CG 04 CODE KO-906-D PKG 012 HP PROCESSES APPROVED BY
SEP 28 1982 K2K28 5008* TIME 3 P.M. ( ) KO-906-D (C) FWP 06/14/82
(DATE) (LOT) (EST WT) COMTYP JOB NAME: 04KO906DMC

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC-10	93	H2K55 90	3700	100.00	74	50	3700	3700
	01	YC-10	93							
	01	YC-10	93							

WAREHOUSE REQUEST NO. 109

EQUIPMENT		NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
		"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
211 & 208 1	1	RUN 60"(990 G) WATER IN V-211 & ADD ASSUME 50% SET AGITATOR ON HIGH SPEED.	26	7-D	13
	2	WEIGH IN DRUM AND POUR IN	245	32-D	245
	3	DUMP IN AND STIR 5 MINS. LOT	74X50	YC10B	3700
		RECORD: START 3:00 PM H2K55	3700		
		FIN 5:00 PM			
	4	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	5	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208			
	6	WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 1800-2200 PSI INTO V-208			
	7	RECORD: V-208 VOL. 41" & ADJUST TO 45"(1662G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV 2	9	RUN 15" (793 G) WATER INTO V-208 & START AGITATOR & INSTALL TEMP CHART 246			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 5:30 TOTAL MINUTES 75			
	11	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 3	12	WHILE HOMOG, RUN 5" (237 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	2165	32-D	2165
	15	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	16	ADJ V-349 TO 20" (946 G) & STIR 15 MIN			
	17	RECORD DENSITY: 1.080 G/ML (1.078-1.081)			
SV 4	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60"(3084 G)			
	19	RECORD: PH 10.1 & ADJ TO 10.4-10.8 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	20	7-D	10
	20	SIPHON N-7-D INTO SV & RECORD: PH 10.8			
		HEAT TO 190-194*F IN 55-65 MIN & REC: HT 194 *F & RECORD: 192 *F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

EC

LOT= _____ _ COMTYP JOB NAME = 04KO906DMC PAGE 02 DATE PRINTED: 6/15/82

PAGE 2 CG 04 KO-906-D PROC- "C" V-246

EQUIPMENT			USE LBS	N-CODE	USE LBS
343 & 386 5	21 22 23 24	WHILE HEATING SV RUN 46* (126SC) WTR INTO V-343 METER IN FROM V-386 M 24 1068¾/GAL 3010 GAL STIR 15 MIN OR LONGER RECORD: DENSITY 1.019 G/ML (1.018-1.020)		27-D	320
SV 6	25 26 27 28 29	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.8 SET V-343 ACID PUMP AT (65) SETTING (225 MIN) SET V-349 SILICATE PUMP AT (57) SETTING (180 MIN) IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194*F DURING STRIKE RECORD: START FINISH MINUTES V-343 8:30 12:30 270 V-349 8 AM 11:30 180 TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH AT 20 MIN 8:50 (43) ___ (18) ___ 9.4 (9.3-10.0) 40 MIN 9:10 (39) ___ (16) ___ 9.7 (9.3-10.0) 1 HR 9:35 (35) 39 (13) 13 9.6 (9.3-10.0) 2 HRS 10:30 (22) 27 (7) 7 9.6 (9.3-10.0) 3 HRS 11:30 (10) 12 (0) ___ 9.6 (9.3-10.0) FINISH 12:15 (0) 5 7.2 (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	
	30	SIFT IN	55	128-A	55
385 7	34 35	ADD 38* (295 G) WATER TO V-385 ADD & STIR FOR 2 MIN FOR S 62 ASSUME 50%	136	7-D	68
387 8	32 34 35 36	DURING STRIKE CHECK LEVEL IN V-387. IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW STEARATE MAKE-UP PROCEDURE.			
388 9	37 38 39 40 41 42 43 44	RUN IN 27* (268 GAL). DO NOT MAKE UP THIS SOLUTION MORE THAN 30 MINUTES IN ADVANCE. DELAY BETWEEN END OF STEP 43 HEAT-UP AND START OF STEP 52 HOMOGENIZATION SHOULD BE LESS THAN 30 MINUTES. TURN ON STEAM & AGITATOR ADJUST TO 37* (366 GAL) AT 178-182*F SET BADGER METER FOR (572±) PUMP IN FROM V-387 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE SHUT OFF PUMP STIR 30 MIN AT 178-182*F FOR S 52 DO NOT SHUT OFF AGITATOR	468 52 52	169-A 155-A 160-A	468 52 52
SV 10	45 46	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING. WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR.			

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EQUIP MENT	PAGE 3 CG 04 KO-906-D PROC-"C" COMTYP JOB NAME: 04KO906DMC	USE LBS	N- CODE	USE LBS
	47 HEAT TO 198-200*F IN 5-10 MIN			
SV	48 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE			
10	PUMP			
CONT	49 OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP			
	INLET			
	50 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER			
	THRU HOMOG AT 2900-3100 PSI TO SEWER			
	51 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE			
	TO SV & CLOSE VALVE TO SEWER			
	52 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,			
	TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100			
	PSI. MAINTAIN SV AT 198-200*F.			
	53 WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE			
	AT STEARATE PUMP ASAP			
	54 WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT			
	WATER FROM HOT WATER MIXER			
	55 TURN OFF HOMOG & STEARATE PUMP			
	56 STIR 5 MIN AT 198-200*F			
	57 SHUT OFF STEAM			
	58 RUN IN ALUM USING BADGER METER	540	115-D	270
	59 FLUSH ALUM LINE WITH WATER			
	60 RECORD: PH 3.5 (3.3-3.7)			
	61 IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY)			
	& RECORD: PH____.			
	NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA			
	BADGER METER. STIR 5 MIN AFTER EACH			
	ADDITION. ASSUME 50%	_____	115-D	_____
	62 RUN IN N-7-D FROM S32 IN 4-6 MIN & STIR 5 MIN			
	63 RECORD: PH 4.0 (4.0-4.2) & IF NECESSARY, ADJ			
	TO PH 4.0-4.2 & RECORD: PH____. ASSUME 78%	_____	27-D	_____
	(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	_____	7-D	_____
	SIPHON N-7-D INTO SV			
	64 DO NOT STOP AGITATOR			

5:00 PM 11:00 PM 320
7:00 AM 2:15 PM 409-438

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WAREHOUSE REQUEST FORM

REQUEST NO. 10980
9/24/82

DELIVER TO Making Area BY 9/28/82 3PM

FOR: CG 04 CODE K0906D LOT K2H28 SCHEDULED 9/28/82

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
BAY 2	01	YC010B	93	H2K55	3700		74	50	3700	_____

PICK UP AND RETURN TO STORAGE:

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT
_____	__	_____	__	_____	_____	__.__	___	___	_____
_____	__	_____	__	_____	_____	__.__	___	___	_____

EXPLANATION FOR SHORTAGE/OVERAGE:

_____

_____

_____

SIGNED _____ DATE __/__/__

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

DUP050103620

WAREHOUSE REQUEST FORM

REQUEST NO. 10980
9/24/82

DELIVER TO Making Area BY 9/28/82 3PM

FOR CG 04 CODE K0906D LOT K2H28 SCHEDULED 9/28/82

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
BAY 2	01	YC010B	93	H2K5[illegible]	3700		74	50	3700	_____

PICK UP AND RETURN TO STORAGE:

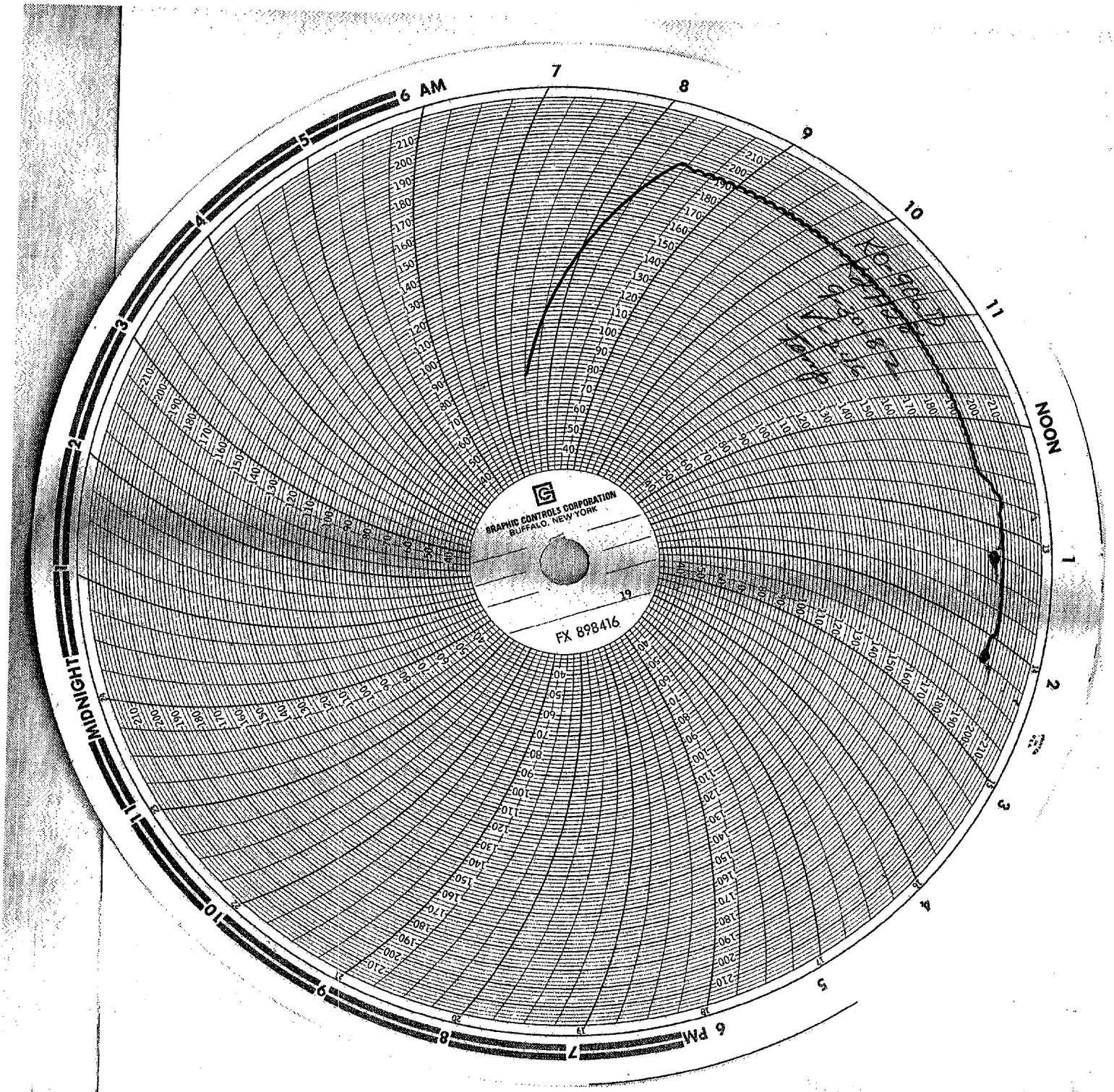
LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT

EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE __/__/__

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

DUP050103621



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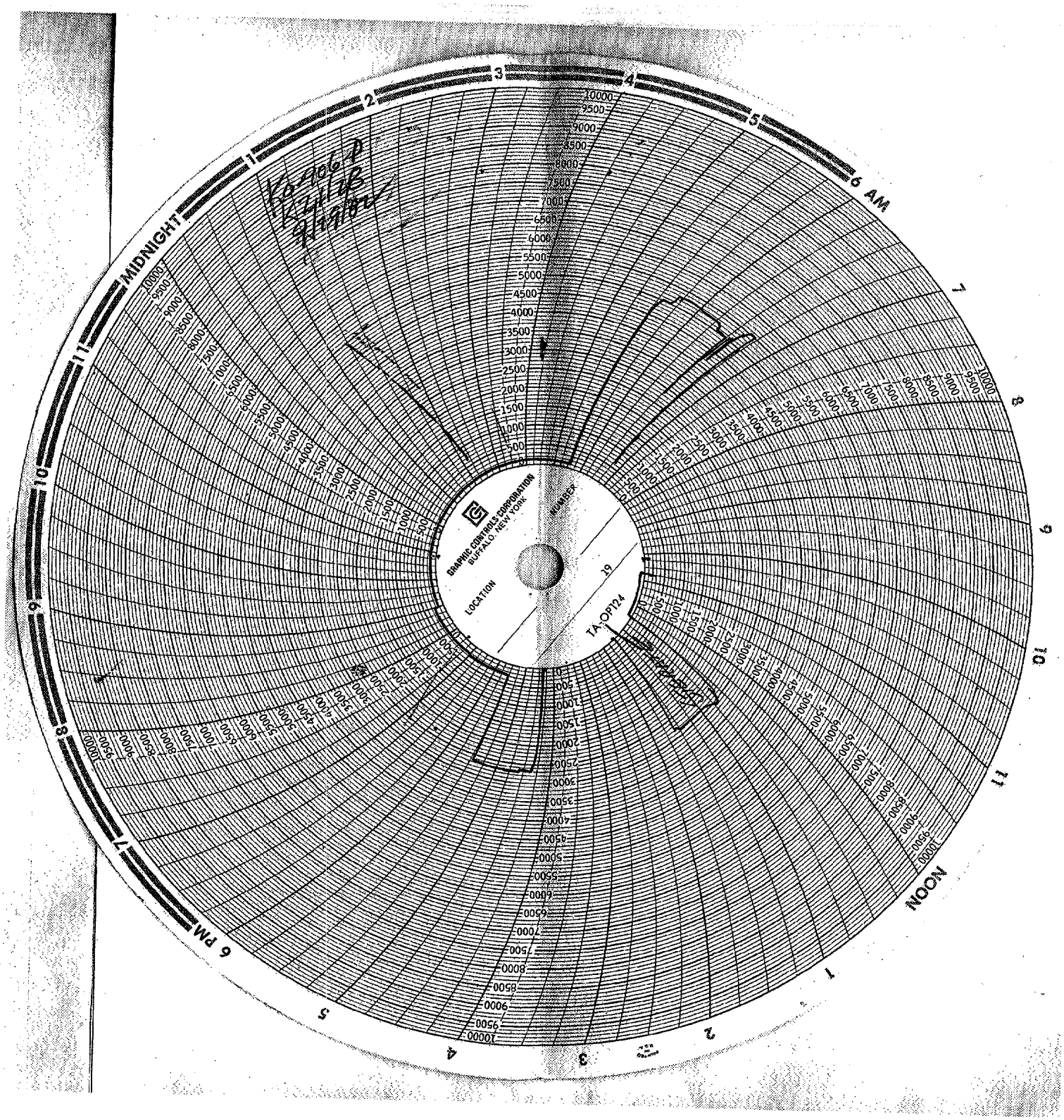

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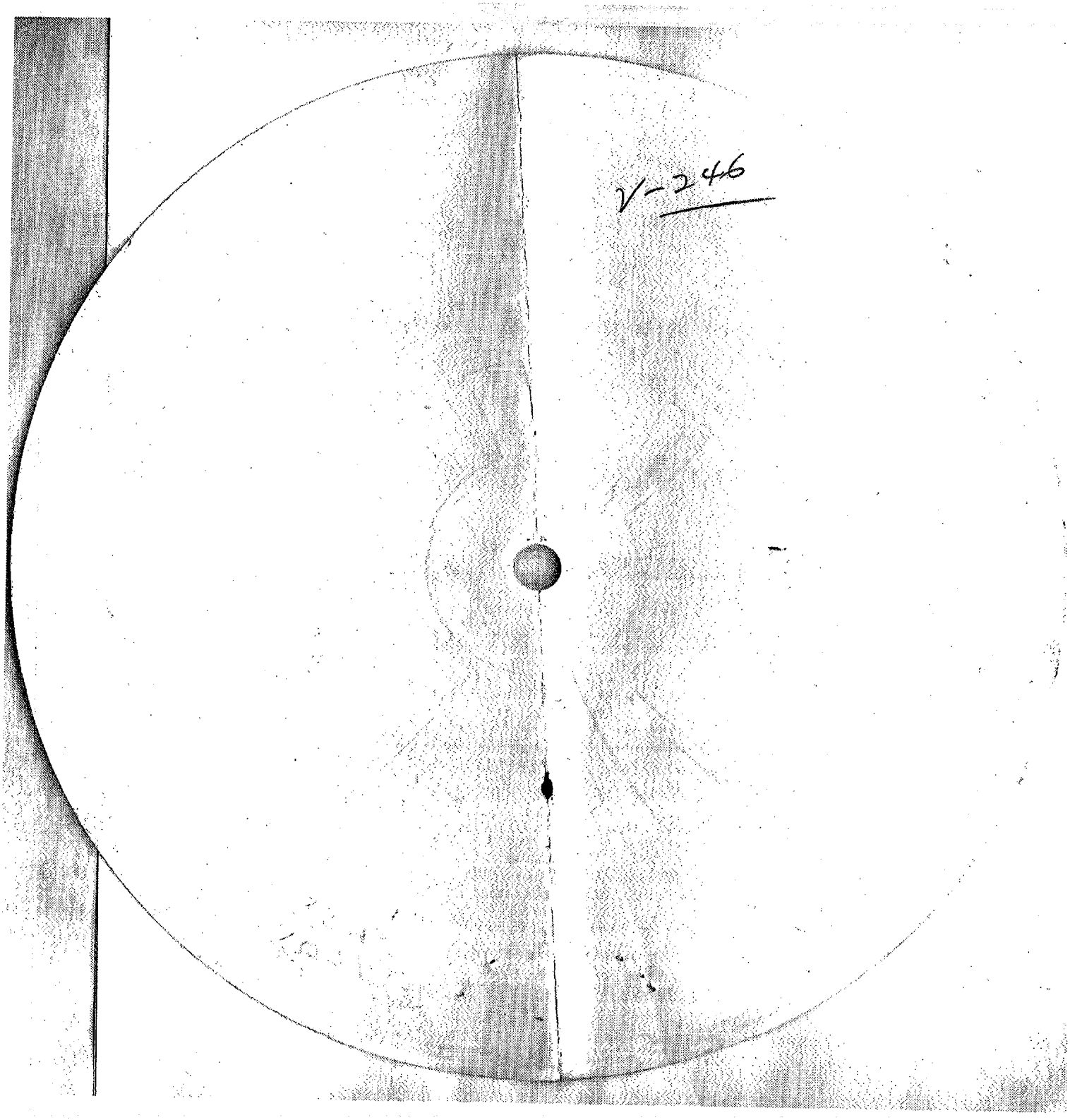
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