

ANUAL)
V. 246

.247

C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.CG 04 CODE KO-786-D PKG
OCT-20 80 37504
EST'D WGT 862 LBS

STANDARD HRS. 10.5 TIME 7A M

PROCESSES
() KO-786-D (P)
()
()
()
()
APPROVED BY
FWP 9/18/80
TYPED BY: FWP 9/18/80

CG	CODE	PQ	LOT	LBS
01	YC010B	93	37261	1000
01	YC010B	93	37271	1100
01	YC010B	93	36210	2000

JP 012
HP

Homog #2

TOTAL EST'D WGT 4962

REQ. NO. ()

NON-BLEEDING

UIP	NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACCT LBS
1	RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15
8	WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MIN RECORD: START 7:15A.M. LOT 37261 FIN 9:40A.M. 37271 36210	270 82X50 1000 1100 2000	32-D YC10B	270 4100
1	ADJUST TO 75" (1275 G) 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. 40" & ADJUST TO 50" (1840G) INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
9	RUN 15" (771 G) WATER INTO V-247, START AGITATOR & INSTALL TEMP CHART PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 7:45P.M. TOTAL MINUTES 125 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			
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	2400	32-D	2400
15	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
16	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
17	RECORD DENSITY: 1.019 G/ML (1.078-1.081)			
18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G) RECORD: PH 10.7 & ADJ TO 10.4-10.8 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH _____ HEAT TO 190-194°F IN 55-65 MIN & REC: HT _____°F & RECORD: _____°F		7-D	

N34588

EQUIP	PAGE 2	CG 04	RD-786-D	EST WGT 4962#	USE LBS	NF CODE	USE LBS
V-247							
✓ 21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO						
343	V-343						
& 22	METER IN FROM V-386 M. <u>63</u> , <u>8.934</u> GAL, <u>39.1</u> GAL <u>39.7</u>				27-D		355
386	STIR 15 MIN OR LONGER						
5	✓ 24 RECORD: DENSITY <u>1.019</u> G/ML (1.018-1.020)						
125	WHEN S 20 HEATING COMPLETE, RECORD: PH <u>9.9</u>						
126	SET V-343 ACID PUMP AT 72 SETTING (225 MIN)						
127	SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)						
128	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV						
SV	AT 190-194°F DURING STRIKE						
129	RECORD:				START	FINISH	MINUTES
	V-343				<u>11:50 AM</u>	<u>3:34 PM</u>	<u>224</u>
	V-349				<u>11:50 AM</u>	<u>2:55 PM</u>	<u>185</u>
	TIME				V-343	V-349	SV NORMAL
					INCHES	INCHES	PH PH
	AT 20 MIN <u>12:10</u> (47)				(20)	<u>9.6</u>	(9.3-10.0)
	40 MIN <u>12:30</u> (43)				(17)	<u>9.6</u>	(9.3-10.0)
	1 HR <u>12:50</u> (38) <u>39</u>				(15) <u>+</u>	<u>9.6</u>	(9.3-10.0)
	2 HR <u>1:50</u> (24) <u>26</u>				(7) <u>8</u>	<u>9.65</u>	(9.3-10.0)
	3 HR <u>2:50</u> (10) <u>12</u>				(0) <u>1/2</u>	<u>9.7</u>	(9.3-10.0)
	FINISH <u>3:35</u> (0)					<u>7.4</u>	(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 RUN 40" (308 G) WATER INTO V-385 & HEAT TO						
7	135-140°F						
✓ 31	DUMP IN & STIR TO DISSOLVE				300	15-A	300
302	✓ 32 ADD 42" (514 G) WATER TO V-302						
8	✓ 33 ADD & STIR 2 MIN				<u>75</u>	<u>75</u>	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 <u>2.8</u> (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 <u>3.8</u> (4.0-4.2) & IF NECESSARY ADJ TO						
	PH 4.0-4.2. RECORD: PH <u>4.2</u> ASSUME 77%				<u>12</u>	27-D	<u>12</u>
	DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%					7-D	
	SIPHON N-7-D INTO SV						
	✓ 41 STOP AGITATOR						
	START		FINISH		OPERATOR		
	<u>9:00 AM</u>		<u>3:00 PM</u>		<u>235-244</u>		
	<u>11:50 AM</u>		<u>5:20 PM</u>		<u>54-120</u>		

WAREHOUSE REQUEST FORM

REQUEST NO. 3579
10/17/80

DELIVER TO MAKING AREA BY 102080 7 AM/PM

OR: CG 04 CODE K0786D LOT 37504 SCHEDULED 10/17/80

WHSE QCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
AY 1	01	YC010B	93	37261	1000		20	50	1000	-----
AY 1	01	YC010B	93	37271	1100		22	50	1100	-----
5BLD	01	YC010B	93	36210	2000		40	50	2000	-----

CK-UP AND RETURN TO STORAGE:

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

INED _____ DATE ____/____/____

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

DUP050104530



