

CG 04 CODE KD-786-D PKG 5084*
 OCT 21 1982 K2KS7 (EST WGT)
 (DATE) (LOT)

PROCESS APPROVED BY:
 () KD-786-D (P) FWP 09/08/82
 COMTYP JOBNAME: 04K0786DMP
 TIME: 11:11 AM, STANDARD HRS. 10.5

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
01	YC-16-B	98		62123	300	100.00	6	50	300	300
01	YC-10	93		H2109	2000	100.00	40	50	2000	2000
01	YC-10	93		G2H90	2000	100.00	40	50	2000	2000
01	YC-10	93								

SUBSTANDARD BLEND-BACK FOR S-40: CODE _____ LOT _____ PQ _____
 REQ. NO. (11006) NON-BLEEDING

EQUIP MENT	NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
211	*BEFORE USING SV, MAKE SURE THAT N-28-D (HYDRO-CHLORIC ACID) LINE, IF ANY IS BLANKED OFF*. RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% CAUSTIC SODA SOLN) & SET AGITATOR ON HIGH SPEED	30	7-D	15
208	WEIGH IN DRUM AND POUR IN (SODIUM SILICATE) DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE) RECORD: START 3:10 PM LOT 62123 FIN 5:30 PM H2109 G2H90	270 80X50 6X50 300 2000 2000	32-D YC10B YC16B	270 4000 300
1	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD. WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208 WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208 RECORD: V-208 VOL 4.1 & ADJUST TO 50" (1840G) INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	RUN 15" (771 G) WATER INTO V-245, START AGITATOR & INSTALL TEMP CHART			
SV	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 4:55 PM TOTAL MINUTES 150			
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	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
384	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F WEIGH INTO V-384 & PUMP TO V-349 RUN 1000# WATER INTO V-384 & PUMP TO V-349 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN RECORD DENSITY: 1.078 G/ML (1.078-1.081)	2400	32-D	2400
SV	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G) RECORD: PH 10.7 & ADJ TO 10.4-10.8 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH HEAT TO 190-194°F IN 55-65 MIN & REC: HT *F & RECORD: *F		7-D	

OCT 22 1982

10/21

EQUIP PAGE 2 CG 04 KO-786-D V.245 USE N- ACCT
MENTI LBS CODE LBS

343 WHILE HEATING SV, RUN 51" (1400 G) WATER INTO
V-343
386 METER IN (SULFURIC ACID 60%) FROM V-386
M 27, 16022 /GAL, 32.1 GAL
5 STIR 15 MIN OR LONGER
127 RECORD: DENSITY 1.017 G/ML (1.018-1.020)

125 WHEN S 20 HEATING COMPLETE, RECORD: PH 9.8
126 SET V-343 ACID PUMP AT 72 SETTING (225 MIN)
127 SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)
128 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
SV AT 190-194*F DURING STRIKE
6 129 RECORD: START FINISH MINUTES
V-343 8:45 12:00 2:35
V-349 7:00 11:45 1:00
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 9.5 (47) 48 (20) 9.5 (9.3-10.0)
40 MIN 9.25 (43) 44 (17) 17 9.25 (9.3-10.0)
1 HR 9.45 (38) 39 (15) 14 9.45 (9.3-10.0)
2 HR 10.45 (24) 25 (7) 7 10.45 (9.3-10.0)
3 HR 11.45 (10) 12 (0) 0 11.45 (9.3-10.0)
FINISH 12:30 0 0 12:30 (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

385 120 ADD 67" (514 G) WATER TO V-385
7 121 ADD & STIR 2 MIN 150 7-D 75

SV 132 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
8 133 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
134 TURN OFF STEAM
135 RUN IN LIQUID ALUM USING BADGER METER 408 600 115-D 300
136 FLUSH ALUM LINE WITH WATER.
137 RECORD: PH 3.7 (3.3-3.7) & IF NECESSARY ADJ
(DOWN ONLY) TO 3.3-3.7 & RECORD: PH
NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA
BADGER METER. STIR 5 MIN AFTER EACH
ADDITION. ASSUME 50% 115-D
138 RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN
139 RECORD: PH 4.5 (4.0-4.2) & IF NECESSARY ADJ TO
PH 4.0-4.2. RECORD: PH 4.2 ASSUME 77% 14 27-D 12
DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 7-D
SIPHON N-7-D INTO SV
140 WHEN SCHEDULED ON TOP OF PAGE 1, DUMP IN
SUBSTANDARD TO BE BLENDED BACK.
RECORD: CODE LOT

141 STOP AGITATOR
START FINISH OPERATOR
7:00 AM 3:00 PM 2:37-4:09
11:00 AM 11:00 AM 3:2-3:42
11:00 AM 12:00 PM 12:00 PM

WAREHOUSE REQUEST FORM

REQUEST NO. 11006
10/18/82DELIVER TO Making BY 10/21/82 11 AM/PM

FOR: CG 04 CODE K07B6D LOT K2K87 SCHEDULED 10/21/82

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
TEMP	01	YC016B	98	G2J23	300		6	50	300	-----
BAY 4	01	YC010B	93	H2L09	2000		40	50	2000	-----
BAY 2	01	YC010B	93	G2H90	2000		40	50	2000	-----

PICK UP AND RETURN TO STORAGE:

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

EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____

DATE ____/____/____

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

