X50	YC16B	4200
	RECORD: START 11:00			
	FIN 11:30			
	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. 42" & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 G) WATER INTO V-247 START			
	AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 11:00 AM TAIL MINUTES 1:50			
	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	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	983-D	2545
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349	2600		2600
	3 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.086 G/ML (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19 RECORD: PH 10.75 ADJ TO 11.1-11.3 USING N-7-D			
4	AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	28	7-D	14
	SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT ____°F & RECORD: ____°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34647

V-247

343 21 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO
& 22 V-343
386 23 METER IN FROM V-386 M 6.9, 1.13 GAL 11.3 GAL 27-D 390
5 24 STIR 15 MIN OR LONGER
RECORD: DENSITY 1.020 G/ML (1.018-1.020)

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

SV AT 190-194°F DURING STRIKE

RECORD:	START	FINISH	MINUTES
V-343	3:25 PM	8:40 PM	275
V-349	3:25 PM	7:10	225
TIME	V-343	V-349	SV
	INCHES	INCHES	NORMAL
AT 20 MIN	3.45 (49)	(20)	10.0 (9.3-10.0)
40 MIN	4.25 (45)	(18)	9.7 (9.3-10.0)
1 HR	4.25 (41)	(16)	9.8 (9.3-10.0)
2 1/4 HR	3.40 (25)	(8)	9.7 (9.3-10.0)
3 1/2 HR	6.55 (9)	(0)	9.5 (9.3-10.0)
FINISH	7.40 (0)	4	6.7 (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
7 135-140°F

31 DUMP IN & STIR TO DISSOLVE

530

15-A

530

302 32 ADD 42" (514 G) WATER TO V-302

8 33 ADD & STIR 2 MIN

330

7-D

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 8:10 PM

37 RUN IN V-385 FROM S 31 & STIR 5 MIN

38 RECORD: PH 3.2 (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 6.4 (6.2-6.4) & IF NECESSARY ADJ TO
PH 6.2-6.4. RECORD: PH 6.3

ASSUME 77%

27-D

DILUTE N-7-D 10 TO 1 WITH WATER

ASSUME 50%

30

7-D

41 SIPHON N-7-D INTO SV

42 POUR IN STIR 15 MIN

150

978-A

50

43 STOP AGITATOR

START

FINISH

OPERATOR

2:00 AM
3:00 PM3:00 PM
7:45 PM237-235
342

WAREHOUSE REQUEST FORM

REQUEST NO. 3625
11/25/80

DELIVER TO Making AREA BY 12/1/80 AM/PM

FOR: CG 04 CODE K0789D LOT 38074 SCHEDULED 11/24/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
BAY 2	01	YC016B	93	37623	2750		55	50	2750	-----
35B-3	01	YC016B	93	37621	1450		29	50	1450	-----

PICK UP AND RETURN TO STORAGE:

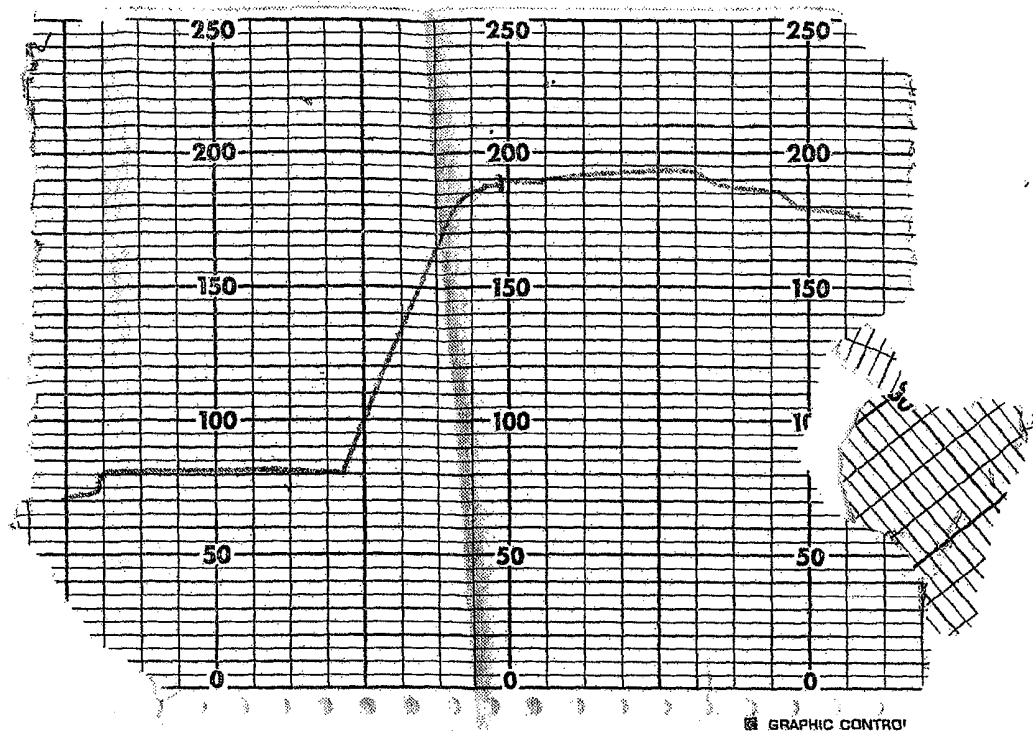
LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT
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11-26-80
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EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE ____/____/____

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



GRAPHIC CONTROL

