

CG 04 CODE KU-786-D 80 38430

EST'D WGT 862 LBS

STANDARD HRS. 10.5 TIME

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PROCESSES - APPROVED BY
() KO-786-D (P) FWP 11/20/80

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JOB NAME: 04KO786DMP

CG	CODE	PQ	LOT	LBS
01	YC010B	93	36262	2500
01	YC010B	93	36785	1600
01	YC010B	93		

Note

PUNCHED & CHECKED

JAN 1 1981

TOTAL EST'D WGT 4962

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACCT LBS
211	✓ RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15
208	2 ✓ WEIGH IN DRUM AND POUR IN 3 ✓ DUMP IN AND STIR 5 MIN	280 82X50	983-D YC10B	280 4100
1	RECORD: START <u>11:30</u> LOT <u>36262</u> FIN <u>1:07</u> <u>36785</u>			
4	✓ ADJUST TO 75" (1275 G) WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208 6 ✓ WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208 7 ✓ RECORD: V-208 VOL. <u>45</u> " & ADJUST TO 50" (1840G) 8 ✓ INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 ✓ RUN 15" (771 G) WATER INTO V- 211 , START & AGITATOR & INSTALL TEMP CHART SV 10 ✓ PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>7:00 PM</u> TOTAL MINUTES <u>120</u> 2 ✓ 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	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	2450	983-D	2450
3	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: <u>1.079</u> G/ML (1.078-1.081)			
SV	18 ✓ WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G) 19 ✓ RECORD: PH <u>10.5</u> & ADJ TO 10.4-10.8 USING N-7-D 4 ✓ DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH <u>10.5</u>		7-D	
20	✓ HEAT TO 190-194°F IN 55-65 MIN & REC: HT <u>192</u> °F & RECORD: <u>192</u> °F			

N34552

			V-247	LBS	CODE	LBS
343	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO				
&	22	V-343				
386	23	METER IN FROM V-386	M31 9.424/GAL 36.8 GAL		27-D	355
5	24	STIR 15 MIN OR LONGER				
	24	RECORD: DENSITY 1.018 G/ML (1.018-1.020)				
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.5				
	26	SET V-343 ACID PUMP AT 72 SETTING (225 MIN)				
	27	SET V-349 SILICATE PUMP AT 64 SETTING (180 MIN)				
SV	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV				
		AT 190-194°F DURING STRIKE				
	29	RECORD: START FINISH MINUTES				
		V-343 11:15 3:10 AM 235				
		V-349 11:20 2:20 AM 185				
		TIME V-343 V-349 SV NORMAL				
		11:15 INCHES INCHES PH PH				
		AT 20 MIN 11:35 (47) (20) 9.35 (9.3-10.0)				
		40 MIN 11:55 (43) (17) 9.4 (9.3-10.0)				
		1 HR 12:15 (38) 39+ (15) 9.4 (9.3-10.0)				
		2 HR 1:15 (24) 25 (7) 9.4 (9.3-10.0)				
		3 HR 2:15 (10) 12 (0) 9.45 (9.3-10.0)				
		FINISH 3:00 (0) 7.9 (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	

385	30	RUN 40" (308 G) WATER INTO V-385 & HEAT TO				
7		175-140°F				
	31	PUMP IN & STIR TO DISSOLVE		300	15-A	300

302	32	ADD 42" (514 G) WATER TO V-302				
8	33	ADD & STIR 2 MIN		150	7-D	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 3.5 (3.3-3.7) & IF NECESSARY ADJ			15-A	
		(DOWN ONLY) TO 3.3-3.7 & RECORD: PH				
		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 4.0 (4.0-4.2) & IF NECESSARY ADJ TO			27-D	
		PH 4.0-4.2. RECORD: PH			7-D	
		DILUTE N-7-D 10 TO 1 WITH WATER				
		SIPHON N-7-D INTO SV				
	41	STOP AGITATOR				

START	FINISH	OPERATOR
3:00 P	1:00 P	235-244
1:55 AM	3:00 PM	381
300 P	11:00 P	209
11:00 P	4:00 AM	235-244

Note: V-247 MTY AT 6:30 P.M.

MD-3-A

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE KO-786 LOT 38430

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PO
<u>2500</u>	<u>1</u>	<u>T-218</u>		
<u>2400</u>	<u>1</u>	<u>T-239</u>		

TOTAL NET WT. 4900 PKG. N-CODE 4916

PROD. SPVR. ARR DATE 1, 9, 84 WHSE. OPER.

DUP050104391

38430

41

231

0.00M0

3.56 +

0.12 -

3.58 +

0.12 -

3.58 +

0.12 -

3.53 +

0.12 -

3.73 +

0.12 -

3.64 +

0.12 -

3.75 +

0.12 -

3.74 +

0.12 -

3.65 +

0.12 -

3.85 +

0.12 -

3.55 +

0.12 -

3.48 +

0.12 -

42.20 *

38430
41
16

0.00 *

3.51 +

0.12 -

3.69 +

0.12 -

6.96 *

4716