

CG 04 JUL 9 80 36464 86-D HONCHED & CHLORED PROCESSES APPROVED BY () KO-786-D (P) FWF 5/22/80

EST'D WGT 862 LBS

JUL 1 1980

STANDARD HRS. 10.5 TIME

7 AM

TYPED BY: FWF 5/22/80

CG	CODE	PQ	LOT	LBS
01	YC010B	93	34410	1000
01	YC010B	93	33484	1500
01	YC010B	93	36140	1600
			36216	1000

**CLEAN UP
AS YOU GO ALONG**

Homog #2

TOTAL EST'D WGT 4962

REQ. NO. (

JUL 10 1980

NON-BLEEDING

EQUIP	NAME	USE LBS	NCODE	ACCT LBS
	"KROLOR" ORANGE R			
211	1 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	270	32-D	270
	RECORD: START 10:30 A.M. LOT 33484 FIN 12:30 P.M. 36140 36216	1500 1600 1000	YC10B	4100
	4 ADJUST TO 75" (1275 G)			
	5 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. 54 " & ADJUST TO 50" (1840G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 15" (771 G) WATER INTO V-208, START & AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 7:10 P.M. 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	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	2400	32-D	2400
	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: 1.081 G/ML (1.078-1.081)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)			
	19 RECORD: PH 11.0 & 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%		7-D	
	SIPHON N-7-D INTO SV & RECORD: PH			
	20 HEAT TO 190-194°F IN 55-65 MIN. & REC: HT 182°F & RECORD: 194°F			

1704010

V-247

LBS CODE LBS

343	121	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343			
&	122	METER IN FROM V-384	M 41, 10.25/GAL	32.7 GAL	27-D 355
386	123	STIR 15 MIN OR LONGER			
5	124	RECORD: DENSITY 1.018 G/ML ()			
	125	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.2			
	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 AT 190-194°F DURING STRIKE			
SV	129	RECORD: START FINISH MINUTES			
		V-343 11:45/A	2:50P	1:05	
		V-349			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 12:05 (47) (20) 10.0 (9.3-10.0)			
		40 MIN 12:25 (43) 44 (17) 10.0 (9.3-10.0)			
		1 HR 12:45 (38) 39 (15) 10.0 (9.3-10.0)			
		2 HR 1:14.5 (24) 26 (7) 10.0 (9.3-10.0)			
		3 HR 2:14.5 (10) 12 (0) 9.95 (9.3-10.0)			
		FINISH 3:30 (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	130	RUN 31" (238 G) WATER INTO V-385 & HEAT TO 135-140°F			
7	131	DUMP IN & STIR TO DISSOLVE	300	15-A	300

302	132	ADD 42" (514 G) WATER TO V-302			
8	133	ADD & STIR 2 MIN	150	7-D	75

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	TURN OFF STEAM			
	137	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	138	RECORD: PH 3.6 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & 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			
	139	RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN			
	140	RECORD: PH 4.5 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH 4.1	ASSUME 77%	10	27-D
		DILUTE N-7-D 10 TO 1 WITH WATER	ASSUME 50%		7-D
		SIPHON N-7-D INTO SV			
	141	STOP AGITATOR			

START

FINISH

OPERATOR

12:20P

3:00P

235

1:00P

2:00P

126

7:00A

3:00P

235-144

3PM

445

223-282

WAREHOUSE REQUEST FORM

REQUEST NO. 3497
7/08/80

DELIVER TO MAKING AREA BY 7/9/80 7 AM/PM

FOR: CG 04 CODE K0786D LOT 36464 SCHEDULED 7/07/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
BAY 1	01	YC010B	93	<u>36216</u> 34410	1000		20	50	1000	-----
BAY 3	01	YC010B	93	33484	1500		30	50	1500	-----
BAY1	01	YC010B	93	36140	1600		32	50	1600	-----

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