CG 04 CODE K0789D PKG PUNCHED & CHECKED PROCESSES APPROVED BY
K0789D (I) FWP 4/28/80
EST'D WGT 1032 LBS ( ) ( )
STANDARD HRS. 10.8 TIME 74 JUN 1 5 1980 ( ) ( )
WATER & COLOR ( ) ( )
TYPED BY: FWP 4/28/80

CG	CODE	PR	LOT	LBS
01	YC016B	93	34185	1000
~~01~~	~~YC016B~~	~~93~~	~~34201~~	~~500~~
01	YC016B	93	35863	1250
01	YC108	93	35864	1450
01	YC-16-B	93	34573	500

TOTAL EST'D WGT 5232 REQ. NO. (V-208 and Completed homogenizing from V-208 NON-BLEEDING

V-245 'WHT' 12:15 AM
Rehomog V-247 To V-245
START 12:15 AM
Homog #3 Rehomogenized from V-247 for ± 2 hrs. more than original formula
" #4 to meet specs.

Appears that the N-32-D or stage 2 was left out of batch. Added N-32-D into V-247 and rehomogenized in V-245 per E. W.K. JFM

EQUIP		NAME : "KROLOR"ORANGE Y	USE LBS	NCODE	ACCT LBS
211 & 208	4	RUN 60"(990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
	3	WEIGH IN DRUM AND POUR IN	530	32-D	530
		DUMP IN AND STIR 5 MINS. LOT	84X50	YC16B	4200
		RECORD: START 1230 PM 34185	1000		
1		FIN _____ 35863	1250		
		35864	1450		
	4	ADJUST TO 75" (1275 G) 34573	500		
	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 OF HOT WATER AT 2800-3200 PSI INTO V-208			
	7	RECORD: V-208 VOL. 52 " & ADJUST TO 54"(1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
200 & SV 2	9	RUN 10" (514 G) WATER INTO V-241 & START AGITATOR & INSTALL TIME CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START _____ TOTAL MINUTES 240			
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	12	WHILE HOMOG, RUN 6" (284 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	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: 1.085 G/ML (1.082-1.086)			
SV 4	18	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45"(2300 G)			
	19	RECORD: PH 10.7 & ADJ TO 11.1-11.3 USING N-7-D			
		DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	26	7-D	13
		SIPHON N-7-D INTO SV & RECORD: PH 11.2			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC: HT 191 *F & RECORD: 192 *F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

JFM

N32329

EQUIP		PAGE 2 CG 04 KO-789-D EST WGT 5232# V-245	USE LBS	N-CODE	USE LBS
343 & 386 5	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343			
	22	METER IN FROM V-386 M37 10.85#/GAL 35.9 GAL		27-D	39(
	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.020 GM/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 11:30AM 4:05 275 V-349 3:10 220 TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH AT 20 MIN 11:50A (49)___ (20)___ 9.9 (9.3-10.0) 40 MIN 12:10P (45)___ (18)___ 9.9 (9.3-10.0) 1 HR 12:30P (41) 41 (16) 16 9.9 (9.3-10.0) 2 1/4 HR 1:45P (25) 29 (8) 8 9.9 (9.3-10.0) 3 1/2 HR 3:50P (9) 11 (0) 1 9.9 (9.3-10.0) FINISH 3:45P (0)___ 8.0 (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	
~~356~~ 7	30	RUN ~~33"~~ 31" (238 G) WATER INTO V-~~356~~ 385 & HEAT TO 135-140*F			
385	31	PUMP IN & STIR TO DISSOLVE	530	15-A	530
302 8	32	ADD ~~42"~~ 20 (514 G) WATER TO V-302			
	33	ADD & STIR 2 MIN	330	7-D	165
SV 9	34	WHEN V-349 MT, ~~RINSE IN WITH MINIMUM WATER~~ & SET PUMP AT ZERO SETTING.			
	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 _____			
	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____ 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 4.2 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4 & RECORD: PH 6.2 ASSUME 77%		27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	32	7-D	16
		SIPHON N-7-D INTO SV			
	41	POUR IN STIR 15 MIN	50 ✓	978-A	50
	42	STOP AGITATOR			

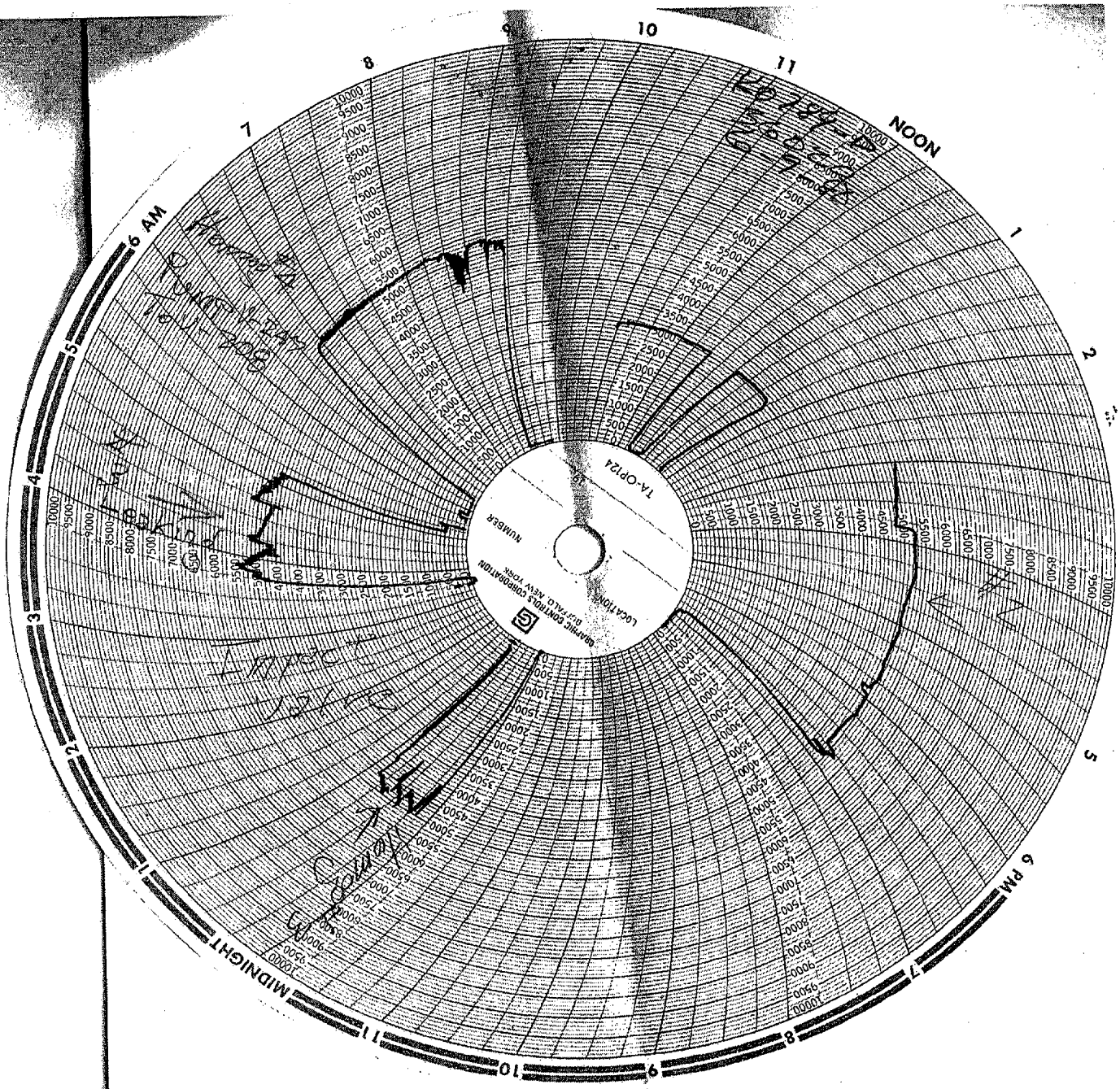
START	FINISH	OPERATOR
11 PM	3 PM	285
3 P.M	11 P.M	54-120
11:00 P	7:00 AM	235-323
3 PM	5:10 P	120-

Add DP1

DUP050457590

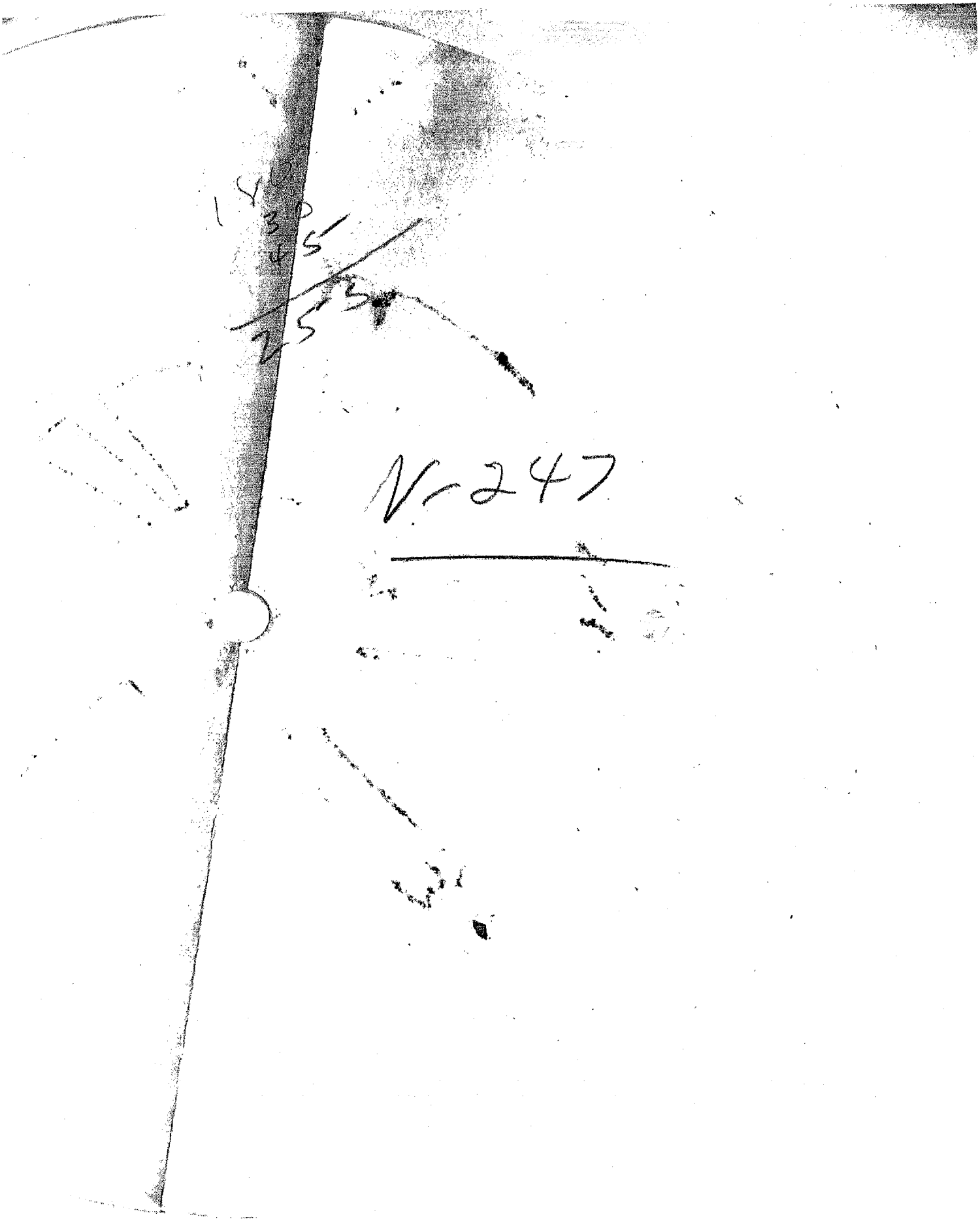
N32329.01

DUP050457591



N32329.02

DUP050457592



DUP050457593