

CG 04 CODE KO-789-D PKG PROCESSES APPROVED BY
 EST'D WGT 1032 LBS MAY -0.81-31461 () KO-789-D (I) FWP 01/16/81
 STANDARD HRS. 10.8 TIME _____ M () () () ()
 JOB NAME: 04K0789-DMI

CG	CODE	PQ	LOT	LBS
01	YC016B	93	39844	850
01	YC016B	93	E1224	3000
01	YC016B	93	E1229	350
	YC-16		72335	80# (2 bags)
			E1231	850

CHARGE OUT.
CANNOT FIND

TOTAL EST'D WGT 5272 5272 REQ. NO. (10236) 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.	390		390
	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MIN	84X50	YC16B	4200
	RECORD: START 4:15 AM	2846	YC16B	80
	FIN 1:00 PM			
	4 ADJUST TO 75" (1275 G)	850		
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208	3000		
	6 WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2800-3200 PSI INTO V-208	350		
	7 RECORD: V-208 VOL. _____ & ADJUST TO 54" (1890G)	80		
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 10" (514 G) WATER INTO V-208, START AGITATOR & INSTALL TEMP CHART			
	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 4:30 TOTAL MINUTES _____			
	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			
	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: 1.024 G/ML (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19 RECORD: PH 10.2 & ADJ TO 11.1-11.3 USING N-7-D			
	4 AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	40	7-D	20
	SIPHON N-7-D INTO SV & RECORD: PH 11.3			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 192°F			
	& RECORD: PH 11.3			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

V-246

343	121	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343			
386	122	METER IN FROM V-386 M.16, 11.14/GAL, 35.0 GAL		27-D	390
5	123	STIR 15 MIN OR LONGER			
	124	RECORD: DENSITY 1.019 G/ML (1.018-1.020)			

SV	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 10:25 PM 2:33 AM 270			
		V-349 10:25 PM 2:20 AM 235			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 10:45 (49) (20) 9.5 (9.3-10.0)			
		40 MIN 11:05 (45) (18) 9.3 (9.3-10.0)			
		1 HR 11:25 (41) 7.2 (16) 9.3 (9.3-10.0)			
		2 1/4 HR 11:40 (25) 7.6 (8) 9.3 (9.3-10.0)			
		3 1/2 HR 11:55 (9) 7.0 (0) 9.3 (9.3-10.0)			
		FINISH 2:00 (0) 7.0 (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 40" (308 G) WATER INTO V-385 & HEAT TO 135-140°F			
7	131	PUMP IN & STIR TO DISSOLVE	530	15-A	530

302	132	ADD 42" (514 G) WATER TO V-302			
8	133	ADD & STIR 2 MIN	330	7-D	165

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			
LOOK	136	STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM			
		RECORD: START 2:00 AM			
	137	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	138	RECORD: PH 3.1 (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			
	139	RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN			
	40	RECORD: PH 6.2 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH	ASSUME 77%	27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER	ASSUME 50%	7-D	
	41	SIPHON N-7-D INTO SV			
	42	PUR IN STIR 15 MIN	50	978-A	50
	42	STOP AGITATOR			

START
7:00 A
3:00 PM
11:00 PM

FINISH
3:00 P
11:00 PM
5:00 PM

OPERATOR
235-244
23331
409-301

WAREHOUSE REQUEST FORM

REQUEST NO 10236
5/18/81DELIVER TO Making BY 5/18/81 AM/PM

FOR: CG 04 CODE K07890 LOT E1461 SCHEDULED 5/19/81

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
35B8	01	YC016B	93	E/231 39844	850		17	50	850	-----
35B	01	YC016B	93	E1224	3000		60	50	3000	-----
35B	01	YC016B	93	E1229	350		7	50	350	-----

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