

CG 04 CODE KD-909-D PKG

PROCESSES

APPROVED BY

EST'D WGT 1596 LBS

() KD-909-D (C)

FWP 11/3/80

STANDARD HRS.

TIME 11A M

TYPED BY: PLUMMER 11/3/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	36407	3000
01	YC016B	93	36360	300
01	YC016B	93	37336	600

NOV 14 1980

NOV 12 1980

TOTAL EST'D WGT 5296

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	480	983-D	480
	3 DUMP IN AND STIR 5 MINS. RECORD: START 930 AM	78 X50	YC16B	3700
		3000		3700
	FIN 1 PM	300		
		600		
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG 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. 41" & 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 110A TOTAL MINUTES 120			
	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	2500	983-D	2500
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349	2000		2000
	3 16 ADJ V-349 TO 19" (899 G) & STIR 15 MIN.			
	17 RECORD DENSITY: 1.077/ML (1.074-1.074)			
SV & 4	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 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%	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: 194°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

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EQUIP	PAGE 2	CG 04	KO-909-D	EST WGT 5296#	USE LBS	N- CODE	USE LBS
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V-247

343	21	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343				
&	22	METER IN FROM V-386 M. 9.15 #/GAL, 40.7 GAL		27-D	373	
386	23	STIR 15 MIN OR LONGER				
5	24	RECORD: DENSITY 1.019 G/ML (1.018-1.020)				

SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.8				
	26	SET V-343 ACID PUMP AT 69 SETTING (225 MIN)				
	27	SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)				
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE				
	29	RECORD:				
		START FINISH MINUTES				
		V-343 6:14G 9:30A 225				
		V-349 5:45 8:45A 180				
		TIME V-343 V-349 SV NORMAL				
		INCHES INCHES PH PH				
		AT 20 MIN 6:05 (46) (17) 9.5 (9.3-10.0)				
		40 MIN 6:25 (41) (15) 9.4 (9.3-10.0)				
		1 HR 6:45 (37) (13) 9.4 (9.3-10.0)				
		2 HRS 7:45 (23) (6) 9.4 (9.3-10.0)				
		3 HRS 8:45 (10) (0) 9.3 (9.3-10.0)				
		FINISH 9:30 (0) 7.5 (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	END IN		50	100-A	50

385	31	RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140°F				
7	32	DUMP IN & STIR TO DISSOLVE FOR S-61	477	15-A	477	

302	33	ADD 38" (465 G) WATER TO V-302				
8	34	ADD & STIR FOR 2 MIN FOR S 64 ASSUME 50%	296	7-D	148	

PT	35	DURING STRIKE PUMP INTO PT	482	169-A	482	
	36	PUMP IN	54	155-A	54	
9	37	PUMP IN	54	160-A	54	
	38	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42				

	39	DURING STRIKE RUN 15" (268 G) WATER INTO V-356				
	40	TURN ON STEAM				
356	41	ADJ TO 21" (366 G) AT 81-82°C				
10	42	PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE				
	43	RINSE PT WITH HOT WATER FROM HOT WATER MIXER & PUMP IN				
	44	SHUT OFF PUMP				
	45	STIR 30 MIN AT 81-82°C FOR S 55				
	46	DO NOT SHUT OFF AGITATOR				

USE
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NOV 3 1980

- SV 147 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
- 11 148 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
- 149 STIR 60 MIN AT 198-194°F
- 150 HEAT TO 198-200°F IN 5-10 MIN
- 151 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
PUMP
- 152 OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP
INLET
- 153 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
THRU HOMOG AT 2900-3100 PSI TO SEWER
- 154 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE
TO SV & CLOSE VALVE TO SEWER
- 155 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100
PSI. MAINTAIN SV AT 198-200°F.
- 156 WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE
AT STEARATE PUMP ASAP
- 157 WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT
WATER FROM HOT WATER MIXER
- 158 TURN OFF HOMOG & STEARATE PUMP
- 159 STIR 5 MIN AT 198-200°F
- 160 SHUT OFF STEAM
- 161 RUN IN V-385 FROM S-32 & STIR 5 MIN
- 162 RECORD: PH 3.0. (3.4-3.8)
- 163 IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY)
& RECORD: PH .
- 164 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
- 165 RECORD: PH 5.5. (6.2-6.4) & IF NECESSARY, ADJ
TO PH 6.2-6.4 & RECORD: PH 6.2 ASSUME 78%
(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%
SIPHON N-7-D INTO SV
- 166 DO NOT STOP AGITATOR

27-D
7-D2.01.0START
6:20 A.M.FINISH OPER
7:10 A.M. 54-1011100 P
7:00 A.M.700 A
1:30 P.M.259-101
237-244

WAREHOUSE REQUEST FORM

REQUEST NO. 3601
11/07/80DELIVER TO MARKING AREA BY 111080 11 AM/PM

FOR: CG 04 CODE K0909D LOT 37789 SCHEDULED 11/06/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
35-B3	01	YC016B	93	36407	3000		60	50	3000	-----
P2-SEC	01	YC016B	93	36360	300		6	50	300	-----
35,B10	01	YC016B	93	37336	600		12	50	600	-----

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

