

S.V. 246 247 (MANUAL) DATE PRINTED: 9/08/82
 CODE KD-786-D PKG 5084* PROCESS () KD-786-D (P) APPROVED BY: *APL*
SEP 24 1982 **K2H02** COMTYP JOBNAME: 04K0786DMP
 ("DATE") ("LOT") TIME: 3:00 P.M., STANDARD HRS. 10.5

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
01	YE721D	98		<i>Δ2H89</i>	200	100.00	4	50	200	200
01	YC-10	93		<i>62H95</i>	1000	100.00	40	50	1000	1000
01	YC-10	93		<i>Δ2H61</i>	3100	100.00	62	50	3100	3100
01	YC-10	93								

SUBSTANDARD BLEND-BACK FOR S-40: CODE _____, LOT _____, PQ _____
 REQ. NO. (10976) NON-BLEEDING

EQUIP MENT	NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
211	"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
208	RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MIN LOT RECORD: START <i>9:15 AM</i> FIN <i>11:15 AM</i>	30	7-D	15
	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD. WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208 WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208 RECORD: V-208 VOL. <i>4.2</i> & ADJUST TO 50" (1840G) INSPECT HOMOG STRAINER & CLEAN IF NECESSARY	270 82X50 4X50	32-D YC10B YE721D	270 4100 200
208	RUN 15" (771 G) WATER INTO V-246 START & AGITATOR & INSTALL TEMP CHART SV PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV RECORD: TIME START <i>4:25</i> TOTAL MINUTES <i>180</i> NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208 WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349	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 RUN 1000# WATER INTO V-384 & PUMP TO V-349 3 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN RECORD DENSITY <i>1.081</i> G/ML (1.078-1.081)	2400	32-D	2400
SV	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G) RECORD: PH <i>10.7</i> & ADJ TO 10.4-10.8 USING N-7-D 4 DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH <i>9.7</i> 20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT <i>100</i> *F & RECORD: <i>100</i> *F		7-D	

LOT# _____ COMTYP JOB NAME = 04K0786DMP PAGE 02 DATE PRINTED: 7/08/82

EQUIP PAGE 2 CG 04 KO-786-D USE N- ACCT
MENT LBS CODE LBS

343 21 WHILE HEATING SV, RUN 51" (1400 G) WATER INTO
& 22 V-343 24 10682 33.2 GAL 27-D 355
386 23 METER IN FROM V-386 M 24 10682 33.2 GAL
5 24 STIR 15 MIN OR LONGER
24 RECORD: DENSITY 1.020 G/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH
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
SV AT 190-194°F DURING STRIKE
6 29 RECORD: START FINISH MINUTES
V-343 9:25 12:30 2:05
V-349 9:25 12:30 2:05
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 9:45 (47) 12:20 (20) 2:05 (9.3-10.0)
40 MIN 10:25 (43) 12:17 (17) 2:05 (9.3-10.0)
1 HR 10:25 (38) 12:15 (15) 2:05 (9.3-10.0)
2 HR 11:25 (24) 12:12 (12) 2:05 (9.3-10.0)
3 HR 12:25 (10) 12:09 (9) 2:05 (9.3-10.0)
FINISH 1:10 (0) 12:07 (7) 2:05 (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 &
33 SET PUMP AT ZERO SETTING
8 34 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
35 TURN OFF PUMP MOTOR
36 TURN OFF STEAM
37 RUN IN ALUM USING BADGER METER 600 115-D 300
38 FLUSH ALUM LINE WITH WATER.
39 RECORD: PH 3.7 (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-D
38 RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN
39 RECORD: PH 4.0 (4.0-4.2) & IF NECESSARY ADJ TO
PH 4.0-4.2. RECORD: PH ASSUME 77% 27-D
DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 7-D
SIPHON N-7-D INTO SV
40 WHEN SCHEDULED ON TOP OF PAGE 1, DUMP IN
SUBSTANDARD TO BE BLENDED BACK.
RECORD: CODE _____ LOT _____

41 STOP AGITATOR
START FINISH OPERATOR

3:00 PM 11:00 PM 3:20
11 P 7 A 126-170
7:00 AM 2:00 PM 109-242

WAREHOUSE REQUEST FORM

REQUEST NO. 10976
9/21/82

DELIVER TO Making BY 92482 3 PM

FOR: CG 04 CODE K0786D LOT K2H02 SCHEDULED 9/24/82

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
BAY 11	01	YE721D	98	D2H89	200		4	50	200	-----
P-2	01	YC010B	93	G2H95	1000		20	50	1000	-----
B10	01	YC010B	93	J2H61	3100		62	50	3100	-----

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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EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE ____/____/____

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

