

MAY 28 1982

F2H46

5179*

COMTYP JOB NAME:

FWP 03/25/82

(DATE)

(LOT)

(EST WGT)

TYPED BY:

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
13		YC016B	93	E2E04	3750	XX.XX		50		
13		YC016B	93	E2E02	450	XX.XX		50		
01		YC016B	93			XX.XX		50		
						XX.XX				
						XX.XX				
						XX.XX				

(Reg No. 10820)

3 P.M.

EQUIP	NAME	USE LBS	NCODE	ACCT LBS
	NAME : "KROLOR" ORANGE Y NON-BLEEDING			
	"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
211 & 208	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MIN	84X50	YC16B	4200
	RECORD: START	3750		
	FIN	450		
	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 2800-3200 PSI INTO V-208			
	6 WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2800-3200 PSI INTO V-208			
	7 RECORD: V-208 VOL. 40 & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 10" (514 G) WATER INTO V-246. START AGITATOR & INSTALL TEMP CHART			
	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 10:35 A TOTAL MINUTES 95			
	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: 1.082 G/ML (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19 RECORD: PH 11.1 & ADJ TO 11.1-11.3 USING N-7-D			
	4 AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	SIPHON N-7-D INTO SV & RECORD: PH		7-D	
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 192°F			
	& RECORD: 192°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING			

JUN 1 1982

(2)

MENTI COMTYP JOB NAME: 04K0789DMI V-246 LBS CODE LBS

343 21 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343
 & 22 METER IN FROM V-386 M 17:10.318 ÷ GAL 32.8 GAL 27-D 390
 386 23 STIR 15 MIN OR LONGER
 5 24 RECORD: DENSITY 1.018 G/ML (1.018-1.020)
 NOTE: THIS PROCESS CALLS FOR N-27-D ON SURFACE.
 BE SURE THAT HOSE IS NOT IN UNDERSURFACE STRIKE LINE.

SV 25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.3
 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
 6 29 RECORD: START FINISH MINUTES
 V-343 2:10 PM 6:35 PM 265
 V-349 2:10 PM 5:50 PM 220
 TIME V-343 V-349 SV NORMAL
 INCHES INCHES PH PH
 AT 20 MIN 2:30 P (49) 49 (20) 20 9.8 (9.3-10.0)
 40 MIN 2:50 P (45) 45 (18) 18 9.8 (9.3-10.0)
 1 HR 3:10 P (41) 41 (16) 15 9.8 (9.3-10.0)
 2 1/4 HR 4:25 P (25) 26 (8) 8 9.8 (9.3-10.0)
 3 1/2 HR 5:45 P (9) 11 (0) 2 9.8 (9.3-10.0)
 FINISH 6:25 P (0) 2 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

302 30 ADD 67" (514 G) WATER TO V-343 302
 31 ADD & STIR 2 MIN 330 7-D 165

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 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM
 RECORD: START 6:35
 35 RUN IN ALUM USING BADGER METER 1060 115-A 530
 36 FLUSH ALM LINE WITH WATER
 37 RECORD: PH 3.0 (3.4-3.8) & IF NECESSARY ADJ
 (DOWN ONLY) TO 3.4-3.8 & 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 S31 IN 10-12 MIN & STIR 5 MIN
 39 RECORD: PH 4.5 (6.2-6.4) & IF NECESSARY ADJ TO
 PH 6.2-6.4. RECORD: PH 6.4 ASSUME 77% 27-D
 DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 170 7-D 60
 40 SIPHON N-7-D INTO SV
 41 POUR IN STIR 15 MIN 50 978-A 50
 STOP AGITATOR

START 8:00 AM
 3:00 PM
 FINISH 3:00 PM
 9:10 PM
 OPERATOR 381-144
 320-342

