

CG 04 CODE KD-786-D PKG

PROCESSES

APPROVED BY

EST'D WGT 862 3625/

() KD-786-D (P) FWP 5/22/80

STANDARD HRS. 10.5 TIME

7: P M

TYPED BY: FWP 5/22/80

CG	CODE	PQ	LOT	LBS
01	YC010B	93	34414	1700
01	YC010B	93	35780	2400
01	YC010B	95	73241	50

Homog #2

CLEAN UP
AS YOU GO ALONG
PUNCHED & CHECKED

Rec'D VAT 247
AT 4:00 A.M.

will look yellow

TOTAL EST'D WGT 4962 5012

REQ. NO. (

JUN 30 1980

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACCT LBS
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 RECORD: START 5:50 AM FIN 9:00	270 83 2X50 1700 50 2400	32-D YC10B	270 4400 4/50
	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 HDT WATER AT 1800-2200 PSI INTO V-208 RECORD: V-208 VOL. 40 & ADJUST TO 50" (1840G) 7 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	8 RUN 15" (771 G) WATER INTO V-247, START & AGITATOR & INSTALL TEMP CHART			
SV	110 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 4:40 A TOTAL MINUTES 90			
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	112 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349 & 113 RUN 1000# WATER INTO V-384 & HEAT TO 110-120*F			
384	114 WEIGH INTO V-384 & PUMP TO V-349 115 RUN 1000# WATER INTO V-384 & PUMP TO V-349	2400	32-D	2400
3	116 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN 117 RECORD DENSITY: 1.079 G/ML (1.078-1.081)			
V	118 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G) 119 RECORD: PH 10.0 & ADJ TO 10.4-10.8 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%			
4	SIPHON N-7-D INTO SV & RECORD: PH	18	7-D	9
20	HEAT TO 190-194*F IN 55-65 MIN. & REC: HT & RECORD: *F			

35 BAGS
To Go

INCHES

V-247

LBS

CODE

LBS

343	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343			
386	22	METER IN FROM V-386	M39	1694 #/GAL	32.4 GAL
5	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.018 G/ML ()			

27-D

355

SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.6			
	26	SET V-343 ACID PUMP AT 72 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE			

RECORD:	START	FINISH	MINUTES
V-343	8:30P	12:15P	225
V-349	8:30P	11:30A	180

TIME	V-343	V-349	SV	NORMAL
	INCHES	INCHES	PH	PH
AT 20 MIN	8.50 (47)	(20)	9.65	(9.3-10.0)
40 MIN	9.10 (43)	(17)	9.7	(9.3-10.0)
1 HR	9.10 (38)	(15)	9.7	(9.3-10.0)
2 HR	10.30 (24)	(7)	9.8	(9.3-10.0)
3 HR	11.30 (10)	(0)	9.8	(9.3-10.0)
FINISH	12.15 (0)	(0)	7.2	(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 31" (238 G) WATER INTO V-385 & HEAT TO 135-140°F			
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131		PUMP IN & STIR TO DISSOLVE			
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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			
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9	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
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34		TURN OFF STEAM			
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37		RUN IN V-385 FROM S 31 & STIR 5 MIN			
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38		RECORD: PH 3.4 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & RECORD: PH			
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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

39		RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN			
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40		RECORD: PH 4.0 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH			
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ASSUME 77%

27-D

		DILUTE N-7-D 10 TO 1 WITH WATER			
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ASSUME 50%

7-D

		SIPHON N-7-D INTO SV			
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41		STOP AGITATOR			
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START

7A

AM

2:00P

FINISH

3P

7:00AM

1:45P

OPERATOR

120-54

381-223

126-259

WAREHOUSE REQUEST FORM

REQUEST NO 3475
6/20/80

DELIVER TO MAKING AREA BY 6/23/80 7 PM

FOR: CG 04 CODE K0786D LOT 36254 SCHEDULED 6/20/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
NL	01	YC010B	93	34414	1700		34	50	1700	-----
BAY 1	01	YC010B	93	35780	2400		48	50	2400	-----
TEMP	01	YC010B	98	73241	50				50	-----

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



