CG 04 CODE KO-906-D PKG OK/RP PROCESSES APPROVED BY
SEP 28 1982 K21129 5008* TIME 7 A M. ( ) KO-906-D (C) FWP 06/14/82
(DATE) (LOT) (EST WT) COMTYP JOB NAME: 04KO906DMC

LOCAIN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
(a)	01	YC-10	93	H21255	2300	100.00	46	50	2300	2300
	01	YC-10	93	H2K57	1400	100.00	28	50	1400	1400
	01	YC-10	93							

WAREHOUSE REQUEST NO. 109

EQUIPMENT		NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
		"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
211 & 208	1	RUN 60"(990 G) WATER IN V-211 & ADD ASSUME 50% SET AGITATOR ON HIGH SPEED.	26	7-D	13
	2	WEIGH IN DRUM AND POUR IN	245	32-D	245
	3	DUMP IN AND STIR 5 MINS. LOT	74X50	YC10B	3700
		RECORD: START 6:05 PM H21255	2300		
1		FIN 7:12 PM H2K57	1400		
	4	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	5	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208			
	6	WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 1800-2200 PSI INTO V -208			
	7	RECORD: V-208 VOL. 37 " & ADJUST TO 45"(1662G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV 2	9	RUN 15" (793 G) WATER INTO V-246 & START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV RECORD: TIME START 12:10 TOTAL MINUTES 120			
	11	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 3	12	WHILE HOMOG, RUN 5" (237 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	2165	32-D	2165
	15	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	16	ADJ V-349 TO 20" (946 G) & STIR 15 MIN			
	17	RECORD DENSITY: 1.081 G/ML (1,078-1.081)			
SV 4	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60"(3084 G)			
	19	RECORD: PH 10.4 & ADJ TO 10.4-10.8 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
		ASSUME 50%	____	7-D	____
	20	SIPHON N-7-D INTO SV & RECORD: PH ___ HEAT TO 190-194*F IN 55-65 MIN & REC HT 192 *F & RECORD 192 *F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

LOT= _____ COMTYP JOB NAME = 04KO906DMC PAGE 02 DATE PRINTED: 6/15/82

EQUIPMENT		PAGE 2 CG 04 KO-906-D PROD- "C" V-246	USE LBS	N-CODE	USE LBS
343 & 386 5	21	WHILE HEATING SV RUN 46* (126SC) WTR INTO V-343			
	22	METER IN FROM V-386 M24 10682/GAL 30.0 GAL		27-D	320
	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1019 G/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.10			
	26	SET V-343 ACID PUMP AT 65 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 57 SETTING (180 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
SV 6	29	AT 190-194*F DURING STRIKE			
		RECORD: START FINISH MINUTES			
		V-343 3:00 2:30AM 240			
		V-349 3:00 6:45AM 190			
		TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH			
		AT 20 MIN 3:50 (43) (18) 9.5 (9.3-10.0)			
		40 MIN 4:10 (39) (16) 9.5 (9.3-10.0)			
		1 HR 4:30 (35) (13) 9.2 (9.3-10.0)			
		2 HRS 5:30 (22) (7) 9.6 (9.3-10.0)			
		3 HRS 6:30 (10) (0) 9.8 (9.3-10.0)			
		FINISH 7:15 (0) 6.3 (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	SIFT IN	55	128-A	55
385 7	31	ADD 38* (295 G) WATER TO V-385			
	32	ADD & STIR FOR 2 MIN FOR S 62 0 ASSUME 50%	136	7-D	68
	33	DURING STRIKE CHECK LEVEL IN V-387.			
387 8	34	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37			
	35	IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
	36	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW STEARATE MAKE-UP PROCEDURE.			
	37	RUN IN 27* (268 GAL). DO NOT MAKE UP THIS SOLUTION MORE THAN 30 MINUTES IN ADVANCE. DELAY BETWEEN END OF STEP 43 HEAT-UP AND START OF STEP 52 HOMOGENIZATION SHOULD BE LESS THAN 30 MINUTES.			
388 9	38	TURN ON STEAM & AGITATOR			
	39	ADJUST TO 37* (366 GAL) AT 178-182*F			
	40	SET BADGER METER FOR 572#			
	41	PUMP IN FROM V-387 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE	468	169-A	468
			52	155-A	52
			52	160-A	52
	42	SHUT OFF PUMP			
	43	STIR 30 MIN AT 178-182*F FOR S 52			
	44	DO NOT SHUT OFF AGITATOR			
SV 10	45	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING.			
	46	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR.			

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EQUIPMENT		PAGE 3 CG 04 KO-906-D PROC-"C" COMTYP JOB NAME: 04KO906DMC	USE LBS	N-CODE	USE LBS
	47	HEAT TO 198-200*F IN 5-10 MIN			
SV 10 CONT.	48	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
	49	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
	50	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
	51	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
	52	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200*F.			
	53	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
	54	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
	55	TURN OFF HOMOG & STEARATE PUMP			
	56	STIR 5 MIN AT 198-200*F			
	57	SHUT OFF STEAM			
	58	RUN IN ALUM USING BADGER METER	540	115-D	270
	59	FLUSH ALUM LINE WITH WATER			
	60	RECORD: PH 3.62 (3.3-3.7)			
	61	IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY) & RECORD: PH____. NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION. ASSUME 50%	_____	115-D	_____
	62	RUN IN N-7-D FROM S32 IN 4-6 MIN & STIR 5 MIN			
	63	RECORD: PH 4.0 (4.0-4.2) & IF NECESSARY, ADJ TO PH 4.0-4.2 & RECORD: PH____. ASSUME 78%	_____	27-D	_____
		(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	_____	7-D	_____
		SIPHON N-7-D INTO SV			
	64	DO NOT STOP AGITATOR			

6:00 PM 11:00 PM 320-129
11P 7A 120-126
7:00 AM 9:30 AM 409

WAREHOUSE REQUEST FORM

REQUEST NO. 10981
9/24/82

DELIVER TO Making Area BY 9/28/82 7 AM

FOR: CG 04 CODE K0906D LOT K2H29 SCHEDULED 9/28/82

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
BAY 2	01	YC010B	93	H2K55	2300		46	50	2300	_____
B-1&2	01	YC010B	93	H2K57	1400		28	50	1400	_____

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

DUP050103598

WAREHOUSE REQUEST FORM

REQUEST NO. 10981
9/24/82

DELIVER TO Making AREA BY 9/28/82 7 AM

FOR: CG 01 CODE K09060 LOT K2H29 SCHEDULED 9/28/82

WHSE LOCATN	CG	CODE	PO	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
BAY 2	01	YC0105	93	H2K55	2350		46	50	2300	
B-1&2	01	YC0108	93	H2K57	1400		28	50	1400	

PICK UP AND RETURN TO STORAGE:

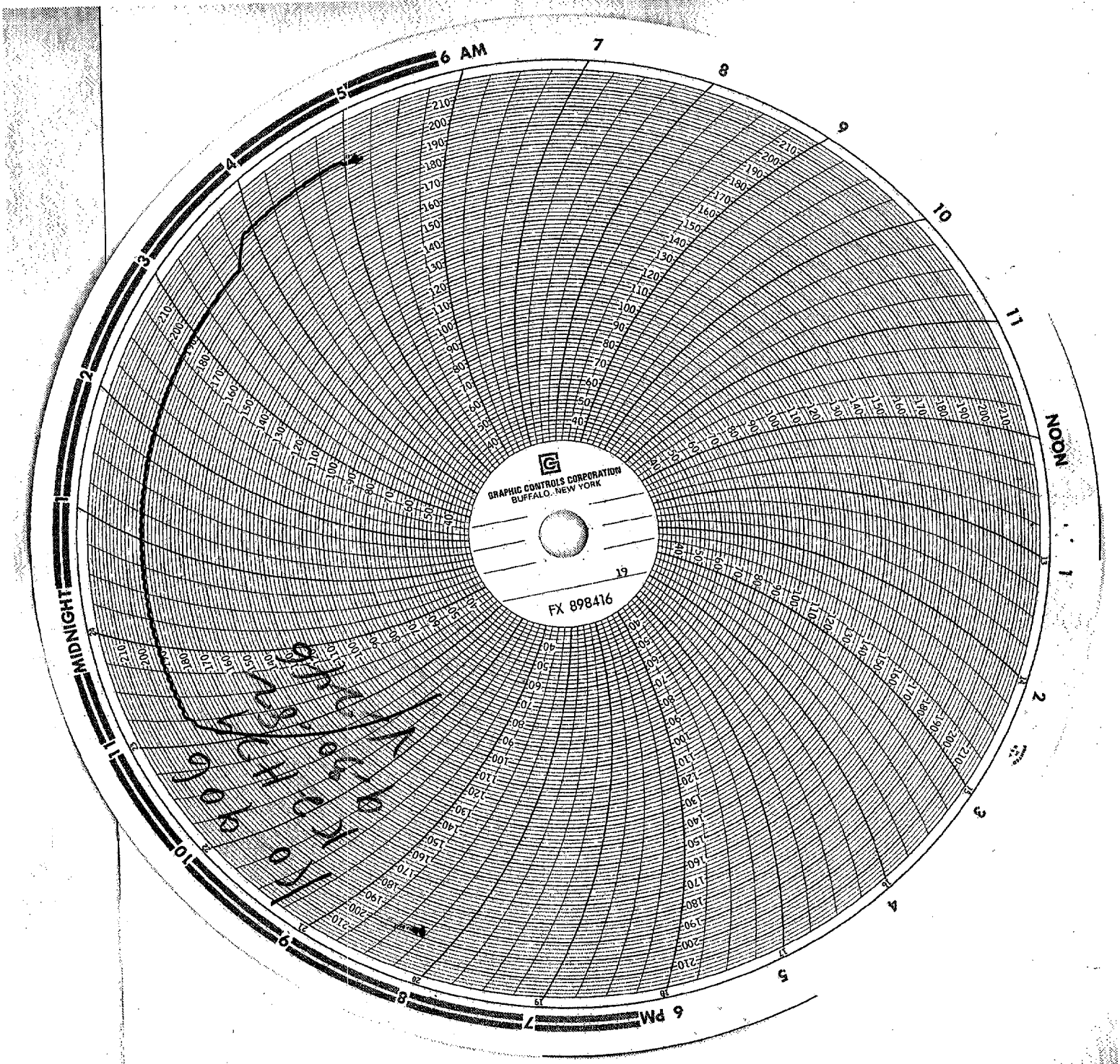
LOCATN	CG	CODE	PO	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT

EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE ___/___/___

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

DUP050103599



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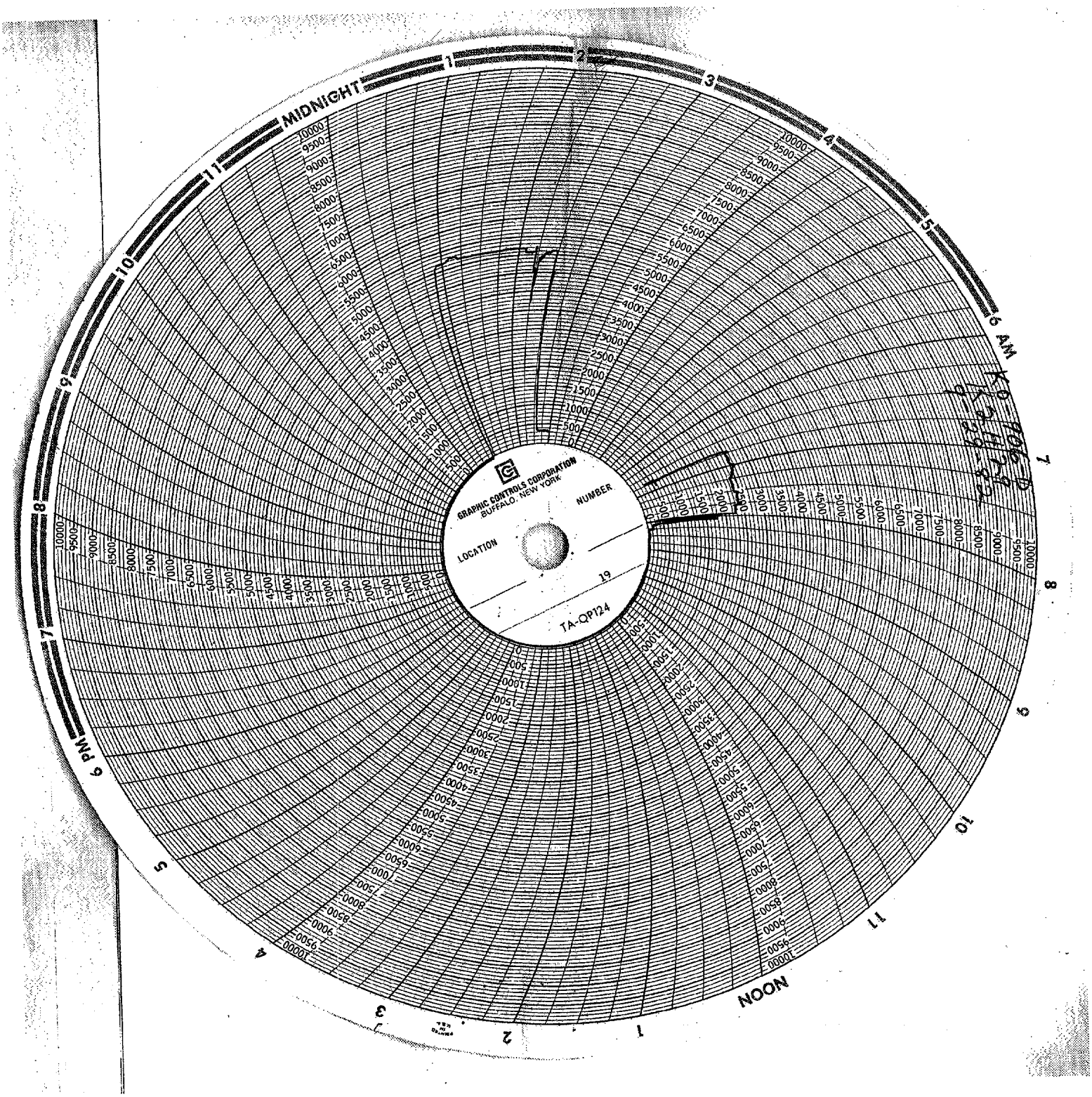

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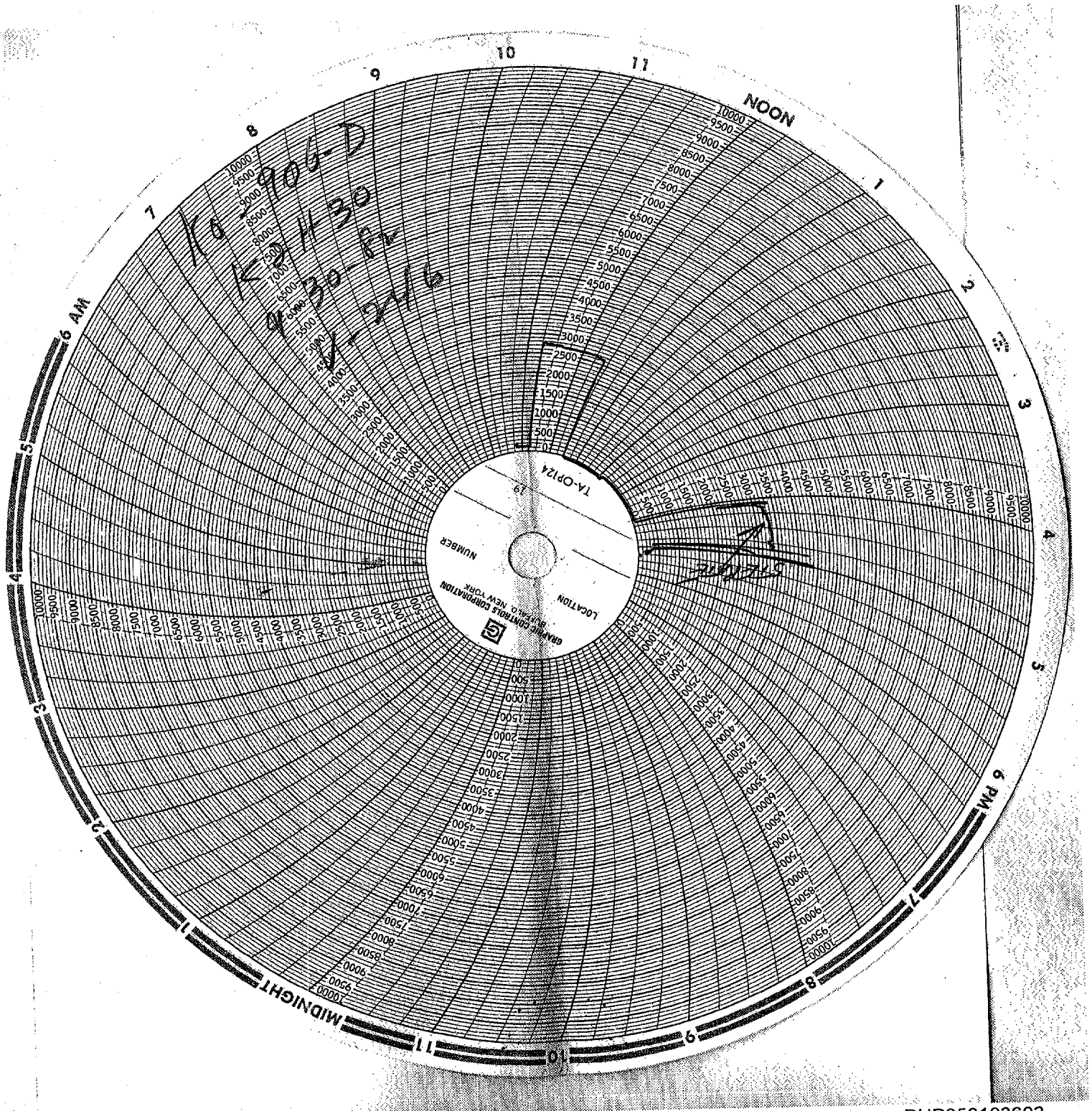

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