

JUN 23 1982

F2K95

5084*

(DATE)

(LOT)

(EST WGT)

COMTYP JOB NAME: 04KO786DMQ

(CONTAINS RE-WORK)

TIME: 7:00 A.M., STANDARD HRS. 10.5

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG.	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	==	=====	==	=====	=====	=====	=====	=====	=====	=====
	04	K0786D	98	84960-1	200	100	4	50	200	200
	01	YC-10	93	E2J45	4100	100	82	50	4100	4100
	01	YC-10	93							

WAREHOUSE REQUISITION NO. 10860

NON-BLEEDING

EQUIP MENT	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	1 RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15
208	2 WEIGH IN DRUM AND POUR IN 3 DUMP IN AND STIR 5 MIN	270	32-D	270
	RECORD: START	82X50	YC10B	4100
	FIN	4X50	K0786D	200
	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 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208			
	7 RECORD: V-208 VOL. 48" & ADJUST TO 50" (1840G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 15" (771 G) WATER INTO V-246 START & AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 1250 P TOTAL MINUTES 140			
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	2400	32-D	2400
	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: 1.081 G/ML (1.078-1.081)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)			

JUL 26 1982

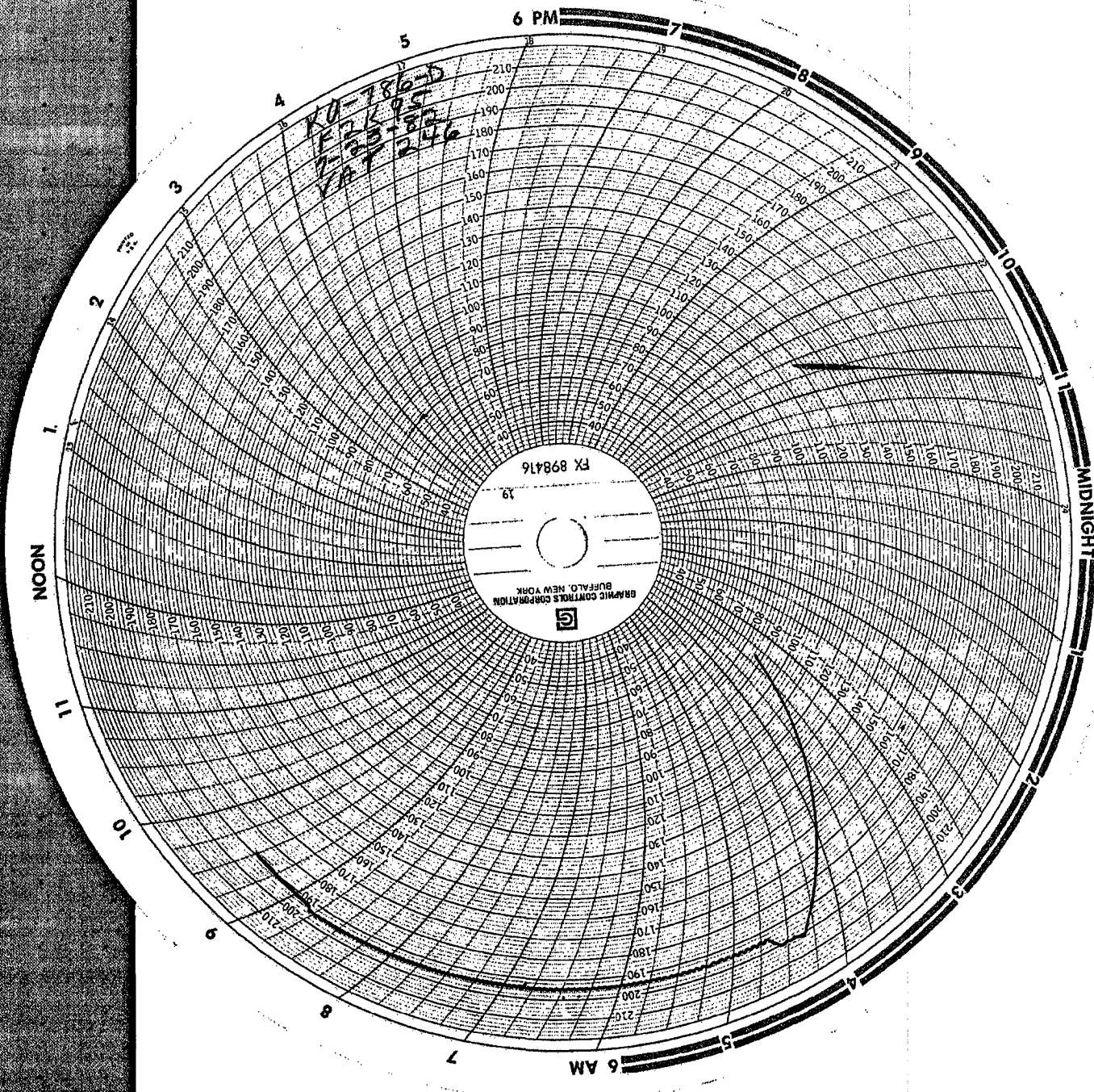
N38028

4 18 RECORD: PH 9.2 & ADJ TO 10.4-10.8 USING N-7-D
 DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)
 ASSUME 50% 6 7-D 3
 SIPHON N-7-D INTO SV & RECORD: PH 10.6
 20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT _____*F
 & RECORD: _____*F
 343 21 WHILE HEATING SV, RUN 51" (1400 G) WATER INTO
 V-343
 & 22 METER IN FROM V-386 M 19 10896/GAL 32.6 GAL
 386 23 STIR 15 MIN OR LONGER
 5 24 RECORD: DENSITY 1.018 G/ML (1.018-1.020)

SV 25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0
 6 26 SET V-343 ACID PUMP AT 72 SETTING (225 MIN)
 27 SET V-349 SILICATE PUMP AT 66 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 4:30 8:05 235
 V-349 4:30 7:20 180
 TIME V-343 V-349 SV NORMAL
 INCHES INCHES PH PH
 AT 20 MIN 4:50 (47) (20) 10.0 (9.3-10.0)
 40 MIN 5:10 (43) (17) 10.0 (9.3-10.0)
 1 HR 5:36 (38) (15) 9.9 (9.3-10.0)
 2 HR 6:30 (24) (7) 9.9 (9.3-10.0)
 3 HR 7:30 (10) (0) 10.0 (9.3-10.0)
 FINISH 8:15 (0) 2.5 (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 ADD 67" (514 G) WATER TO V-385
 7 31 ADD & STIR 2 MIN 150 7-D 75
 SV 32 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
 SET PUMP AT ZERO SETTING
 8 33 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
 TURN OFF PUMP MOTOR
 34 TURN OFF STEAM
 35 RUN IN ALUM USING BADGER METER 600 115-A 300
 36 FLUSH ALUM LINE WITH WATER.
 37 RECORD: PH 2.9 (3.3-3.7) & IF NECESSARY ADJ
 (DOWN ONLY) TO 3.3-3.7 & RECORD: PH _____
 NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA
 BADGER METER. STIR 5 MIN AFTER EACH
 ADDITION. ASSUME 50% 115-A
 38 RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN
 39 RECORD: PH 3.3 (4.0-4.2) & IF NECESSARY ADJ TO
 PH 4.0-4.2. RECORD: PH 4.0 ASSUME 77%
 DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 90 27-D
 SIPHON N-7-D INTO SV 7-D 45
 40 STOP AGITATOR

START 9:PM FINISH 11:PM OPERATOR 54



MD-3-A

PACKAGE TICKET

CODE

K0-786

LOT

F2K95

PO

NET WT/PKG.

NO. PKG.

PACK WT

LOCATION

2430

1

1

244

2600

1

1

180

STUMP

TOTAL NET WT.

5030

LUMP WT.

4910

PKG. N-CODE

PROD. SUPV.

DATE

OPERATOR

1/1/82

7/27/82

PRODUCT NAME = KROLOR ORANGE R

CG 04 CODE KO-786-D PKG

LOT F2K95

EST. WT. 5084* LBS.

JUN 23 1982

OK
HP

DATE PRINTED: 1/11/82

NON-BLEEDING

PROCESSES APPROVED BY
KO-786-D (P) FWP 11/05/81

TYPED BY JMH

MAKING NOTES

JOB NAME: 04K0786DPP

INSTRUCTIONS

= PRESSING =

RECORD

VAT	DATE	TIME	RELEASED BY	PRESS	NO. OF CAKES	PRESS WITH AGITATION	WASH TO 200 M MHOS-	TEST AFTER 6 HOURS	LOAD ON 6 CARS	PRESSLOAD	STARTED	CAKES USED	WATER ON	HRS. WASHED	M MHOS	HRS. WASHED	M MHOS	HRS. WASHED	M MHOS	CAKE CONDITION	NO CARS LOADED	EXPLAIN LOSSES
046	12-24	12:30	AG	22	23	24	(25)	93	48	54	10AM	50	1:30PM	6	120							

SAMPLES
DELIVER TO

SAMPLED BY
RELEASED BY

= DRYING =

DRY 16 HOURS AT 220* F

LUMP: - OK - WET - SALTS - CONTAMINATD

ADDITIONAL DRYING HOURS REQUIRED

SAMPLES
DELIVER TO

NO CARS PULLED
SAMPLED BY
RELEASED BY

NO DRUMS
LUMP WGT

= GRINDING =

MILL 938HSP 3/32" RP SCREEN 3500 RPM
MAX. TEMP 210 DEG F

SCREEN
MAX. TEMP.
RPM
F

SAMPLE W/O MIXING 1 ENV & 2 PT CANS
IF PACKED IN BAGS SAMPLE AS FOLLOWS:
FIRST BAG: 1 ENV.
40TH BAG: 1 ENV. & 2 PINT CANS
LAST BAG: 1 ENV.
DELIVER TO CTL

DATE MIXED
SAMPLED BY
RELEASED BY

N37723

3363
1534
4897

95
124
41
301
14
265
14
297
14
257
14
277
14
262
14
1534

0.00 *

95
41
324
0

262
10
312
10
317
10
287
10
278
10
281
14
289
14
280
10
319
14
297
14
273
14
310
10
3363

12

*Drums Reweighed
7/26/82
Correct wgt. 4910
18 dms.*

3.01 +
0.14 -
2.65 +
0.14 -
2.97 +
0.14 -
2.57 +
0.14 -
2.77 +
0.14 -
2.62 +
0.14 -
2.62 +
0.14 -
3.12 +
0.14 -
3.17 +
0.14 -
2.85 +
0.14 -
2.78 +
0.14 -
2.81 +
0.14 -
2.89 +
0.14 -
2.80 +
0.14 -
3.19 +
0.14 -
2.97 +
0.14 -
2.73 +
0.14 -
3.10 +
0.14 -
49.10 *