

CG 04 CODE K0789D PKG

PROCESSES

APPROVED BY

EST'D WGT 1032 LBS

() K0789D

(I)

FWP 4/28/80

STANDARD HRS. 10.8 TIME 7:48 M

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TYPED BY: FWP 4/28/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	34657	700#
01	YC016B	93	34118	350#
01	YC016B	93	34836	3150#

V-247 'M'T' 1:45/150

Homog #2

TOTAL EST'D WGT 5232

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON & HIGH SPEED.			
208	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MINS	84X50	YC16B	4200
	RECORD: START <u>8:30 AM</u> LOT <u>34657</u>	<u>14</u>		
1	FIN <u>9:45 AM</u> <u>34118</u>	<u>7</u>		
		<u>34836</u>	<u>63</u>	
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU			
	HIMOG AT 2800-3200 PSI INTO V-208			
	6 WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN			
	OF HOT WATER AT 2800-3200 PSI INTO V-208			
	7 RECORD: V-208 VOL. <u>40</u> " & ADJUST TO .54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 G) WATER INTO V-247 & START			
	AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START <u>1:55 AM</u> TOTAL MINUTES <u>2:20</u>			
2	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			
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: <u>1.086</u> /ML (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19 RECORD: PH <u>10.7</u> & ADJ TO 11.1-11.3 USING N-7-D			
4	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	<u>16</u>	7-D	<u>8</u>
	SIPHON N-7-D INTO SV & RECORD: PH <u>11.2</u>			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT <u>185</u> *F			
	& RECORD: <u>192</u> *F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON			
	COMPLETION OF HEATING.			

EQUIP	PAGE 2	CG 04	KD-789-D	EST WGT 52324	USE LBS	N- CODE	USE LBS
V-247							
343	121	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343					
&	122	METER IN FROM V-386 M34-10-88/GAL, 36.0				27-D	390
386	123	STIR 15 MIN OR LONGER					
5	124	RECORD: DENSITY 1.019 GM/ML (1.018-1.020)					
125	125	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.1					
126	126	SET V-343 ACID PUMP AT 65 SETTING (255 MIN)					
127	127	SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)					
128	128	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV					
SV	129	AT 190-194°F DURING STRIKE.					
129	129	RECORD: START FINISH MINUTES					
		V-343	6:50	Am		265	
		V-349					
		TIME	V-343	V-349	SV	NORMAL	
			INCHES	INCHES	PH	PH	
		AT 20 MIN	7:10 (49) 514	(20) 20	10.0	(9.3-10.0)	
		40 MIN	7:30 (45) 47	(18) 18	10.0	(9.3-10.0)	
		1 HR	7:50 (41) 43	(16) 16	10.0	(9.3-10.0)	
		2 1/4 HR	9:15 (25) 29	(8) 8	9.9	(9.3-10.0)	
		3 1/2 HR	10:20 (9) 12	(0) 1/2	9.5	(9.3-10.0)	
		FINISH	11:05 (0)		6.9	(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	130	RUN 73" (238 G) WATER INTO V-356 & HEAT TO					
7	131	135-140°F					
	132	DUMP IN & STIR TO DISSOLVE			530	15-A	530
302	133	ADD 42" (514 G) WATER TO V-302					
8	134	ADD & STIR 2 MIN			330	7-D	165
SV	135	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING.					
9	136	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR.					
	137	STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM					
	138	RECORD: START 11:10 Am					
	139	RUN IN V-356 FROM S 31 & STIR 5 MIN					
	140	RECORD: PH 3.8 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH					
	141	NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140°F IN DRUM, USE 30 GAL WATER TO 50#					
	142	N-15-A. STIR SV 5 MIN AFTER EACH ADDITION					
	143	RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN					
	144	RECORD: PH 5.0 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4 & RECORD: PH 6.4					27-D
	145	DILUTE N-7-D 10 TO 1 WITH WATER					7-D
	146	SIPHON N-7-D INTO SV					
	147	POUR IN STIR 15 MIN			50	978-A	50
	148	STOP AGITATOR					
		START	FINISH	OPERATOR			
		7:30 Am	9:45 Am	358			
		11:00 P	11:10 P	54-301			
		7:00 Am	7:00 A	235-37			
			12:30 Am	483 +201			

WAREHOUSE REQUEST FORM

REQUEST NO. 3409
5/19/80

DELIVER TO MARKING AREA BY 5:21:00 7 AM/PM

FOR: CG 04 CODE K0789D LOT 35836 SCHEDULED 5/19/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
35 P7	01	YC016B	93	34657	700		14	50	700	-----
BAY 1	01	YC016B	93	34118	350		7	50	350	-----
R.M.	01	YC016B	93	34836	3150		63	50	3150	-----

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

WAREHOUSE REQUEST FORM

REQUEST NO. 342
5/19/80

DELIVER TO MAKING AREA BY 3:21:00 7 AM/PM

FOR: CG 04 CODE K0789D LOT 35836 SCHEDULED 5/19/80

WHSE LOCATN	CG	CODE	PR	LOT	DRY WEIGHT	DRY CNT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
35 P7	01	YC016B	93	34657	700		14	50	700	_____
BAY 1	01	YC016B	93	34118	350		7	50	350	_____
R.M.	01	YC016B	93	34836	3150		63	50	3150	_____

PICK UP AND RETURN TO STORAGE:

LOCATN	CG	CODE	PR	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
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V-247