CG 04 CODE KO-789-D PKG NOV -5 80 37730 PROCESSES APPROVED BY

EST'D WGT 1032 LBS ( ) KO-789-D (I) FWP 9/18/80

STANDARD HRS. 10.8 TIME 11 AM ( ) ( ) ( ) ( ) TYPED BY: FWP 9/18/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	36404	100
01	YC016B	93	36361	1100
01	YC016B	93	36121	2000
01	YC16B	93	36039	1000

PUNCHED & CHECKED

TOTAL EST'D WGT 5232 REQ. NO.( ) NON-BLEEDING

EQUIP		NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211 & 208	1	RUN 60"(990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.		983-D	
	2	WEIGH IN DRUM AND POUR IN	530	32-D	530
	3	DUMP IN AND STIR 5 MIN	84X50	YC16B	4200
1		RECORD: START 1230 M LOT 36404	100		
		FIN 230 AM 36361	1100		
		36121	2000		
	4	ADJUST TO 75" (1275 G) 36039	1000		
	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 56 " & ADJUST TO 54"(1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 10" (514 G) WATER INTO V-247 START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 2 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 & 384	12	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	13	RUN 1000# WATER INTO V-384 & HEAT TO 110-120*F		983	
	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: 1.084 G/ML (1.082-1.086)			
SV	18	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45"(2300 G)			
	19	RECORD: PH 10.16 & ADJ TO 11.1-11.3 USING N-7-D			
4		AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	8	721	8
		SIPHON N-7-D INTO SV & RECORD: PH 11.2			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC:HT ____*F & RECORD: ____*F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34654

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EQUIP		PAGE 2 CG 04 KD-789-D EST WGT 5232# V247	USE LBS	N-CODE	USE LBS
	21	WHILE HEATING SV, RUN 52* (1430 G) WATER INTO			
343 & 386 5	22 23 24	V-343 METER IN FROM V-386 M 67,956 #/GAL 42.6 GAL STIR 15 MIN OR LONGER RECORD: DENSITY 1020 G/ML (1.018-1.020)		27-D	390
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9			
	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			
SV	29	AT 190-194*F DURING STRIKE			
		RECORD: START FINISH MINUTES			
		V-343 7:55P 12:20AM 265			
		V-349 7:55P 11:35PM 220			
		TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH			
		AT 20 MIN 8:15 (49)___ (20)___ 10.0 (9.3-10.0)			
		40 MIN 8:35 (45)___ (18)___ 9.8 (9.3-10.0)			
		1 HR 8:55 (41)___ (16)___ 9.5 (9.3-10.0)			
		2 1/4 HR 10:10 (25)___ (8)___ 9.5 (9.3-10.0)			
		3 1/2 HR 11:25 (9) 12 (0) 14 9.5 (9.3-10.0)			
		FINISH 12:10 (0) 0 6.8 (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	RUN 40* (308 G) WATER INTO V-385 & HEAT TO 135-140*F			
	34	DUMP IN & STIR TO DISSOLVE	530	15-A	530
302 8	32 33	ADD 42* (514 G) WATER TO V-302 ADD & STIR 2 MIN	165 330	7-D	165
SV 9	34 35 36	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR STIR 30 MIN AT 190-194*F, THEN TURN OFF STEAM RECORD: START 12:20AM			
	37 38	RUN IN V-385 FROM S 31 & STIR 5 MIN RECORD: PH 2.8 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & 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			
	39	RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN			
	40	RECORD: PH 4.5 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH 6.2 ASSUME 77%		27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	30	27-D	30
		SIPHON N-7-D INTO SV			
	41	POUR IN STIR 15 MIN	50	978-A	50
	42	STOP AGITATOR			

START	FINISH	OPERATOR
3:00P 12:20AM	11:00P 2:05AM	126-120 82-244

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WAREHOUSE REQUEST FORM

REQUEST NO. 3597
11/03/80

DELIVER TO Making Area BY 11.5.80 11 A AM/[redacted]

FOR: CG 04 CODE K0789D LOT 37730 SCHEDULED 11/03/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
P2-SEC	01	YC016B	93	36404	100		2	50	100	_____
P2-SEC	01	YC016B	93	36361	1100		22	50	1100	_____
35BLD	01	YC016B	93	36121	2000		40	50	2000	_____
35-B2	01	YC016B	93	36039	1000		20	50	1000	_____

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:

_____

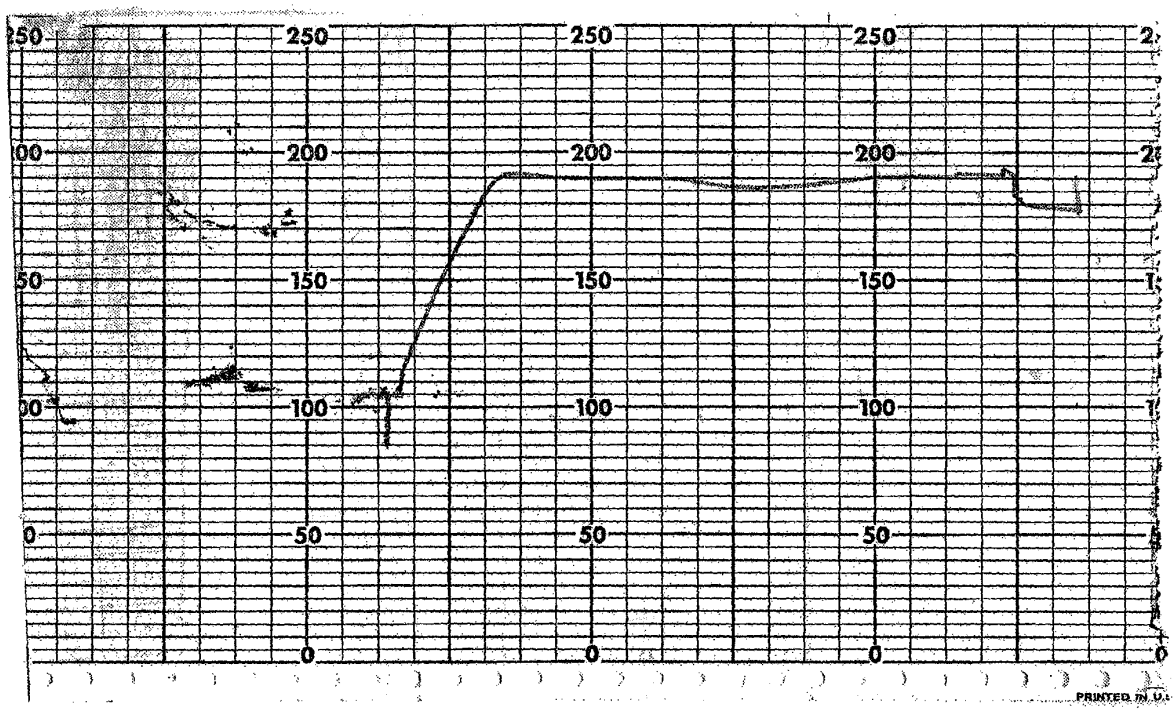
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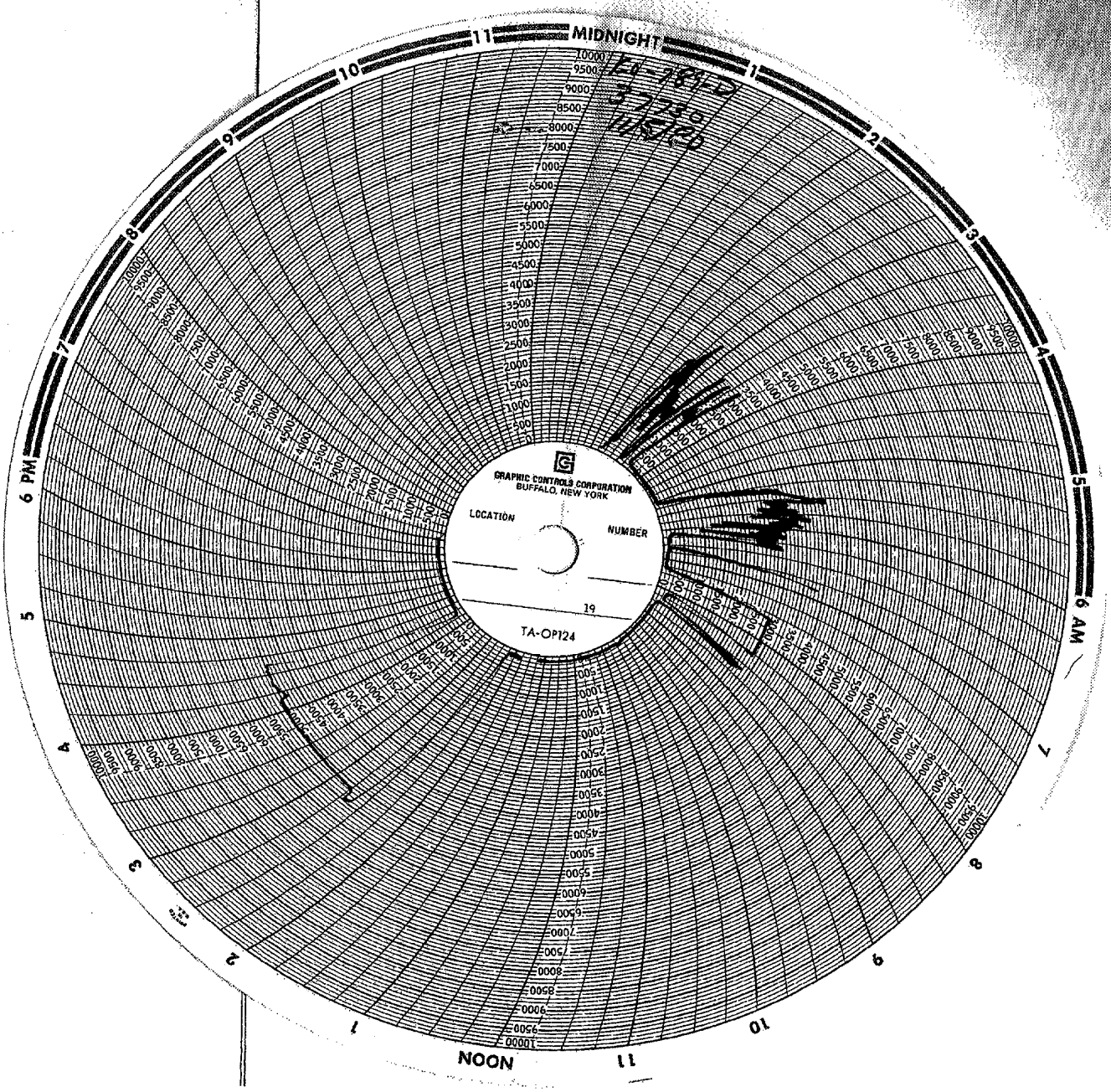
SIGNED _____ DATE __/__/__

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

DUP050104790



DUP050104791



DUP050104792