

(MANUAL)

S.V. ~~244~~ 262

JUN 2, 1980

C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.CG 03 CODE KY-795-D PKG
LOT

JUN 18 36130

EST'D WGT 934 LBS

STANDARD HRS. 11.1 TIME

PROCESSES APPROVED BY

() KY-795-D (I) FWP 5/22/80

() (3/4 N-32-D STRIKE TO

() IMPROVE GLOSS)

() (30 MIN LONGER STRIKE TIL

() STRIKE LINE IS REPLACED)

TYPED BY: FWP 5/22/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

Spring re-ground YC-2-B. See warehouse request
14 omog #3-1st Pass
TOTAL EST'D WGT 4588 4784
NON-BLEEDING

EQUIP	NAME	USE LBS	N- CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
2603	2 WEIGH IN DRUM & POUR IN	500	32-D	500
	3 DUMP IN AND STIR 5 MIN	77X50	YC-2-B	3850
	RECORD: START 12:45 PM	24785		24
	FIN 2:45 PM	24773		7
		24787		5
	4 ADJUST TO 75" (1275 G)	24465		4
	5 WITH AGITATOR ON LOW SPEED PUMP 203 THRU	82205		203
	HOMOG AT 2400-2600 PSI INTO V-205	263		
	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN	3500		
	OF HOT WATER AT 2400-2600 PSI INTO V-205	2070		
	7 RECORD: V-205 VOL 263" & ADJ TO 51" (1874 G)	3500		
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
2605	9 RUN 5" (514 G) WATER INTO V-205 & START			
SV	10 AGITATOR			
	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 9:30 PM TOTAL MINUTES 180			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
14	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP			
	THRU HOMOG AT 4800-5200 PSI INTO SV			
349	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
&	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F	2000	32-D	2000
384	14 WEIGH INTO V-384 & PUMP TO V-349			
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 29" (1372 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.050 G/ML (1.049-1.051)			
	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 25" (2496 G)			
	19 RECORD: PH 10.7 & ADJ TO 11.1-11.3 USING N-7-D			
	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	14	7-D	7
	SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 190°F			
	& RECORD: 190°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON			

V-262

USE LBS N- CODE USE LBS

✓ 21 WHILE HEATING SV, RUN 69" (1898 G) WATER INTO
343 V-343
& ✓ 22 METER IN FROM V-386 M 39, 10.94 #/GAL, 28.5 GAL
386 ✓ 23 STIR 15 MIN OR LONGER
5 ✓ 24 RECORD: DENSITY 1.010 G/ML (1.010-1.012)

✓ 25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0
✓ 26 SET V-343 ACID PUMP AT 82 SETTING (265 MIN)
✓ 27 SET V-349 SILICATE PUMP AT 70 SETTING (210 MIN)
✓ 28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
SV AT 190-194°F DURING STRIKE.
6 ✓ 29 RECORD: START FINISH MINUTES
V-343 1400A 6:50 AM 310
V-349 5:10 AM 210
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 2:00 (65) (26) 9.9 (9.0-10.0)
40 MIN 2:40 (59) (23) 9.9 (9.0-10.0)
1 HR 3:40 (54) 53 (21) 9.9 (9.0-10.0)
2 HRS 4:40 (38) 43 (12) 9.9 (9.0-10.0)
3 HRS 5:40 (22) 33 (4) 9.9 (9.0-10.0)
3 1/2 HRS 6:10 (15) (0) 10.0 (9.0-10.0)
FINISH 6:05 (0) 7:27 (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 ✓ 30 RUN 14" (108 G) WATER INTO V-385 & HEAT TO
7 135-140°F
✓ 31 DUMP IN & STIR TO DISSOLVE FOR S-38 220 15-A 220

DRUM ✓ 32 WEIGH INTO 55 GAL DRUM ✓ 60 7-D 30
8 ✓ 33 FILL WITH WATER & STIR 2 MIN FOR S-40

SV ✓ 34 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP TO ZERO SETTING
9 ✓ 35 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
✓ 36 TURN OFF STEAM
✓ 37 SIFT IN 150 128-A 150
✓ 38 RUN IN V-385 FROM S 31 & STIR 5 MIN
✓ 39 RECORD: PH 3.3 (3.3-3.7) & IF NECESSARY ADJ
(DOWN ONLY) TO 3.3-3.7 & 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
✓ 40 SIPHON IN N-7-D FROM S-33 IN 4-6 MIN & STIR 5
MIN
✓ 41 RECORD: PH 3.07 (4.0-4.2) & IF NECESSARY ADJ TO
PH 4.0-4.2 & RECORD: PH 4.05 ASSUME 77% 27-D
DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 80 7-D 40
SIPHON N-7-D INTO SV
✓ 42 POUR IN STIR 15 MIN 45 978-A 45
✓ 43 STOP AGITATOR

START FINISH OPERATOR
7:00A 3:00P 235-144
10:00 10:00 12:00-50
STEP V-262 8:15A V-26 235-370

REQUEST NO. 3456
6/13/80

DELIVER TO MAKING AREA BY 6/16/80 11 AM

240

FOR: CG 03 CODE KY795D LOT 36130 SCHEDULED 6/13/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
Temp	14	YC002B	93	36130 822042	3850		77	50	3850	-----

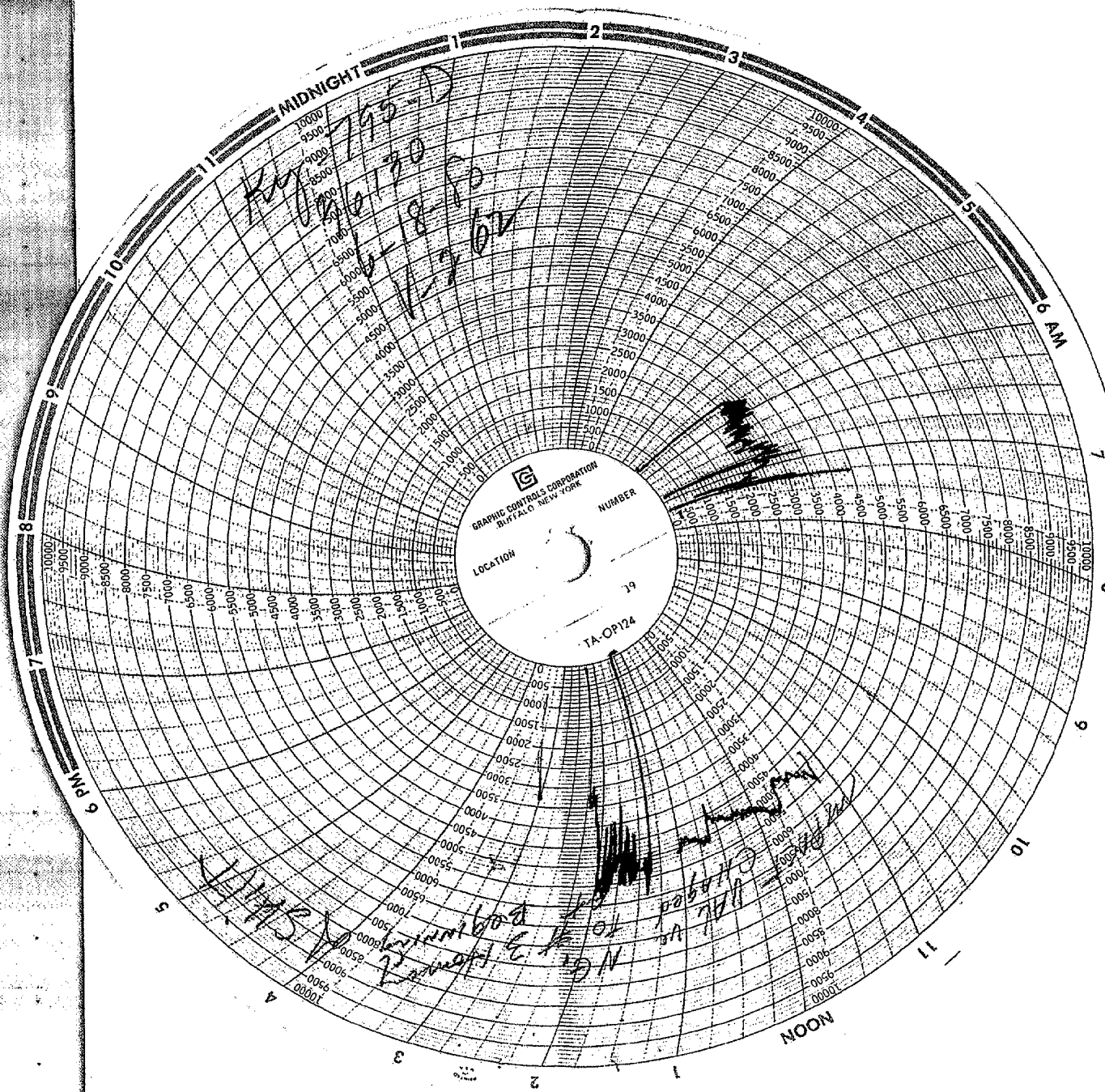
PICK UP AND RETURN TO STORAGE:

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT
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EXPLANATION FOR SHORTAGE/OVERAGE:

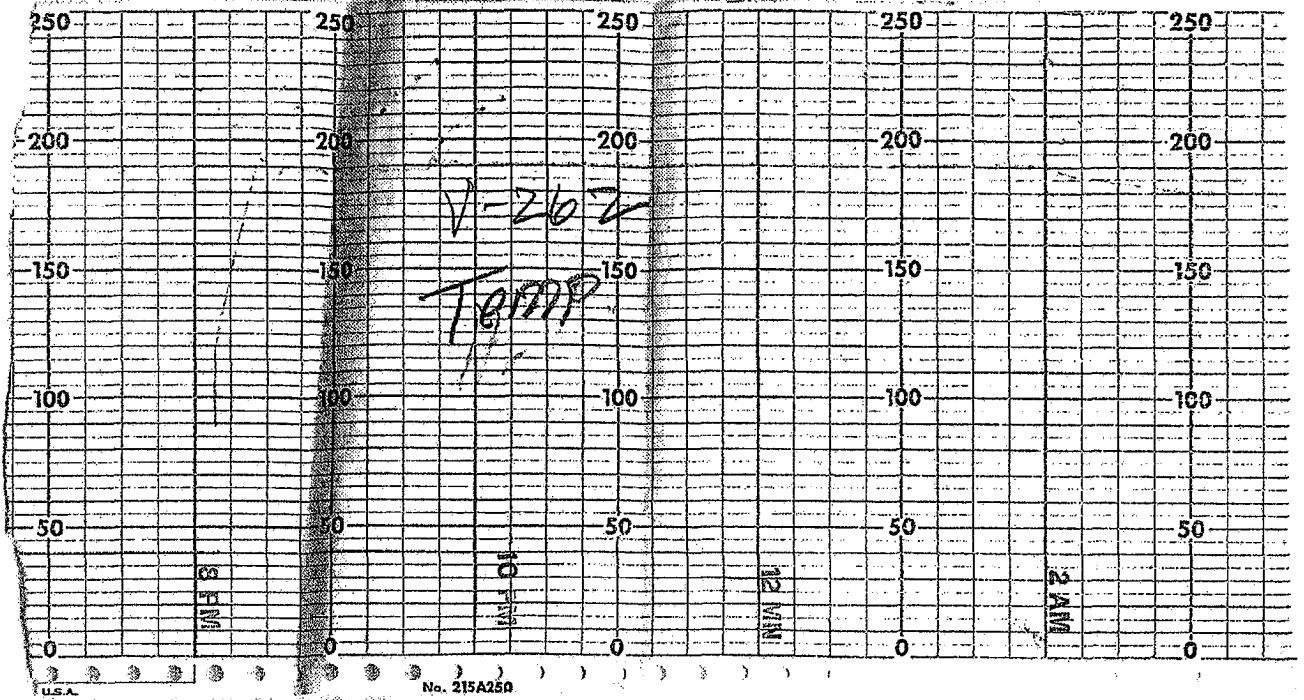
SIGNED _____ DATE ____/____/____

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



N32198.01

DUP050457037



N32198.02

DUP050457038