

CODE KO-786-D

JUN 24 1980

PROCESSES

REMOVED BY

ESTD WGT 462 LBS

() KO-786-D ()
()
()
()

STANDARD WRS. 10.5 TIME 11 A M

TYPED BY: FWP 5/22/80

CG	CODE	FQ	LOT	LBS	S-1
01	YC010B	93	35489	1150	
01	YC010B	93	35488	1600	Bay 3
01	YC010B	93	35782	1350	Bay 2

Homog #2

Homog #2 Repacked + Impact Valve
Finish 10:15AM

TOTAL ESTD 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 DUMP IN AND STIR 5 MIN		270	32-D	270
		RECORD: START	LOT 35489	82X50	YC10B	4100
		FIN 7.45 PM	35488	1150		
			35782	1600		
				1350		
				4100		
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. 4.2" & ADJUST TO 50" (1840G)				
8	✓	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY				
98	✓	RUN 15" (771 G) WATER INTO V-345 START				
99	✓	AGITATOR & INSTALL TEMP CHART				
100	✓	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.				
2	✓	RECORD: TIME START 12.40 P TOTAL MINUTES 2.00				
11	✓	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208				
12	✓	WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV				
349	112	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349				
349	113	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F				
384	114	WEIGH INTO V-384 & PUMP TO V-349		2400	32-D	2400
349	115	RUN 1000# WATER INTO V-384 & PUMP TO V-349				
349	116	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN				
349	117	RECORD DENSITY: 1.081 G/ML (1.078-1.081)				
118	✓	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)				
119	✓	RECORD: PH 10.8 & ADJ TO 10.4-10.8 USING N-7-D				
120	✓	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%			7-D	
120	✓	SIPHON N-7-D INTO SV & RECORD: PH				
120	✓	HEAT TO 190-194°F IN 55-65 MIN. & REC: HT 190°F				
120	✓	& RECORD: 190°F				

1122399

V-245

USE LBS CODE USE LBS

343	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343			
343	22	METER IN FROM V-384	M 39, 10.94	32.4	
343	23	STIR 15 MIN OR LONGER			27-D 355
343	24	RECORD: DENSITY 1.018 G/ML ()			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0			
	26	SET V-343 ACID PUMP AT 72 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)			
SV	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 5:30			
		V-349 5:45	8:45 A	1.95	
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 5:45 (47) (20) 9.85 (9.3-10.0)			
		40 MIN 6:10 (43) (17) 9.85 (9.3-10.0)			
		1 HR 6:30 (38) (15) 9.85 (9.3-10.0)			
		2 HR 7:00 (24) 27 (7) 9.85 (9.3-10.0)			
		3 HR 8:30 (10) (0) 9.85 (9.3-10.0)			
		FINISH 9:15 (0) 7.1 (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
305	30	RUN 31" (238 G) WATER INTO V-385 & HEAT TO 135-140°F			
7	31	DUMP IN & STIR TO DISSOLVE	300	15-A	300
702	32	ADD 42" (514 G) WATER TO V-302			
8	33	ADD & STIR 2 MIN	150	7-D	75
SV	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
9	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	36	TURN OFF STEAM			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.3 (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			
	39	RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN			
	40	RECORD: PH 4.1 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH			27-D
		DILUTE N-7-D 10 TO 1 WITH WATER			7-D
		SIPHON N-7-D INTO SV			
	41	STOP AGITATOR			
		START FINISH OPERATOR			
		7:00 A 3:10 PM 235-320			
		3:08 A 10 342-201			

REQUEST NO 3469
6/18/80

MAKING AREA BY 6-20-80 11 AM

CODE R0380 LOT 34220 SCHEDULED 6/18/80

WEEK LOCATN	CG CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
8-11	01	10010H	93	35489	1150	23	50	1150	
BAY3	01	10010H	93	35488	1600	32	50	1600	
35-112	01	10010H	93	35782	1350	27	50	1350	

PICK UP AND RETURN TO STORAGE:

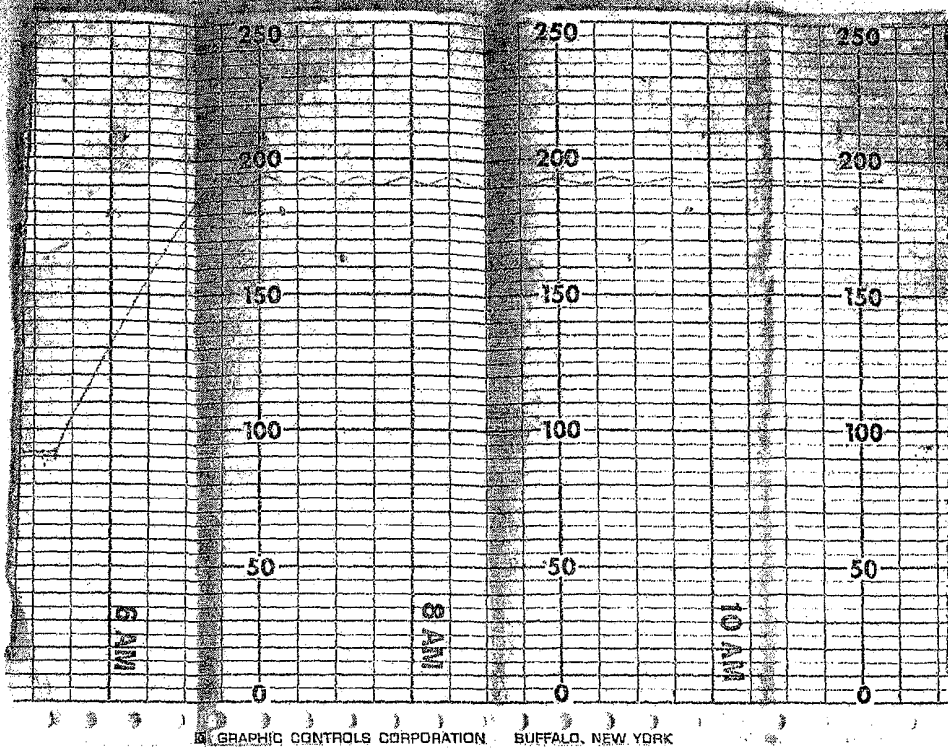
LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT

EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE ____/____/____

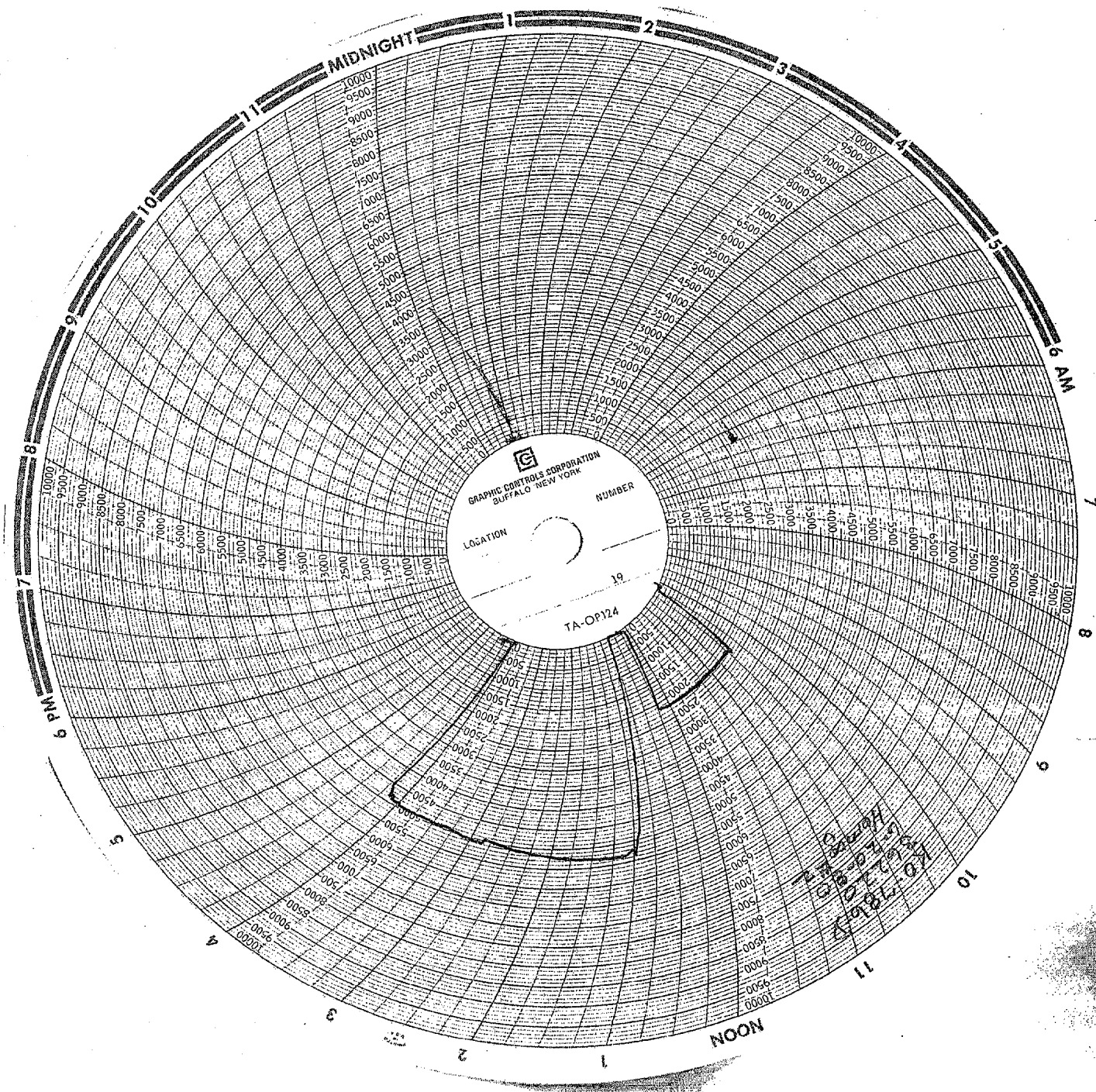
COPY-1 PROD. CONTROL
COPY-2 MANUFACTURING
COPY-3 WAREHOUSE
COPY-4 RAW MATERIAL

N32399.01



N32399.02

DUP050457848



N32399.03

DUP050457849