JUT-E 36004

EST'D WGT 1032 LBS

STANDARD HRS. 10.8 TIME 7A M

( ) K0789D (I) FWP 4/28/80
( ) ( )
( ) ( )
( ) ( )
TYPED BY: FWP 4/28/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	34185	1200
01	YC016B	93	35442	1100
01	YC016B	93	35863	1900

PUNCHED & CHECKED

JUN 10 '80

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	420¢
1		RECORD: START 1050AM 34185	1200		
		FIN 130 PM 35442	1100		
		35863	1900		
	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. 39 " & 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 110P TOTAL MINUTES 20			
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: 1.082 G/ML (1.082-1.086)			
SV	18	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45"(2300 G)			
	19	RECORD: PH 10.6 & 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 ____*F & RECORD: ____*F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N32336

EQUIP		PAGE 2 CG 04 KO-789-D EST WGT 5232# V-247	USE LBS	N-CODE	USE LBS
343 & 386 5	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343			
	22	METER IN FROM V-386 M37 10.85#/GAL 35.9 GAL	35.9	27-D	390
	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.019 GM/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 5:30 PM 9:00 PM 310 V-349 220 TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH AT 20 MIN 5:40 (49) 49 (20) 20 9.8 (9.3-10.0) 40 MIN 6:00 (45) 45 (18) 18 9.8 (9.3-10.0) 1 HR 6:30 (41) 42 (16) 16 9.8 (9.3-10.0) 2 1/4 HR 7:35 (25) 36 (8) 8 9.8 (9.3-10.0) 3 1/2 HR 8:50 (9) 11 (0) 0 9.8 (9.3-10.0) FINISH 9:35 (0) 0 — 6.1 (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	_____
~~356~~ 7	30	RUN 33" (238 G) WATER INTO V-~~356~~ 385 & HEAT TO 135-140*F			
385	31	DUMP IN & STIR TO DISSOLVE	530	15-A	530
302 8	32	ADD 42" (514 G) WATER TO V-302			
	33	ADD & STIR 2 MIN	330	7-D	165
SV 9	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING.			
	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 9:50 PM			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 2.9 (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 6.3 (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	50
	42	STOP AGITATOR			

START	FINISH	OPERATOR
10:30A	1 PM	35
7:00A	3:00P	209-126
[illegible]	11:00P	[illegible]

DUP050457615

WAREHOUSE REQUEST FORM

REQUEST NO. 3436
6/04/80

DELIVER TO Making Area BY 6/5/80 7 AM

FOR: CG 04 CODE K0789D LOT 36004 SCHEDULED 6/03/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
TEMP S	01	YC016B	93	34185	1200		24	50	1200	
BAY 1	01	YC016B	93	35442	1100		22	50	1100	
BAY 1	01	YC016B	93	35863	1900		38	50	1900	

PICK UP AND RETURN TO STORAGE:

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT

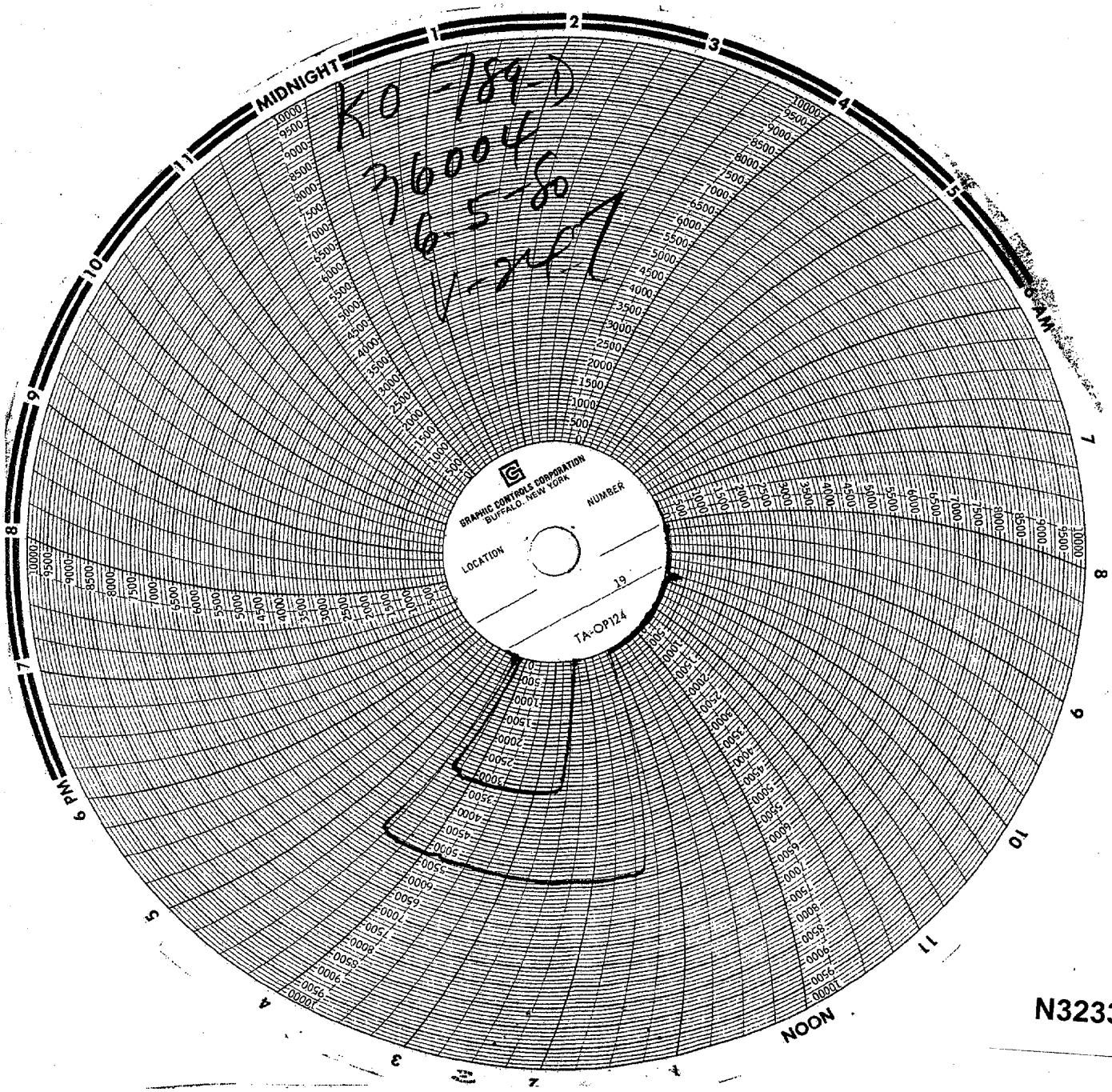
EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE __/__/__

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

N32336.01

DUP050457616



KO-789-D
76004
6-5-80
V-24-A

N32336.02

DUP050457617