

CG 04 CODE KD-789-D PKG
 EST'D WGT 1032 LBS

PROCESSES APPROVED BY
 () KD-789-D (I) FWP 11/20/80

STANDARD HRS. 10.8 TIME _____ M

JOB NAME: 04K0789-DMI

CG CODE PQ LOT LBS
 01 YC016B 93 36036 200
 01 YC016B 93 ~~36036~~ 200
 01 YC016B 93 37620 2000
 01 YC-10-B 93 35783 2000

**CLEAN UP
 AS YOU GO ALONG**

TOTAL EST'D WGT 5232

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
208	2 WEIGH IN DRUM AND POUR IN	540	983-D	540
	3 DUMP IN AND STIR 5 MIN	84X50	YC16B	4200
	RECORD: START 9 AM	36036		100
	FIN 130 PM	35783		2000
		37620		2000
	4 ADJUST TO 75" (1275 G)			
	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. 42 " & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 G) WATER INTO V-208, START			
	AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 9:30 PM 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	2600	983-D	2600
	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: 1.083 G/ML (1.082-1.086)			
SV	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			
4	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	10	7-D	5
	SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT _____°F			
	& RECORD: _____°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34619

V-247

343 21 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343
 & 22 METER IN FROM V-386 70 9.590 GAL 40.7 GAL 27-D 390
 386 23 STIR 15 MIN OR LONGER
 5 24 RECORD: DENSITY 1.020/ML (1.018-1.020)

SV 25 WHEN S 20 HEATING COMPLETE, RECORD: PH 6.0
 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

RECORD:	START	FINISH	MINUTES
V-343	4:40 AM	9:05 AM	265
V-349		8:20 AM	220
TIME	V-343 INCHES	V-349 INCHES	SV PH
AT 20 MIN	5.00 (49)	(20)	9.9 (9.3-10.0)
40 MIN	5.20 (45)	(18)	9.9 (9.3-10.0)
1 HR	5.40 (41)	(16)	9.8 (9.3-10.0)
2 1/4 HR	6.55 (25)	28+ (8)	9.7 (9.3-10.0)
3 1/2 HR	8.10 (9)	13 (0)	9.6 (9.3-10.0)
FINISH	8.55 (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

385 29 RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140°F
 7 30 DUMP IN & STIR TO DISSOLVE 530 15-A 530

302 31 ADD 42" (514 G) WATER TO V-302
 8 32 ADD & STIR 2 MIN 330 7-D 165

SV 33 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING
 9 34 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR
 35 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM
 RECORD: START 9:05 AM
 36 RUN IN V-385 FROM S 31 & STIR 5 MIN
 37 RECORD: PH 3.1 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH 15-A
 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
 38 RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN
 39 MIN
 40 RECORD: PH 5.4 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH 6.2 ASSUME 77%
 DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 40 27-D 7-D 39
 SIPHON N-7-D INTO SV
 41 POUR IN STIR 15 MIN 50 978-A 50
 42 STOP AGITATOR

START	FINISH	OPERATOR
3:00 PM	11:00 PM	381-282
11:00 AM	7:00 AM	301-259
11:00 AM	11:30 AM	320-235

WAREHOUSE REQUEST FORM

REQUEST NO 3630
12/02/80

DELIVER TO MAKING AREA BY 12/3/80 7 AM

FOR: CG 04 CODE K0789D LOT 38134 SCHEDULED 11/25/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
BAY 2	01	YC016B	93	36036	200		4	50	200	-----
35-B10	01	YC016B	93	37415	150		3	50	150	-----
BAY 1	01	YC016B	93	37620	2000		40	50	2000	-----
35-2	01	YC016B	93	35783	1850		37	50	1850	-----

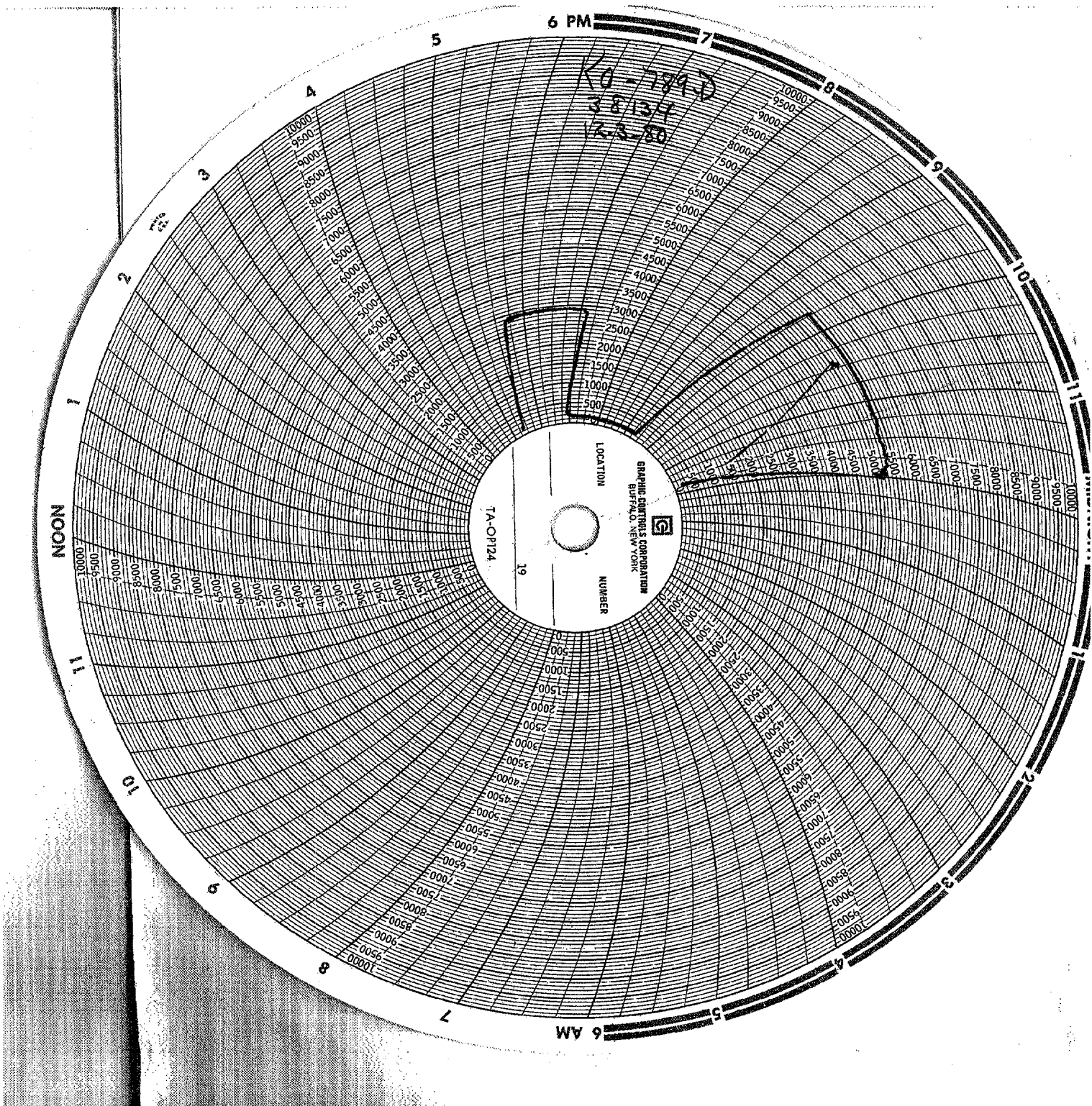
PICK UP AND RETURN TO STORAGE:

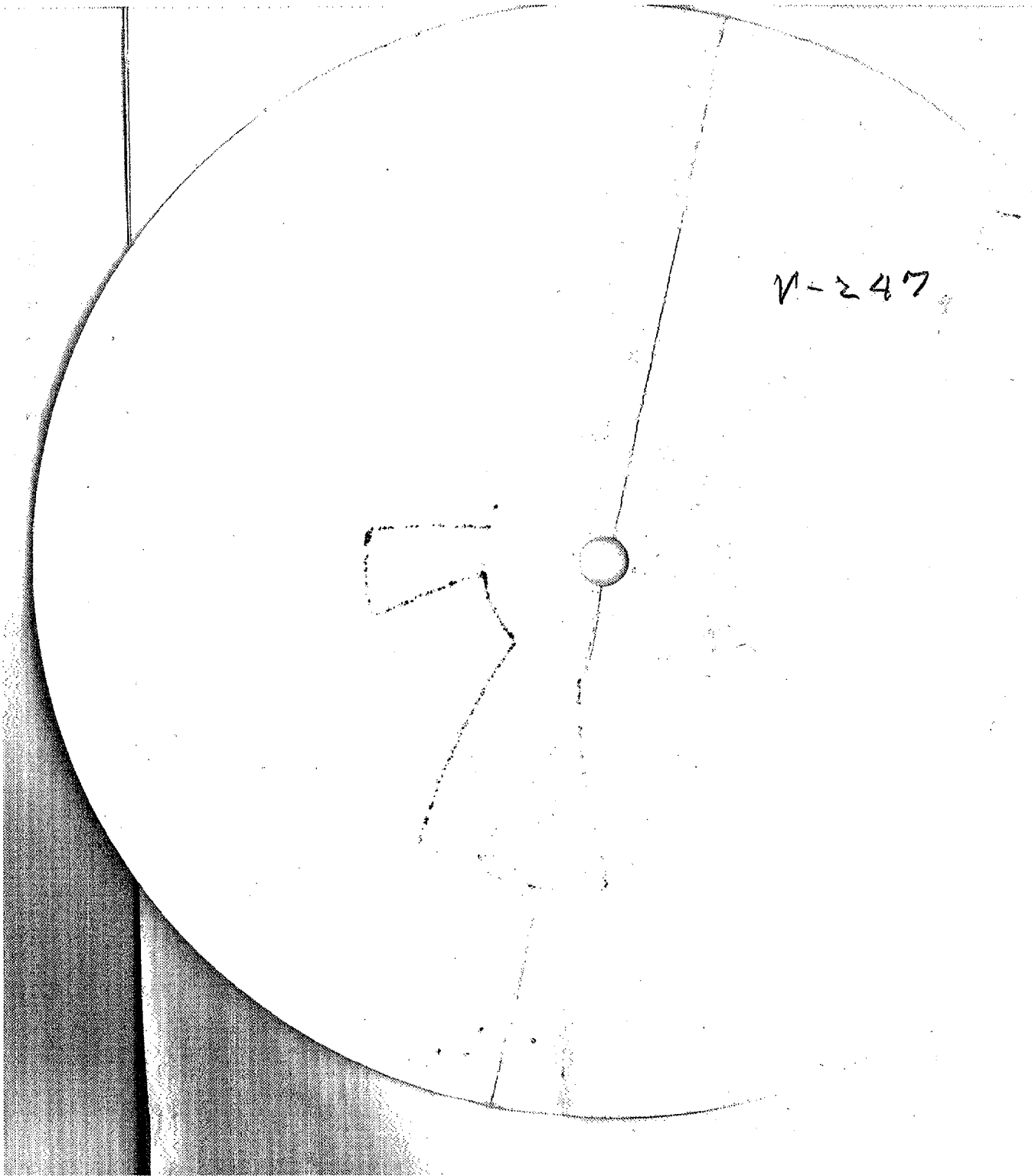
LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT
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EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE ____/____/____

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





V-247