CG 04 CODE KO789D PKG JUN-9 36047

EST'D WGT 1032 LBS

STANDARD HRS. 10.8 TIME 11A M

PROCESSES
( ) KO789D (I)
( ) ( )
( ) ( )
( ) ( )

APPROVED BY FWP 4/28/80

TYPED BY: FWP 4/28/80

CG	CODE	PQ	LOT	LBS
~~01~~	~~YC016B~~	~~93~~	~~35863~~	~~1450~~
01	YC016B	93	35788	2000
01	YC016B	93	35865	2200

Note step 29:—

PUNCHED & CHECKED

TOTAL EST'D WGT 5232 REQ. NO JUN 16 1980 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.			
	2	WEIGH IN DRUM AND POUR IN	530	32-D	530
	3	DUMP IN AND STIR 5 MINS. LOT	84X50	YC16B	4200
		RECORD: START 345PM YC16B 35788 - 2000			
1		FIN 6PM YC16B 35865 2200			
		4200			
	4	ADJUST TO 75" (1275 G)			
	5	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HIMOG AT 2800-3200 PSI INTO V-208			
	6	WHEN V-211 MTY,WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2800-3200 PSI INTO V-208			
	7	RECORD:V-208 VOL. 40 " & ADJUST TO 54"(1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 10" (514 G) WATER INTO V-245 & START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START 920 TOTAL MINUTES 180			
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: 1.084 G/ML (1.082-1.086)			
SV	18	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45"(2300 G)			
	19	RECORD: PH 10.5 & ADJ TO 11.1-11.3 USING N-7-D			
4		DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	16	7-D	8
		SIPHON N-7-D INTO SV & RECORD: PH 11.2			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC:HT 188 *F & RECORD: 194 *F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N32330

EQUIP		PAGE 2 CG 04 KO-789-D EST WGT 5232#	USE LBS	N-CODE	US LE
		V-245			
	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO			
343		V-343			
&	22	METER IN FROM V-386 M 37, 10.85#/GAL, 35.9 GAL		27-D	39
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1.01 GM/ML (1.018-1.020)			
	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			
SV		AT 190-194*F DURING STRIKE.			
	29	RECORD: START FINISH MINUTES			
No Steam.		V-343 2:00 AM 7:30 AM 260			
		V-349 6:45 AM 210			
		TIME V-343 V-349 SV NORMAL			
STOP METERING		2:00 INCHES INCHES PH PH			
3:15/AM		AT 20 MIN 2:20 (49) (20) 9.8 (9.3-10.0)			
		40 MIN 2:40 (45) (18) 9.8 (9.3-10.0)			
Restarted 4:30 AM		1 HR 3:00 (41) 42 (16) 9.8 (9.3-10.0)			
		2 1/4 HR 5:30 (25) 27+ (8) 9.8 (9.3-10.0)			
		3 1/2 HR 6:45 (9) 12 (0) 9.7 (9.3-10.0)			
		FINISH 7:30 (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	
	30	RUN 31" (238 G) WATER INTO V-385 & HEAT TO			
7		135-140*F			
385	31	DUMP IN & STIR TO DISSOLVE	530	15-A	53
302	32	ADD 42" (514 G) WATER TO V-302			
8	33	ADD & STIR 2 MIN	330	7-D	16
SV	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &			
		SET PUMP AT ZERO SETTING.			
9	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &			
		TURN OFF PUMP MOTOR.			
	36	STIR 30 MIN AT 190-194*F, THEN TURN OFF STEAM			
		RECORD: START 7:30 A.M.			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.8 (3.4-3.8) & IF NECESSARY ADJ			
		(DOWN ONLY) TO 3.4-3.8 & RECORD: PH ✓			
		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 6.4 (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	
		SIPHON N-7-D INTO SV			
	41	POUR IN STIR 15 MIN	50	978-A	5
	42	STOP AGITATOR			

START	FINISH	OPERATOR
11:00 P	7:00 A	235-37-323
7:00 A.M	9:05 AM	381

Note → STEAM DOWN 75 MIN

DUP050457595

WAREHOUSE REQUEST FORM

REQUEST NO. 3342
6/06/80

DELIVER TO Mixing Room BY 6/2/80 11 AM/[redacted]

FOR: CG 04 CODE KH7890 LOT 36047 SCHEDULED 6/05/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
35BLDG F	04	KC0108	24	35788	2000		40	50	2000	
BAY 2	01	KC0108	24	35865	2200		44	50	2200	

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:

SIGNED _____ DATE __/__/__

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

N32330.01

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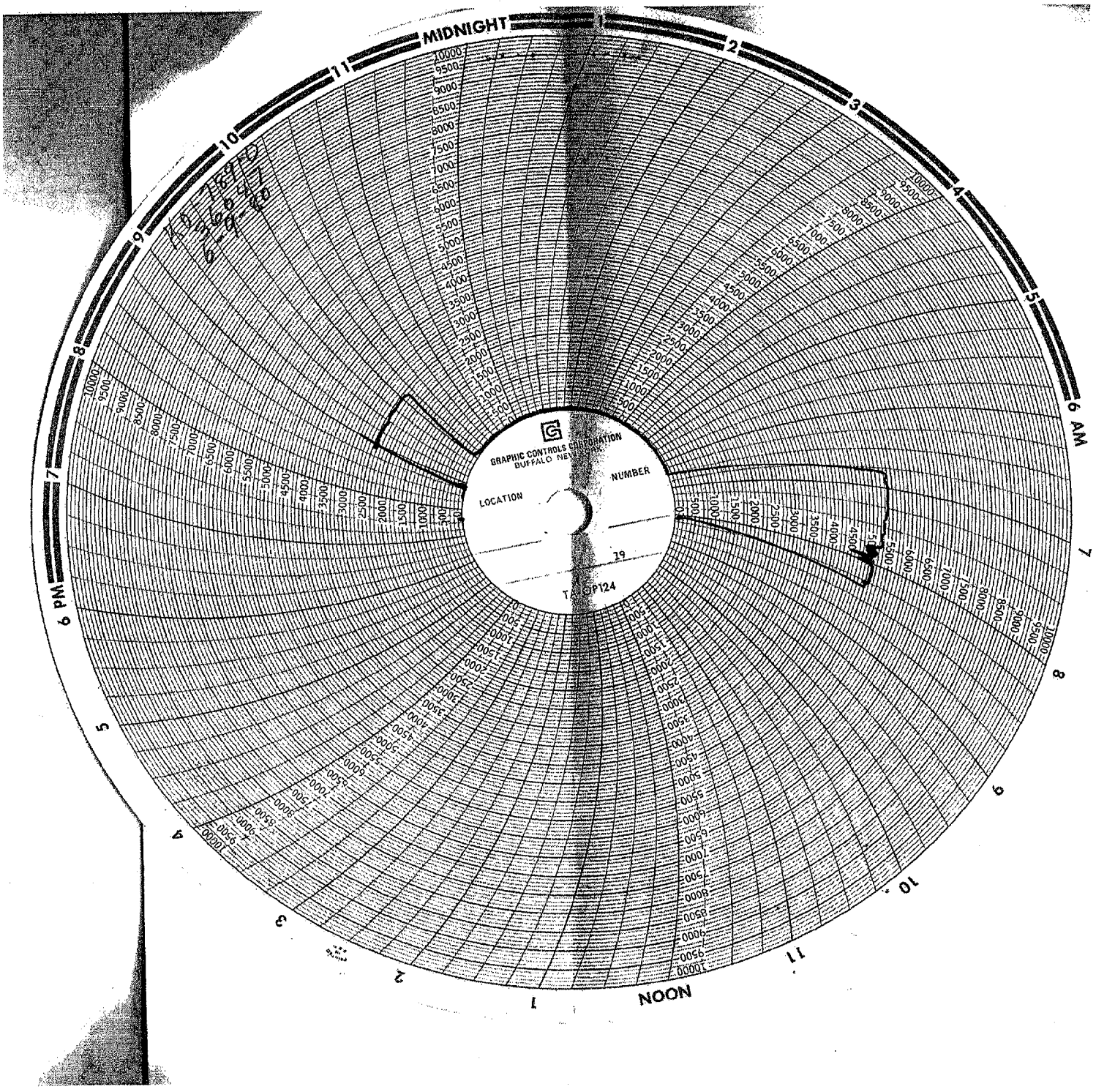

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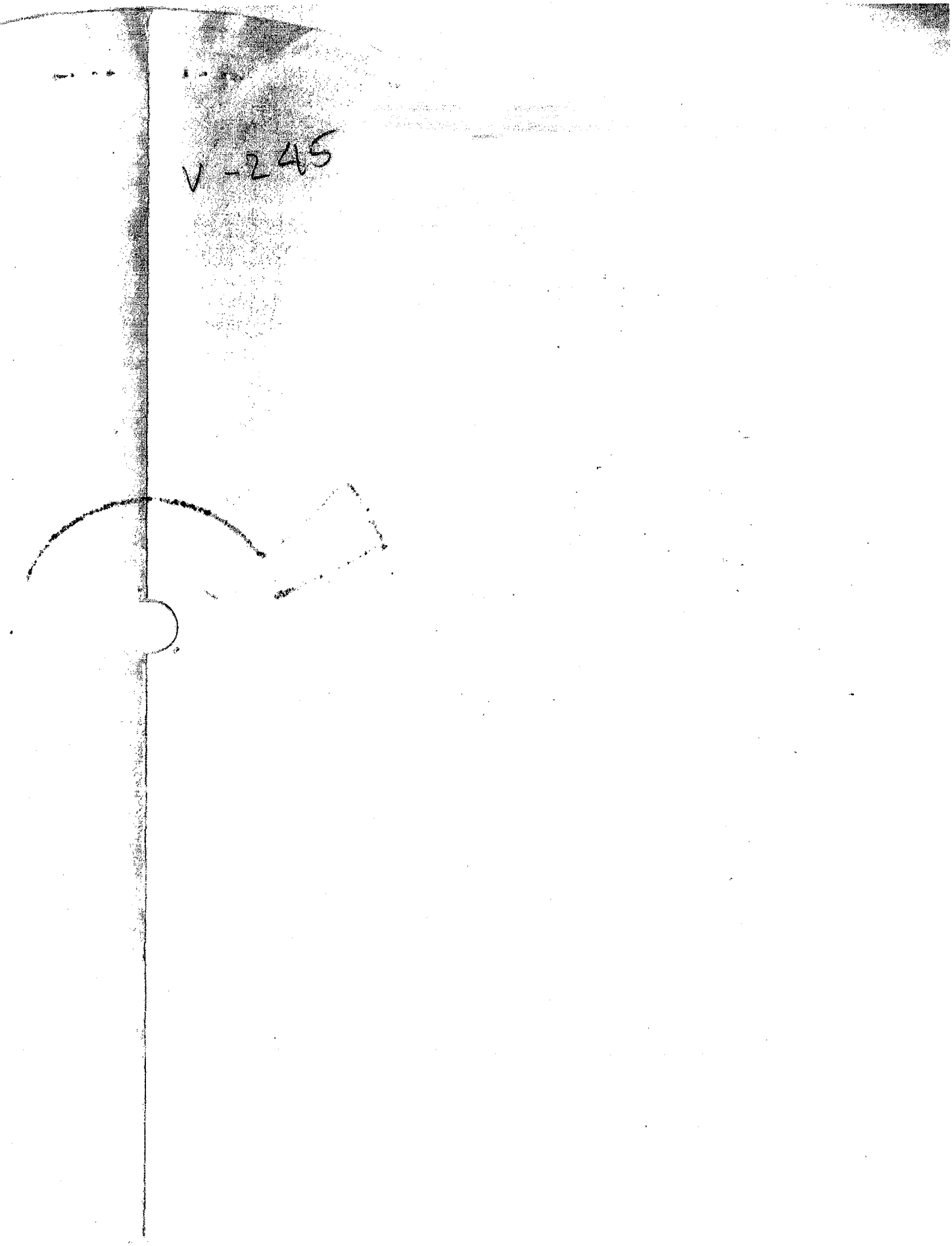
V-245



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