

CG 03 CODE KY-795-D PKG JUN 2 1961

PROCESSES

APPROVED BY

LOT

6/17

36173

() KY-795-D (I) FWP 5/22/80
 () (3/4 N-32-D STRIKE TO
 () IMPROVE GLOSS)
 () (30 MIN LONGER STRIKE TIL
 () STRIKE LINE IS REPLACED)

EST'D WGT 938 934 LBS

3 PM

OK
H

STANDARD HRS. 11.1 TIME

TYPED BY: FWP 5/22/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	82204-3	93	250	14	YC002B		93	
100	14	YC002B	82204-1	93	14	YC002B		93	
	14	YC002B	82204-2	93	14	YC002B		93	

7/11/61

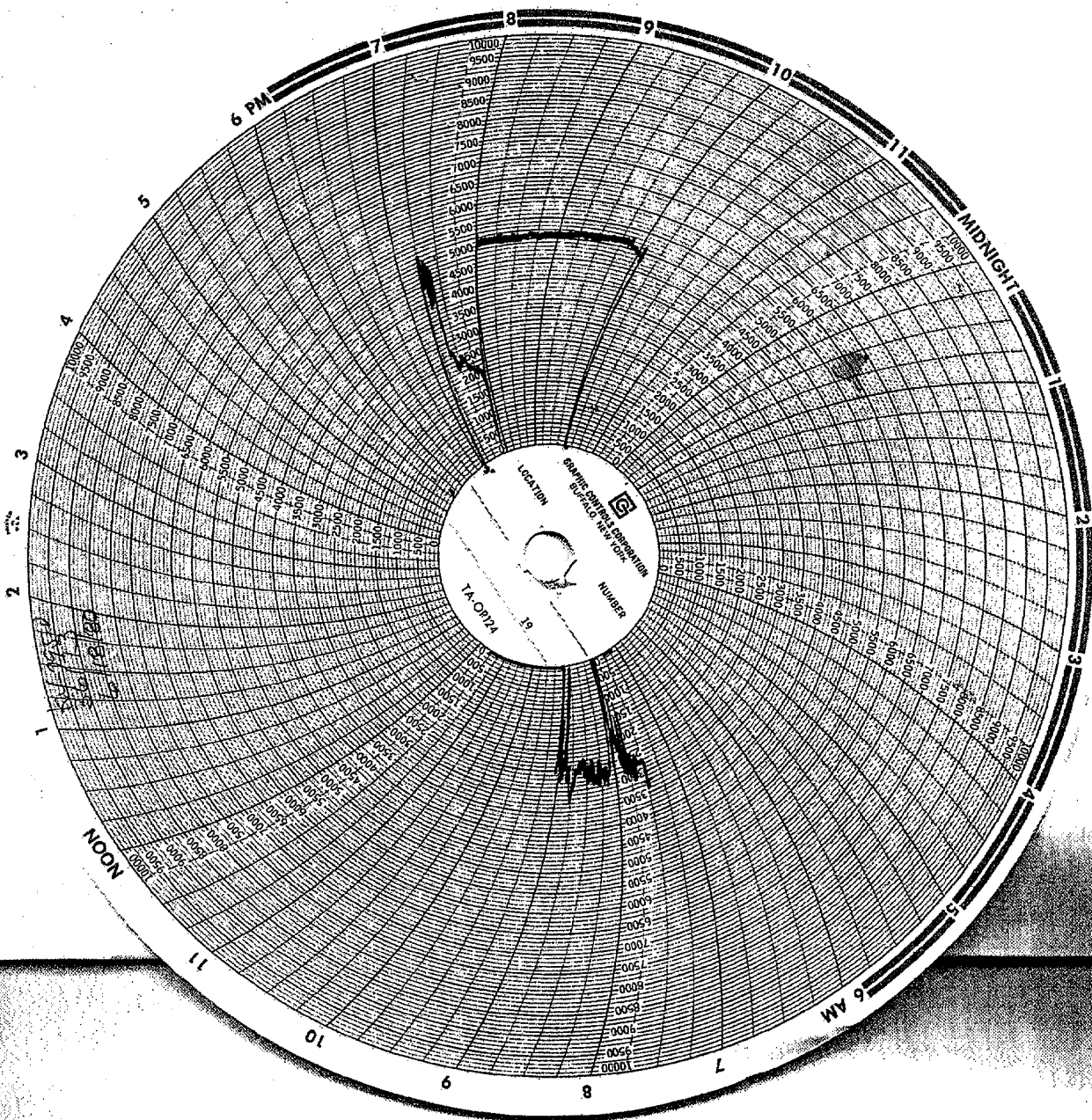
Homog #4 - 1st Pass

TOTAL EST'D WGT 4888 4784

NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW MEDIUM		USE LBS	N- CODE	ACCT LBS
03	4	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.				
05	2	WEIGH IN DRUM & POUR IN		500	32-D	500
	3	DUMP IN AND STIR 5 MIN		77X50	YC-2-B	3850
		RECORD: START 3:00 AM		300		
		FIN 5:30 AM		1300		
		ADJUST TO 75" (1275 G)		222		
		WITH AGITATOR ON LOW SPEED PUMP V-203 THRU		2000		
		HOMOG AT 2400-2600 PSI INTO V-205				
		WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN				
		OF HOT WATER AT 2400-2600 PSI INTO V-205				
		RECORD: V-205 VOL 56" & ADJ TO 51" (1874 G)				
		INSPECT HOMOG STRAINER & CLEAN IF NECESSARY				
05	4	RUN 2" (514 G) WATER INTO V-262 START				
		AGITATOR				
05	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.				
		RECORD: TIME START 7 PM TOTAL MINUTES 130				
		NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,				
		3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205				
		WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP				
		THRU HOMOG AT 4800-5200 PSI INTO SV				
09	12	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349				
		RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F				
384	14	WEIGH INTO V-384 & PUMP TO V-349		2000	32-D	2000
		RUN 1000# WATER INTO V-384 & PUMP TO V-349				
		ADJ V-349 TO 29" (1372 G) & STIR 15 MIN				
		RECORD DENSITY: 1.050 G/ML (1.049-1.051)				
05	10	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 24" (2496 G)				
		RECORD: PH 10.4 & ADJ TO 11.1-11.3 USING N-7-D				
		DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)				
		ASSUME 50%		20	7-D	10
		SIPHON N-7-D INTO SV & RECORD: PH 11.2				
		HEAT TO 190-194°F IN 55-65 MIN & RECORD: _____°F				
		& RECORD: _____°F				
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON				
		COMPLETION OF HEATING				

		V-262	LBS	CODE	LBS
343	21	WHILE HEATING SV, RUN 69" (1898 G) WATER INTO V-343			
386	22	METER IN FROM V-386 M <u>39</u> , <u>1094</u> /GAL, <u>285</u> GAL		27-D	312
5	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY <u>10.11</u> G/ML (1.010-1.012)			
		WHEN S:20 HEATING COMPLETE, RECORD: PH <u>10.1</u>			
SV	25	SET V-343 ACID PUMP AT 82 SETTING (265 MIN)			
6	26	SET V-349 SILICATE PUMP AT 70 SETTING (210 MIN)			
	27	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE.			
	28	RECORD: START FINISH MINUTES			
		V-343 <u>11:15</u> -----			
		V-349 -----			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN <u>11:38</u> (65) (26) <u>10.0</u> (9.0-10.0)			
		40 MIN <u>11:55</u> (59) (23) <u>10.0</u> (9.0-10.0)			
		1 HR <u>12:15</u> (54) (21) <u>10.0</u> (9.0-10.0)			
		2 HRS <u>1:15</u> (38) (12) <u>10.0</u> (9.0-10.0)			
		3 HRS <u>2:15</u> (22) (4) <u>10.0</u> (9.0-10.0)			
		3 1/2 HRS <u>2:40</u> (15) (0) <u>10.0</u> (9.0-10.0)			
		FINISH <u>3:15</u> (0) <u>7.8</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	
356	30	RUN 14" (108 G) WATER INTO V-385 & HEAT TO 135-140°F			
	31	DUMP IN & STIR TO DISSOLVE FOR S-38	220	15-A	220
DRUM	32	WEIGH INTO 55 GAL DRUM	60	7-D	30
8	33	FILL WITH WATER & STIR 2 MIN FOR S-40			
SV	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP TO ZERO SETTING			
9	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	36	TURN OFF STEAM			
	37	STIR IN	150	128-A	150
	38	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	39	RECORD: PH <u>3.3</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			
	40	SIPHON IN N-7-D FROM S-33 IN 4-6 MIN & STIR 5 MIN			
	41	RECORD: PH <u>4.2</u> (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	
	42	SIPHON N-7-D INTO SV			
	43	POUR IN STIR 15 MIN	45	978-A	45
	44	STOP AGITATOR			
		START 2:00A 3pm 11P			
		FINISH 3:00PM 11PM 6:00A			
		OPERATOR 285-320 282-223 120-27			
		V-261 (20 RPM) V-243, 244			
		5" 10"			
		25" 50"			



N32124.01

DUP050456742

