

CG 04 CODE KQ-789-D PROCESSES APPROVED B
 EST'D WGT 1032 LBS () KO-789-D (I) FWP 5/22/80
 STANDARD HRS. 10.8 TIME 11.9 M () () ()
 TYPED BY: FWP 5/22/80

CG	CODE	FR	LOT	LBS
01	YC016B	93	35921	3050
01	YC016B	93	34186	200
01	YC016B	93	36033	950

OK
HP

TOTAL EST'D WGT 5232 REQ. NO. () NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACC LBS
211 & 208	RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
208	WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MIN	530	32-D	536
	RECORD: START 8:30 AM LOT 35921 <i>OK</i>	84X50	YC16B	426
	FIN 11:10 AM 36033	3000		
		1200		
	ADJUST TO 75" (1275 G)			
	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 HOT WATER AT 2800-3200 PSI INTO V-208			
	RECORD: V-208 VOL. 49" & ADJUST TO 54" (1890G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	RUN 10" (514 G) WATER INTO V-247 START			
	AGITATOR & INSTALL TEMP CHART			
	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 11:30 AM TOTAL MINUTES 150			
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 & 384	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	WEIGH INTO V-384 & PUMP TO V-349	2545	32-D	254
	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	RECORD DENSITY: 1.085 G/ML (1.082-1.086)			
V	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	RECORD: PH 10.6 & ADJ TO 11.1-11.3 USING N-7-D			
	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	SIPHON N-7-D INTO SV & RECORD: PH 11.3	12	7-D	6
	ASSUME 50%			
20	HEAT TO 190-194°F IN 53-45 MIN & RECORD: 19.2			
	& RECORD: 19.2			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEAT			

N32320

247

LBS CODE LBS

343	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO			
8	22	V-343			
386	23	METER IN FROM V-386	M. 38.10.86 / GAL	35.9 / GAL	27-D 390
5	24	STIR 15 MIN OR LONGER			
	25	RECORD: DENSITY 1.020 G/ML (1.018-1.020)			

28	26	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.1			
29	27	SET V-343 ACID PUMP AT 65 SETTING (255 MIN)			
30	28	SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)			
31	29	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
	30	AT 190-194°F DURING STRIKE			
32	31	RECORD: START FINISH MINUTES			
		V-343 3:43A 8:20A 275			
		V-349 7:30 225			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 4:05A-49 (20) 30+ 7.7 (9.3-10.0)			
		40 MIN 4:25A-45 (18) 18+ 7.3 (9.3-10.0)			
		1 HR 4:45A-41 (16) 16 6.8 (9.3-10.0)			
		2 1/4 HR 6:00A-25 (8) 8 9.9 (9.3-10.0)			
		3 1/2 HR 7:15A-9 (0) 14 11.2 9.95 (9.3-10.0)			
		FINISH 8:00A-0 (0) 6.5 (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

85	30	RUN 31" (238 G) WATER INTO V-385 & HEAT TO			
	31	135-140°F			
	32	DUMP IN & STIR TO DISSOLVE	530	15-A	530

92	33	ADD 42" (514 G) WATER TO V-302			
	34	ADD & STIR 2 MIN	330	7-D	165

93	35	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &			
	36	SET PUMP AT ZERO SETTING			
94	37	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &			
	38	TURN OFF PUMP MOTOR			
	39	STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM			
	40	RECORD: START 8:20A			
	41	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	42	RECORD: PH 3.2 (3.4-3.8) & IF NECESSARY ADJ			
	43	(DOWN ONLY) TO 3.4-3.8 & RECORD: PH			15-A
	44	NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
	45	°F IN DRUM, USE 30 GAL WATER TO 50%			
	46	N-15-A. STIR SV 5 MIN AFTER EACH ADDITION			
	47	RUN IN N-7-D FROM S 32 IN 10-12 1 & STIR 5			
	48	MIN			
	49	RECORD: PH 6.0 (6.2-6.4) & IF NECESSARY ADJ TO			
	50	PH 6.2-6.4. RECORD: PH 6.2 ASSUME 77%			27-D
	51	DILUTE N-7-D 40 TO 1 WITH WATER ASSUME 50%	16	7-D	8
	52	SIPHON N-7-D INTO SV			
	53	POUR IN STIR 15 MIN	50	978-6	50
	54	STOP AGITATOR			

START	FINISH	OPERATOR
11:00A	7:00A	301-27
7:15A	10:00AM	235-320

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

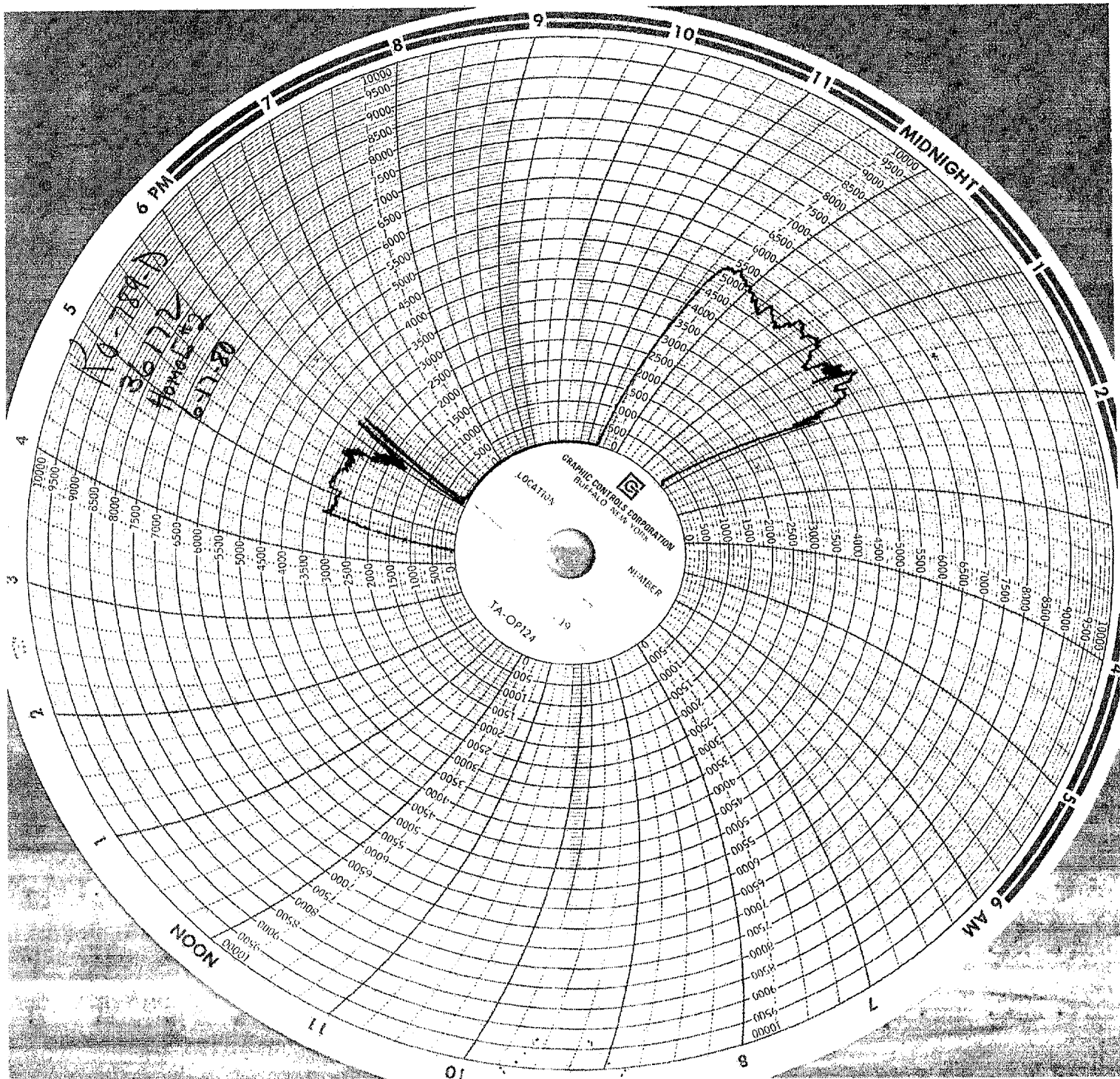
CG 04 CODE KQ-789-D PUNCHED & CHECKED PROCESSES APPROVED BY
EST'D WGT 1032 LBS () KQ-789-D (I) FWP 5/22/80
STANDARD HRS. 10.8 TIME 11:19 M () ()
TYPED BY: FWP 5/22/80

CG CODE PQ LOT LBS
01 YC016B 93 35921 3050
01 YC016B 93 34186 200
01 YC016B 93 36033 950

TOTAL EST'D WGT 5232 REQ. NO. () NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
208	WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MIN	530	32-D	530
	RECORD: START 8:30 AM LOT 35921	84X50	YC16B	4200
	FIN 11:10 AM 36033	3000		
	ADJUST TO 75" (1275 G)			
	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 HOT WATER AT 2800-3200 PSI INTO V-208			
	RECORD: V-208 VOL. 479" & ADJUST TO 54" (1890G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	RUN 10" (514 G) WATER INTO V-247 START			
SV	AGITATOR & INSTALL TEMP CHART			
	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 11:30 AM TOTAL MINUTES 150			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
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349	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
384	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F	2545	32-D	2545
	WEIGH INTO V-384 & PUMP TO V-349			
	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	RECORD DENSITY: 1.085 G/ML (1.082-1.086)			
V	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	RECORD: PH 10.6 & ADJ TO 11.1-11.3 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	SIPHON N-7-D INTO SV & RECORD: PH 11.3	12	7-D	6
20	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 150°F			
	& RECORD: 11.3			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

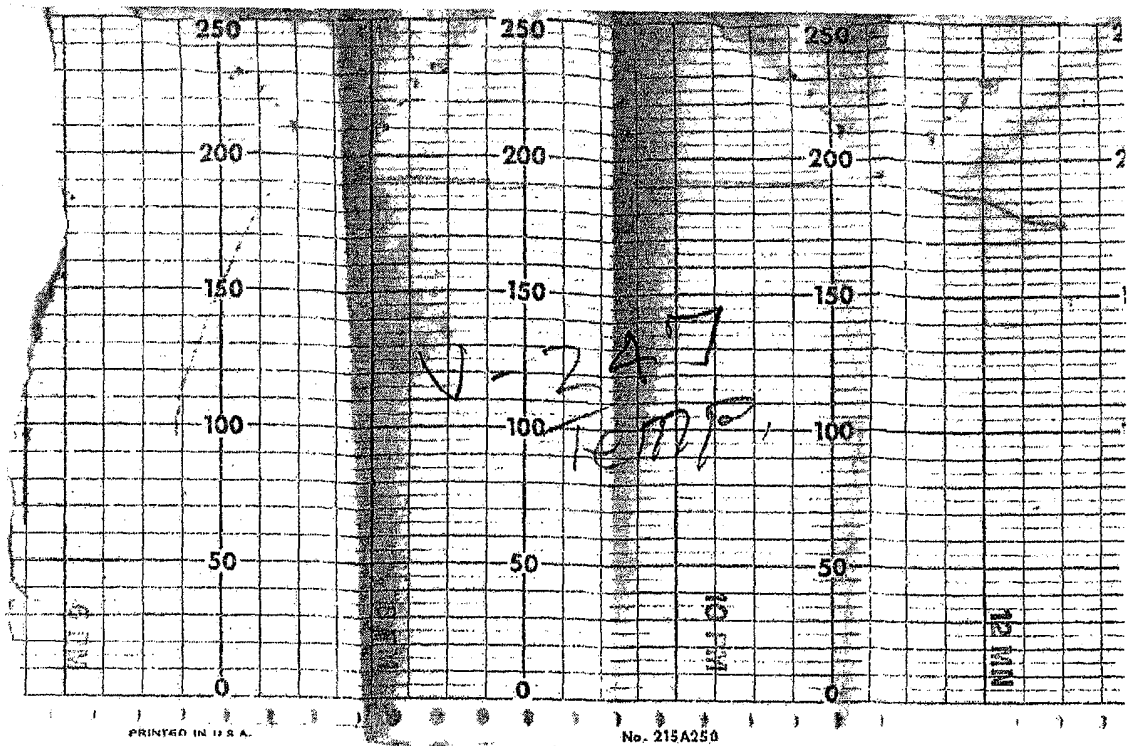
DUP050457557



N32320.01

DUP050457558

247



N32320.02

DUP050457560