

CG 04 CODE KO-789-D PROCESSES APPROVED BY
 JUN 18 1980 JUN 2 4 1981 () KO-789-D (I) FWP 5/22/80
 EST'D WGT 1032 LBS () ()
 STANDARD HRS. 10.8 TIME 11A M () ()
 TYPED BY: FWP 5/22/80

CG	CODE	PR	LOT	LBS
01	YC016B	93	35443	3000
01	YC016B	93	34186	250
01	YC016B	93	35710	950

Homog #2

JUN 19 1980

TOTAL EST'D WGT 5232 REQ. NO. () NON-BLEEDING

EQUIP	NAME	USE LBS	NCODE	ACCT LBS
	"KROLOR" ORANGE Y			
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON			
	2 HIGH SPEED.			
208	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MIN	84X50	YC16B	4200
	RECORD: START	35443		
	FIN	34186		
		35710		
	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 5L & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	1 RUN 10" (514 G) WATER INTO V-247 START			
	2 AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START 12:30 A TOTAL MINUTES 180			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	22 WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
14	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	2545	32-D	2545
	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: 1.086 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			
	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%		7-D	
	SIPHON N-7-D INTO SV & RECORD: PH 11.2			
20	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 185°F			
	& RECORD: 192°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON			
	COMPLETION OF HEATING.			

N32311

343 21 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343
 & 22 METER IN FROM V-386 M 39 10.94 GAL 35.6 GAL
 386 23 STIR 15 MIN OR LONGER
 5 24 RECORD: DENSITY 1020 G/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.2
 26 SET V-343 ACID PUMP AT 45 SETTING (255 MIN)
 27 SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)
 28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
 SV AT 190-194°F DURING STRIKE

RECORD:	START	FINISH	MINUTES
V-343	7:30	12:10	280
V-349	7:30	11:55A	215
TIME	V-343	V-349	SV
	INCHES	INCHES	PH
AT 20 MIN	7:50 (49)	(20)	10.0 (9.3-10.0)
40 MIN	8:10 (45)	(18)	10.0 (9.3-10.0)
1 HR	8:30 (41)	(16)	10.0 (9.3-10.0)
2 1/4 HR	9:45 (25)	27*	9.85 (9.3-10.0)
3 1/2 HR	11:00 (9)	12*	9.7 (9.3-10.0)
FINISH	11:55 (0)		7.2 (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 31" (238 G) WATER INTO V-385 & HEAT TO 135-140°F
 31 DUMP IN & STIR TO DISSOLVE

530

15-A

530

302 32 ADD 42" (514 G) WATER TO V-302
 8 33 ADD & STIR 2 MIN

330

7-D

165

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 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM
 RECORD: START 12:10 PM
 37 RUN IN V-385 FROM S 31 & STIR 5 MIN
 38 RECORD: PH 3.75 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH
 NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140°F IN DRUM, USE 20 GAL WATER TO 50% N-15-A. STIR SV 5 MIN AFTER EACH ADDITION

15-A

39 RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN
 40 RECORD: PH 7.5 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH 6.3
 DILUTE N-7-D 10 TO 1 WITH WATER
 SIPHON N-7-D INTO SV

ASSUME 77%

ASSUME 50%

27-D

7-D

41 POUR IN STIR 15 MIN
 42 STOP AGITATOR

50

78-A

50

START	FINISH	OPERATOR
2:15 PM	3:00 PM	235-320
3 PM	11 PM	282-223
11:00 P	7:00 A	120-27
7:00 AM	2:30 P	235-144

WAREHOUSE REQUEST FORM

REQUEST NO. 3407
6/17/80DELIVER TO MAKING AREA BY 6/18/80 11 AM/PM

FOR: CG 04 CODE K0789D LOT 36182 SCHEDULED 6/17/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
35-B-1	01	YC016B	93	35443	3000		60	50	3000	-----
T 5	01	YC016B	93	34186	250		5	50	250	-----
35-B2	01	YC016B	93	35710	950		19	50	950	-----

PICK UP AND RETURN TO STORAGE:

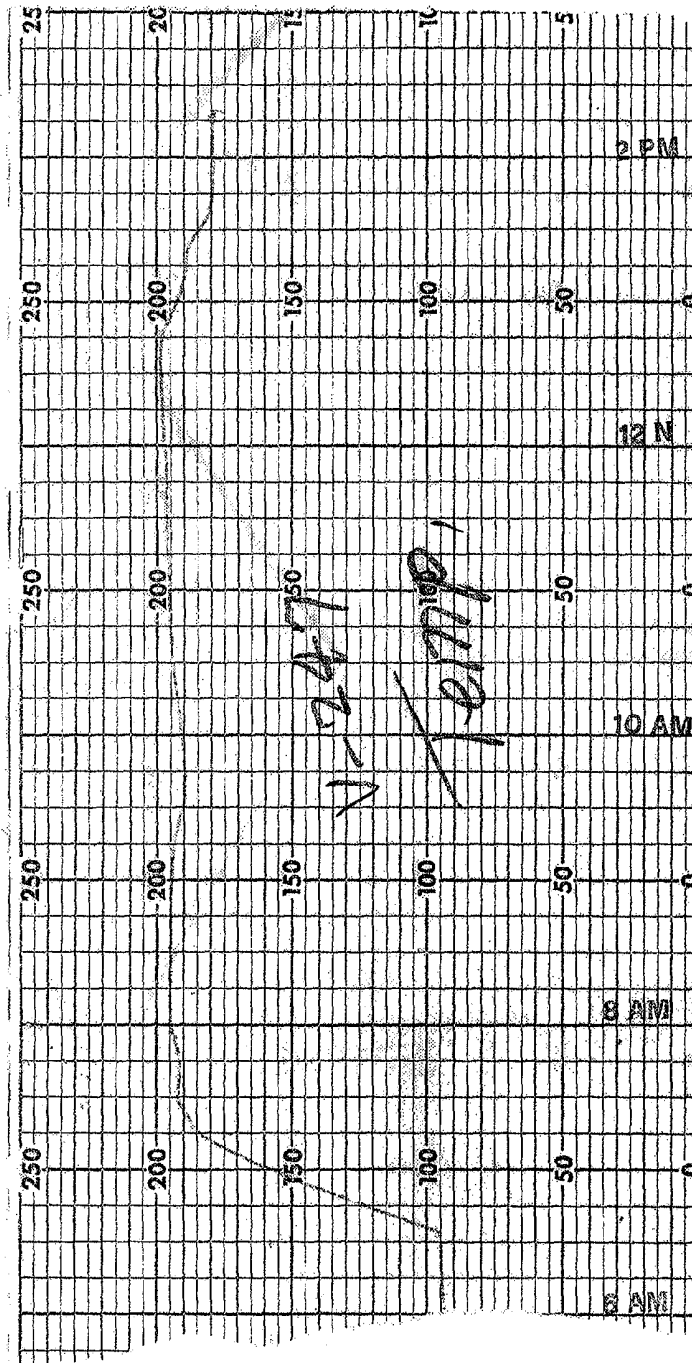
LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT
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EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE ____/____/____

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

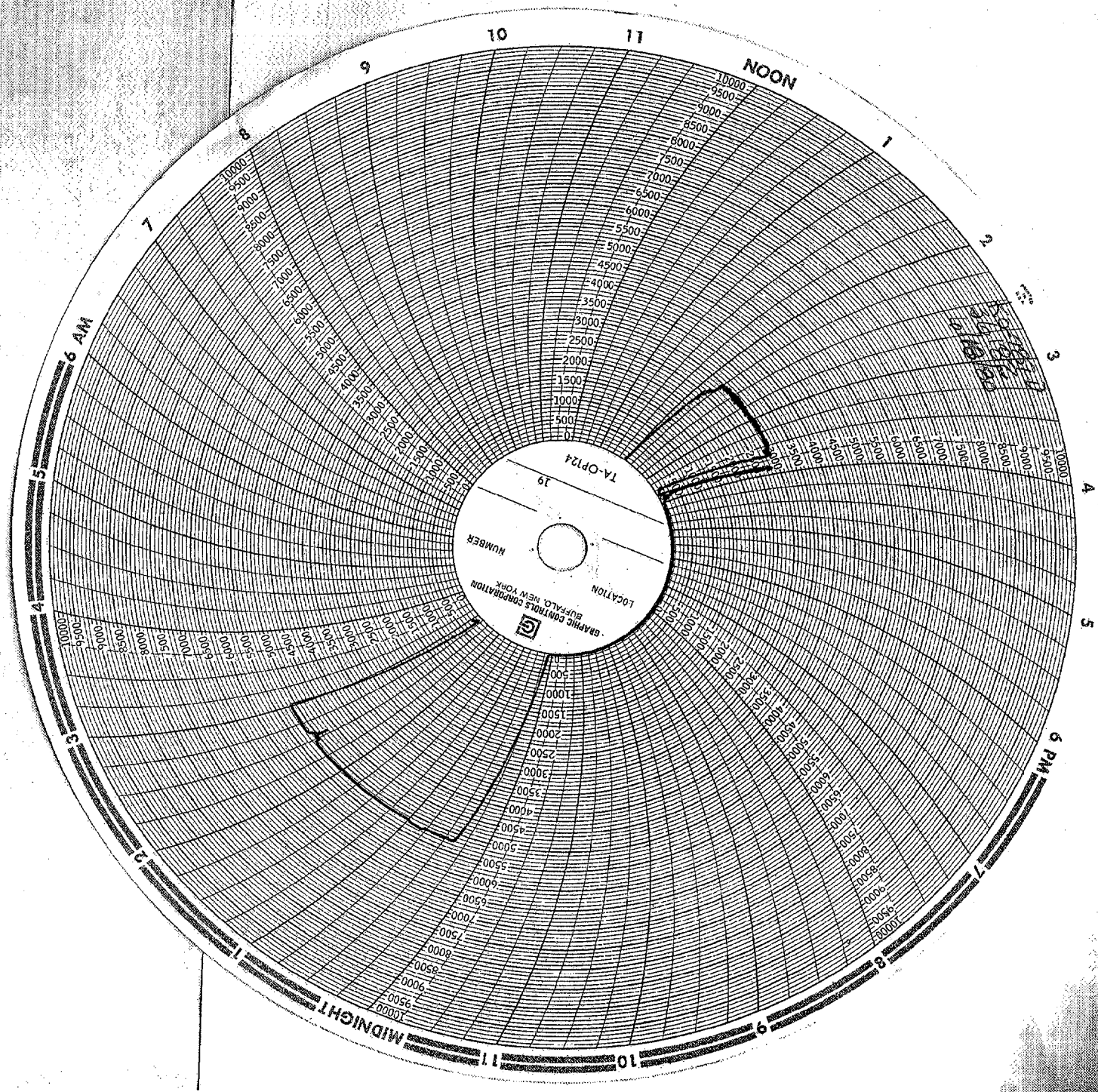
N32311.01



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

N32311.02

DUP050457526



N32311.03

DUP050457527

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