

CG 04 CODE K0789D 0088 PKG

PUNCHED & CHECKED

PROCESSES

APPROVED BY

EST'D WGT 1032 LBS

(I) K0789D (I)

FWP 4/28/80

STANDARD HRS. 10.8

TIME

7:45 AM - 9:30 AM

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TYPED BY: FWP 4/28/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	34572	500
01	YC016B	93	34184	1000
01	YC016B	93	35784	1200
01	YC16B	93	35785	1500

Homog #2

V-245 'M'T' AT 5:45 AM

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.			
	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MINS. LOT	84X50	YC16B	4200
	RECORD: START 11:20			
	FIN			
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU			
	6 HOMOG AT 2800-3200 PSI INTO V-208			
	7 WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN			
	8 OF HOT WATER AT 2800-3200 PSI INTO V-208			
	9 RECORD: V-208 VOL. 5.2" & ADJUST TO 54" (1890G)			
	10 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 10" (514 G) WATER INTO V-245 & START			
	10 AGITATOR & INSTALL TEMP CHART			
	11 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 5:50A TOTAL MINUTES 19:55			
	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 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	11 RECORD DENSITY: 1.083 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			
	4 DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	18	7-D	9
	SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 19.2			
	& RECORD: 19.2			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON			
	COMPLETION OF HEATING.			

N34674

EQUIP	PAGE 2	CG 04	KO-789-D	EST WGT 5232#	USE LBS	N- CODE	USE LBS
V-245							
343	421	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343					
386	422	METER IN FROM V-386	M 37	10.85# / GAL	35.9 GAL	27-D	390
5	423	STIR 15 MIN OR LONGER					
124	5	RECORD: DENSITY 1.019 GM/ML (1.018-1.020)					
25	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.7					
26	26	SET V-343 ACID PUMP AT 65 SETTING (255 MIN)					
27	27	SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)					
28	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE.					
29	29	RECORD:	START	FINISH	MINUTES		
		V-343	9:40	2:18	340		
		V-349	1:15	1:30	230		
		TIME V-343	V-349	SV	NORMAL		
		9:40 INCHES	INCHES	PH	PH		
		AT 20 MIN (49)	(20)	10.0	(9.3-10.0)		
		40 MIN (45)	(18)	10.0	(9.3-10.0)		
		1 HR 10:30 (41)	(16)	10.0	(9.3-10.0)		
		2 1/4 HR 11:55 (25)	(8)	9.8	(9.3-10.0)		
		3 1/2 HR 12:50 (9)	(0)	9.8	(9.3-10.0)		
		FINISH 1:35 (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	
350	130	RUN 34" (238 G) WATER INTO V-343 & 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.					
136	136	STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM					
137	137	RECORD: START 2:10 PM					
138	138	RUN IN V-385 FROM S 31 & STIR 5 MIN					
139	139	RECORD: PH 2.8 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH					
140	140	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					
141	141	RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN					
142	142	RECORD: PH 5.6 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4 & RECORD: PH 6.3			ASSUME 77%	27-D	
143	143	DILUTE N-7-D 10 TO 1 WITH WATER			ASSUME 50%	7-D	
144	144	SIPHON N-7-D INTO SV					
145	145	POUR IN STIR 15 MIN			50	978-A	50
146	146	STOP AGITATOR					
		START	FINISH	OPERATOR			
		3:00 PM	11:00 PM	235-323			
		11 PM	7 PM	381-223			
		7 PM	3 PM	120-126			
		3 PM	4:20 PM	144-235			

WAREHOUSE REQUEST FORM

REQUEST NO. 3432
6/03/80DELIVER TO MAKING AREA BY 6/4/80 7 AM

FOR: CG 04: CODE K0789D LOT 35988 SCHEDULED 6/02/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
35TEMP	01	YC016B	93	34572	500		10	50	500	-----
TEMP 3	01	YC016B	93	34184	1000		20	50	1000	-----
BAY 2	01	YC016B	93	35784	1200		24	50	1200	-----
BAY 1	01	YC016B	93	35785	1500		30	50	1500	-----

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 6/4/80COPY-1 PROD. CONTROL
COPY-2 MANUFACTURING
COPY-3 WAREHOUSE
COPY-4 RAW MATERIAL

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TEMP S	01	YC016B	93	34184	1000		20	50	1000	545
BAY 2	01	YC016B	93	35784	1200		24	50	1200	
BAY 1	01	YC016B	93	35785	1500		30	50	1500	

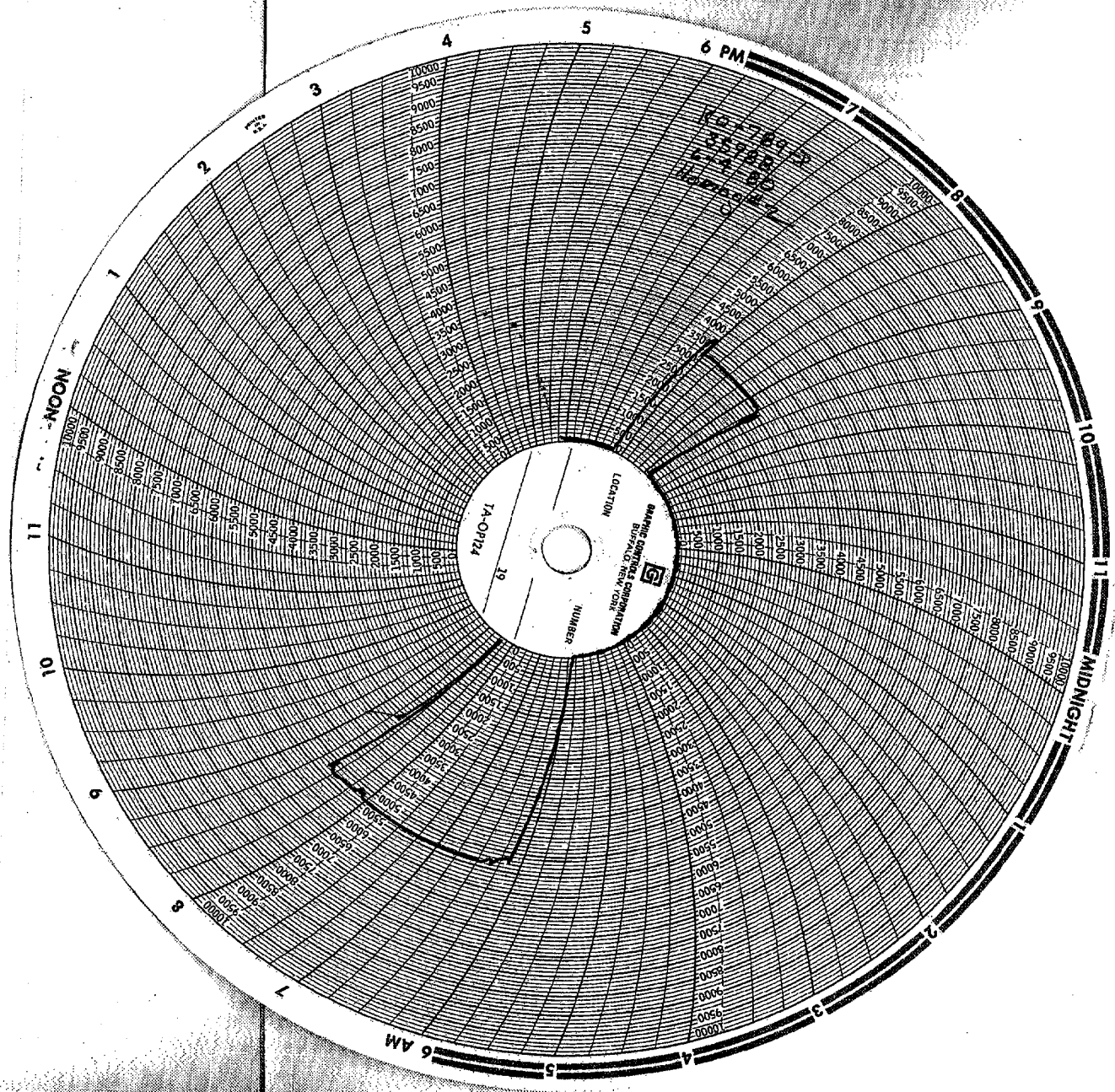
PICK UP AND RETURN TO STORAGE:

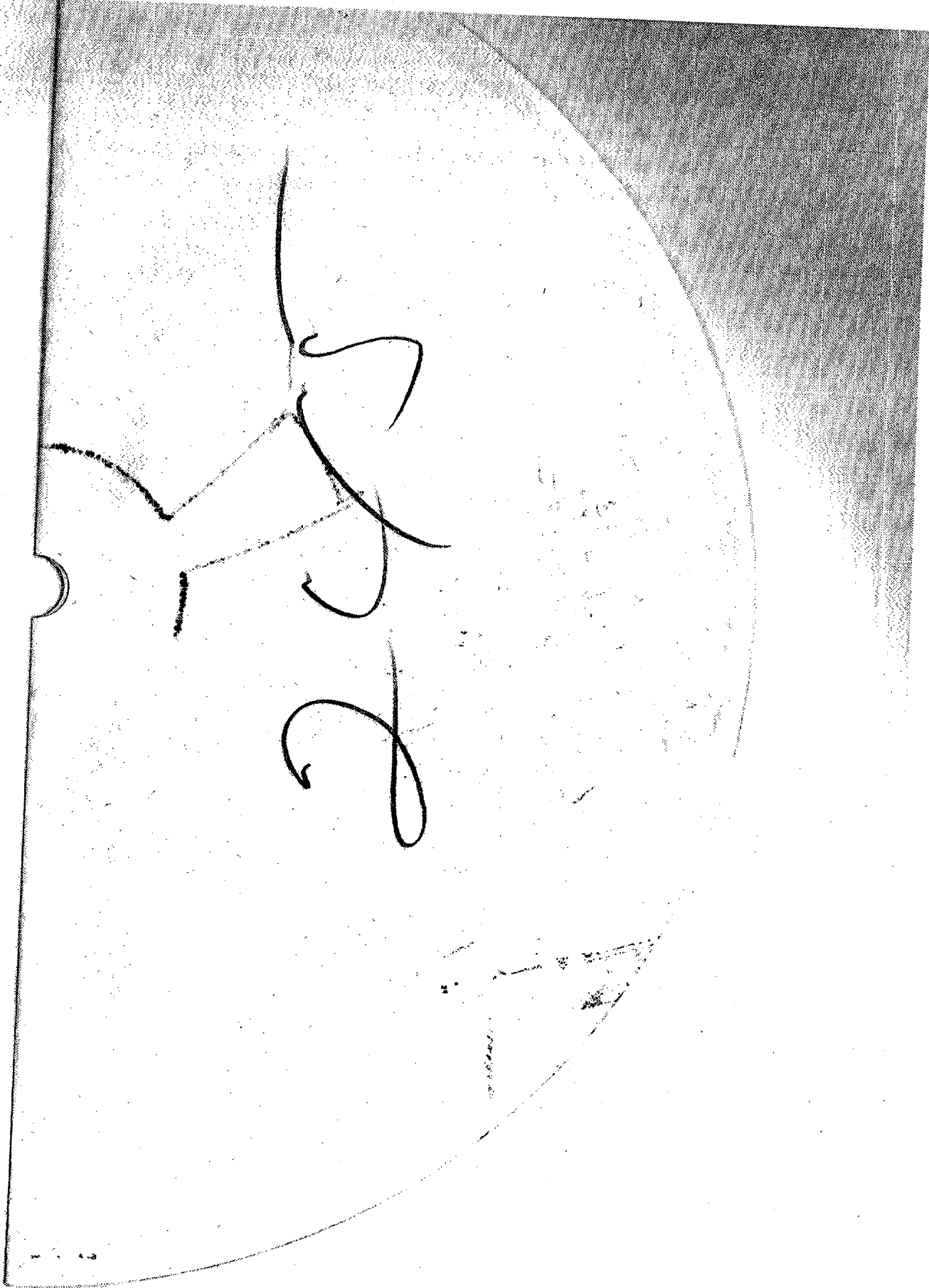
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