

S.V. 246 (247) C.V. D.V.
 CG 04 CODE KO-789-D 480 37718 PROCESSES APPROVED BY
 EST'D WGT 1032 LBS () KO-789-D (1) FWP 9/18/80
 STANDARD HRS. 10.8 TIME 17 A M () ()
 TYPED BY: FWP 9/18/80

CG CODE PQ LOT LBS
 01 YC016B 93 36121 1100
 01 YC016B 93 36349 1000
 01 YC016B 93 36404 2100

PUNCHED & CHECKED

NOV - 7 1980

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

EQUIP	NAME : "KROLOR" DRANGE Y	USE LBS	NCODE	ACCT LBS
211 & 208	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM AND POUR IN	530	983 32-D	530
	3 DUMP IN AND STIR 5 MIN	84X50	YC16B	4200
	RECORD: START 3:20 AM	11.00		
	FIN 6 AM	1.000		
	4 ADJUST TO 75" (1275 G)	2100		
	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. 40 " & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
SV	1 RUN 10" (514 G) WATER INTO V-247, START AGITATOR & INSTALL TEMP CHART			
	2 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 8:30 AM TOTAL MINUTES 135			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
	11 WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349 & 384	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F	2545	983 32-D	2545
	14 WEIGH INTO V-384 & PUMP TO V-349			
	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: 1.083 G/ML (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19 RECORD: PH 12.17 ADJ TO 11.1-11.3 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4	20 ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH 11.1	4	721 50	4
	21 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 192°F			
	& RECORD: 192°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34658

V-247

343	121	WHILE HEATING SV, RUN (1430 G) WATER INTO V-343		
&	122	METER IN FROM V-386	66.9053/GAL, 43.1 GAL	27-D 390
386	123	STIR 15 MIN OR LONGER		
5	124	RECORD: DENSITY 1.019 G/ML (1.018-1.020)		

SV	125	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0		
	126	SET V-343 ACID PUMP AT 65 SETTING (255 MIN)		
	127	SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)		
	128	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE		
	129	RECORD: START FINISH MINUTES		
		V-343 2:00 PM 6:20 PM 2.60		
		V-349 2:00 PM 5:45 PM 2.10		
		TIME V-343 V-349 SV NORMAL		
		INCHES INCHES PH PH		
		AT 20 MIN 2.20 (49) 4.9 (20) 2.0 9.8 (9.3-10.0)		
		40 MIN 2.40 (45) 4.5 (18) 1.8 9.8 (9.3-10.0)		
		1 HR 2.40 (41) 4.5 (16) 1.6 9.8 (9.3-10.0)		
		2 1/4 HR 2.15 (25) (8) 2.5 (9.3-10.0)		
		3 1/2 HR 2.15 (9) (0) 2.1 (9.3-10.0)		
		FINISH 6:15 (0) 7.0 (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	130	RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140°F		
7	131	DUMP IN & STIR TO DISSOLVE	530	15-A 530

302	132	ADD 42" (514 G) WATER TO V-302		
8	133	ADD & STIR 2 MIN	165	721 165

SV	134	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING		
9	135	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR		
	136	STIR 30 MIN AT 190-194°F THEN TURN OFF STEAM		
	137	RECORD: START 6:20 PM		
	138	RUN IN V-385 FROM S 31 & STIR 5 MIN		
	139	RECORD: PH 3.3 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & 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		
	140	RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN		
	141	RECORD: PH 4.0 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH 6.3		27-D
		DILUTE N-7-D 10 TO 1 WITH WATER	22	721 22
	142	SIPHON N-7-D INTO SV		
	143	POUR IN STIR 15 MIN	50	978-A 50
	144	STOP AGITATOR		

START	FINISH	OPERATOR
11:00 PM	3:00 PM	381-282
3:00 PM	9:00 PM	54-26

WAREHOUSE REQUEST FORM

REQUEST NO. 3525
11/03/80

DELIVER TO Making Area BY 11/4/80 3 AM

FOR: CG 04 CODE K0789D LOT 37718 SCHEDULED 11/03/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
35BLD	01	YC016B	93	36121	1100		22	50	1100	
BAY 3	01	YC016B	93	36349	1000		20	50	1000	
P2-SEC	01	YC016B	93	36404	1000 2100		20 42	50	1000 2100	

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. 3595
11/03/80DELIVER TO Making Area BY 11/4/80 3 AM

FOR CG 04 CODE K0789D LOT 37718 SCHEDULED 11/03/80

WITSE# LOCATN	CG	CODE	FR	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
35BLD	01	YC016B	93	36124	1100		22	50	1100	
BAY 3	01	YC016B	93	36349	1000		20	50	1000	
P2-JEC	01	YC016B	93	36404	1100 2100		22 42	50	1100 2100	

PICK UP AND RETURN TO STORAGE:

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

EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE 11/4/80COPY-1 PROD. CONTROL
COPY-2 MANUFACTURING
COPY-3 WAREHOUSE
COPY-4 RAW MATERIAL



