

JUL 11 80

36493

Cancell

EST'D WGT 862 LBS

() KD-786-D (P)

FWP 5/22/80

STANDARD HRS. 10.5 TIME

7A M

TYPED BY: FWP 5/22/80

CG	CODE	PQ	LOT	LBS
01	YC010B	93	36216	900#
01	YC010B	93	36215	450#
01	YC010B	93	36214	2750#

OK
HP

TOTAL EST'D WGT 4962

REQ. NO. ()

NON-BLEEDING

EQUIP		NAME : "KROLOR" ORANGE R			USE LBS	NCODE	ACCT LBS
211	1	RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED			30	7-D	15
208	2	WEIGH IN DRUM AND POUR IN			270	32-D	270
	3	DUMP IN AND STIR 5 MIN LOT			82X50	YC10B	4100
1		RECORD: START _____					
		FIN _____					
	4	ADJUST TO 75" (1275 G)					
	5	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208					
	6	WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208					
	7	RECORD: V-208 VOL. _____" & ADJUST TO 50" (1840G)					
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY					
208	9	RUN 15" (771 G) WATER INTO V-____, START AGITATOR & INSTALL TEMP CHART					
SV	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START _____ TOTAL MINUTES _____					
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			2400	32-D	2400
	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: _____ G/ML (1.078-1.081)					
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)					
	19	RECORD: PH _____ & ADJ TO 10.4-10.8 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)					
4		ASSUME 50%				7-D	
		SIPHON N-7-D INTO SV & RECORD: PH _____					
	20	HEAT TO 190-194°F IN 55-65 MIN. & REC: HT _____ °F & RECORD: _____ °F					

N34508

121	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO			
343	V-343			
8	22 METER IN FROM V-386 M _____ #/GAL, _____ GAL		27-D	355
386	23 STIR 15 MIN OR LONGER			
5	24 RECORD: DENSITY _____ G/ML. ()			
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			
29	RECORD: START FINISH MINUTES			
	V-343 _____			
	V-349 _____			
	TIME V-343 V-349 SV NORMAL			
	INCHES INCHES PH PH			
	AT 20 MIN _____ (47) _____ (20) _____ (9.3-10.0)			
	40 MIN _____ (43) _____ (17) _____ (9.3-10.0)			
	1 HR _____ (38) _____ (15) _____ (9.3-10.0)			
	2 HR _____ (24) _____ (7) _____ (9.3-10.0)			
	3 HR _____ (10) _____ (0) _____ (9.3-10.0)			
	FINISH _____ (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	

385	130 RUN 31" (238 G) WATER INTO V-385 & HEAT TO			
7	135-140°F			
	131 DUMP IN & STIR TO DISSOLVE	300	15-A	300

302	132 ADD 42" (514 G) WATER TO V-302			
8	133 ADD & STIR 2 MIN	150	7-D	75

SV	134 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &			
	SET PUMP AT ZERO SETTING			
9	135 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &			
	TURN OFF PUMP MOTOR			
	136 TURN OFF STEAM			
	137 RUN IN V-385 FROM S 31 & STIR 5 MIN			
	138 RECORD: PH _____ (3.3-3.7) & IF NECESSARY ADJ			
	(DOWN ONLY) TO 3.3-3.7 & 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			
	139 RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN			
	140 RECORD: PH _____ (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			
	141 STOP AGITATOR			

START FINISH OPERATOR

WAREHOUSE REQUEST FORM

REQUEST NO. 3500
7/09/80

DELIVER TO MAKING AREA BY 7/11/80 7 AM/PM

FOR: CG 04 CODE K0786D LOT 36493 SCHEDULED 7/09/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
BAY-1	01	YC010B	93	36216	900		18	50	900	-----
BAY-1	01	YC010B	93	36215	450		9	50	450	-----
BAY-2	01	YC010B	93	36214	2750		55	50	2750	-----

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

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COPY-2 MANUFACTURING
COPY-3 WAREHOUSE
COPY-4 RAW MATERIAL

JUL 9 1980

CG 04 CODE K0-786-D PKG. _____
 → JUL 11 80 36493
 EST. WGT. 862 LBS.

OK
TR

PROCESSING INSTRUCTIONS: BATCH UNIT

PROCESSES K0-786-D (P)	APPROVED BY EWK 9-21-76 DCG 9-21-76
TYPED BY jlc 11-15-76	
MAKING NOTES	

REMARKS

TOTAL WEIGHT 4962 (Req. _____)

NAME: "KROLOR" ORANGE R

NON-BLEEDING

INSTRUCTIONS					-PRESSING-	RECORD				
VAT					PRESSLOAD	1ST	2ND	3RD	4TH	5TH
DATE					STARTED					
TIME					CAKES USED					
RELEASED BY					WATER ON					
PRESS	22	23	24	25	HRS. WASHED					
NO. OF CAKES	46	46	52	48	OHMS					
PRESS with	AGITATION				HRS. WASHED					
WASH TO 5000	OHMS with 35-75°F water				OHMS					
TEST AFTER 6	HOURS				HRS. WASHED					
LOAD on 6 cars					OHMS					
					CAKE CONDITION					
					NO. CARS LOADED					
					EXPLAIN LOSSES					
SAMPLES 1-8 oz. jar										
DELIVER TO CTI for color					SAMPLED BY	RELEASED BY				

-DRYING-

DRY 16 HOURS AT 220°F L.V.	L.V.	LUMP: - OK - WET - SALTS - CONTAMINATED
TEMP.	°F	
		ADDITIONAL DRYING HOURS REQUIRED
		NO. DRUMS:
SAMPLES	NO. CARS PULLED	LUMP WGT.
DELIVER TO	SAMPLED BY	RELEASED BY

-GRINDING-

HTL 938 HSP 3/32" SCREEN 3500 RPM	SCREEN	RPM
MAX. TEMP. 210°F	MAX. TEMP.	°F
		EXPLAIN LOSSES
SAMPLE AFTER / WITHOUT MIXING		DATE MIXED
SAMPLES 1 Env. + 1 Pint Can		
DELIVER TO C T L		SAMPLED BY
		RELEASED BY

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