

CG 04 CODE KO-789-D PKG

PROCESSES

APPROVED BY:

NOV 9, 1982

L2J55

5179*

() KO-789-D (I)

FWP 11/04/82

(DATE)

(LOT)

(EST WGT)

COMTYP JOB NAME: 04KO789DMI

WAREHOUSE REQUEST NO. 11027

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
01	YC016B	93		12J83	1000	100.00	20	50	1000	1000
01	YC016B	93		12J86	3200	100.00	64	50	3200	3200
01	YC016B	93				100.00		50		
01	YC016B	93				100.00		50		
01	YC016B	93				100.00		50		

EQUIP	NAME : "KROLOR" ORANGE Y	NON-BLEEDING	USE LBS	N-CODE	ACCT LBS
211	1	*BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF.			
208	2	RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
	3	WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)	530	32-D	530
		DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE)	84X50	YC16B	4200
		LOT			
		RECORD: START 3:50 PM. 12J83	1000		
		FIN 4:45 PM. 12J86	3200		
	4	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
		RECORD PH: 10.6 (9.0-10.5)			
	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. 79" & ADJUST TO 54" (1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9	RUN 10" (514 G) WATER INTO V-246 START			
SV	10	AGITATOR & INSTALL TEMP CHART			
		PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START 4:30 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			
384	13	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
	14	WEIGH INTO V-384 & PUMP TO V-349	2545	32-D	2545
	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: 1.085 G/ML (1.082-1.086)			
SV	18	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19	RECORD: PH 10.7 & ADJ TO 11.1-11.3 USING N-7-D (CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4		ASSUME 50%			
		SIPHON N-7-D INTO SV & RECORD: PH 11.3	10	7-D	5
20		HEAT TO 190-194°F IN 55-65 MIN & RECORD: 191 *F			
		& RECORD: 192 *F. STRIKE MUST START IMMEDIATELY			

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EQUIP MENT		PAGE 2 CG 04 KO-789-D	USE LBS	N- CODE	ACCT LBS
343 & 386 5	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343			
	22	METER IN (SULFURIC ACID 60%) FROM V-386	353	27-D	390
	23	M28, 1/4 GAL, 35 GAL			
	24	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.020 G/ML (1.018-1.020)			
		NOTE: THIS PROCESS CALLS FOR N-27-D ON SURFACE.			
		BE SURE HOSE IS NOT IN UNDERSURFACE STRIKE LINE			
SV 6	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0			
	26	SET V-343 ACID PUMP AT 65 SETTING (255 MIN)			
	27	SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 V-349			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 8.20 (49) (20) 9.8 (9.3-10.0)			
		40 MIN 8.40 (45) (18) 9.2 (9.3-10.0)			
		1 HR 9.6 (41) (16) 9.7 (9.3-10.0)			
		2 1/4 HR 10.15 (25) (8) 9.6 (9.3-10.0)			
		3 1/2 HR 11.30 (9) (0) 9.4 (9.3-10.0)			
		FINISH 12.15 (0) 7.5 (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 7	30	ADD 67" (514 G) WATER TO V-385			
	31	ADD & STIR 2 MIN	2-0	330	7-D 165
SV 8	32	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
	33	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	34	STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM			
		RECORD: START 12.15			
	35	RUN IN LIQUID ALUM USING BADGER METER	1060	115-D	530
	36	FLUSH ALM LINE WITH WATER	848		
	37	RECORD: PH 3.7 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH			
		NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION.			
	38	RUN IN N-7-D FROM S31 IN 10-12 MIN & STIR 5 MIN		115-D	
	39	RECORD: PH 5.15 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH 6.4			
		DILUTE N-7-D 10 TO 1 WITH WATER		27-D	
		ASSUME 50%		7-D	25
		SIPHON N-7-D INTO SV			
	40	POUR IN (PLASTOLEIN 9746A) & STIR 15 MIN	50	978-A	50
	41	STOP AGITATOR			
		START FINISH OPERATOR			
		12:01 PM 7:00 PM 12:50 PM			
		2:00 PM 3:00 PM 4:38 PM			
		4:30 PM 7:00 PM 4:38 PM			

WAREHOUSE REQUEST FORM

REQUEST NO 11027
11/04/82

DELIVER TO Making BY 11/9/82 7 AM/PM

FOR: CG 04, CODE K0789D LOT L2J55 SCHEDULED 11/09/82

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
BAY 3	01	YC016B	93	K2J83	1000		20	50	1000	-----
BAY2	01	YC016B	93	K2H26	3200		64	50	3200	-----

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