

246 247

C.V.

D.V.

06 04 CODE K0-786-D PKG.

12/26 DEF 33324

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME

01 YC-10-B 93 4 30922 450#
01 YC-10-B 93 4 33052 400#
01 YC-10-B 93 4 33051 250#

Total Weight 4962# (Req. 0480)

PROCESSES		APPROVED BY
() K0-786-D	(P)	EWK 9-21-76
()	()	DCG 9-21-76
()	()	MTW 10-1-76
TYPED BY		
JIC 11-16-76		

01 YC-10-B 93 4 33055 250#
01 YC-10-B 93 4 33054 7100#
01 YC-10-B 93 4 33059 400#
01 YC-10-B 93 4 32830 50#
NON-BLEEDING

#	INSTRUMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
2.1		Run 60" (990 G) water in V-211 and add Assume 50%	30	7-D	15
208		Weigh in drum and pour in V-211	270	32-D	270
1		Dump in and stir 5 minutes LOT	82 x 50	YC-10-B	4100
		Record: Start 12:30 V/100 33055	2500		
		Fin 2:30 V/100 33054	1100		
		75" (1275 G) 33059	400		
		Adjust to 80" (1370 G) 32830	50		
		Pump V-211 thru Homog #2 at 1800-2200 psi into V-208	4100		
		When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
		Record: V-208 Vol 14 2" and adjust to 50" (1840 G)			
		Inspect homog strainer and clean if necessary			
208		Run 15" (771 G) water into V-246 and start agitator and install temperature chart			
SV		Pump V-208 thru Homog at 4800-5200 psi into SV			
2		Record: Time Start 9:20 PM Total Minutes 130			
		Note: If homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
		When V-208 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349		While Homog, run 6" (284 G) water into V-349			
384		Run ±1000# water into V-384 and heat to 110-120°F			
		Weigh into V-384 and pump to V-349	2400	32-D	2400
		Run ±1000# water into V-384 and pump to V-349			
		Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer			
		Record: 9:10 PM (10.9 ±0.2) 1.078-1.081			
SV		When S. Homog complete, adjust to 66" (3400 G) in SV			
xl		Record: pH 10.7 and adjust to 10.4-10.8 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon N-7-D into SV and Record: pH 10.7			
		Heat to 190-194°F in 55-65 minutes & Record: HT 192°F and Rec 192°F			
		Note: Strike must be started immediately on completion of heating			
343		While heating SV, run 51" (1400 G) water into V-343			
386		Meter in from V-386 M 8.3 #/Gal 2.88 Gal 35.9		27-D	355
5		Stir 15 minutes or longer			
		Record: 9:14 PM (2.8 ±0.1) 1.017-1.019			

91 mL

✓ 246

EQUIPMENT	PAGE	2	CG	04	CODE	K0-786-D (2)	EST. WGT.	4962	LBS.	USE LBS.	N CODE	ACT. LBS.
SV 6	25	When S 20 heating complete. Record: pH 9.9 (9.6-10.2)										
	26	Set V-343 acid pump at 72 setting (±225 minutes)										
	27	Set V-349 silicate pump at 66 setting (±180 minutes)										
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-193°F during strike										
	29	Record:	Start	Finish	Minutes							
			V-343	12:35 PM	4:40	245						
			V-349	12:35 PM	3:40	185						
		Record:	Time	V-343	V-349	SV	Normal					
				Inches	Inches	pH	pH					
		at 20 min	12:35 PM	(47) 40	(20) 20	9.5	9.3-10.0					
		40 min	1:15 PM	(43) 44	(17) 17	9.5	9.3-10.0					
		1 hr	1:35 PM	(38) 30	(15) 15	9.5	9.3-10.0					
		2 hrs	2:35 PM	(24) 25	(7) 7	9.5	9.3-10.0					
		3 hrs	3:35 PM	(10) 11	(0) ±1	9.5	9.3-10.0					
		Finish	4:20 PM	(0) 0	0	6.5	7.5-8.5					
		Note: if pH drops below 9.3 in 1st hour, stop pumps and see supervisor. If final pH is above 8.5, adjust to (7.5-8.5) and Record: pH Assume 77%										
		27-D										
357 7	30	Run 21" (150 G) water into V-357 and heat to 135-140°F										
	31	Dump in and stir to dissolve										
		300 15-A 300										
302 8	32	Add 42" (514 G) water to V-302 2-D										
	33	Add and stir 2 minutes Assume 50%										
		150 7-D 75										
SV 9	34	When V-349 MTY, rinse in with minimum water then set pump to zero setting										
	35	When V-343 MTY, rinse in with minimum water, then turn off pump motor										
	36	TURN OFF STEAM										
	37	Run in V-357 from S 31 and stir 5 minutes										
	38	Record: pH 3.5 (3.3-3.7)										
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH 15-A										
	40	Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes										
	41	Record: pH 4.1 (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH Assume 77%										
		27-D										
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%										
		7-D										
		Siphon N-7-D into SV										
	42	Stop agitator										
		START	FINISH	OPTR								
		3:00 PM	11:00 PM	438-409								
		11:00 A.M.	5:20 A.M.	201-333								

REQUEST FOR MATERIAL

REQUEST NO.

0480

DATE

12/13/79

DELIVER TO Making Area BLDG. 6 FLOOR 3RD BY 12/16/79 7:15 A.M.FOR CODE K07860 LOT 33324

WRITTEN BY

C. J. N. O.

Production Control

Whse. Loc.	Code	Pkg./ Qunt.	Lot	No. Pkg.	Net	Total Dry Weight	Lbs. Dry Received	SUPERVISOR*		CONSUMPTION DATA									
								Delivering Area	Receiving Area	Lbs. Pulp/Paste	Dry Content	Lbs. Dry	Consume Lbs./Hr.	Lbs. Consumed	Balance Remaining	Consuming Supp.			
Bay 3	YE-10-B	93	30922	9	50	450													
Bay 1	YE-10-B	93	33052	8	50	400													
Bay 1	YE-10-B	93	33051	5	50	250													
Bay 2	YE-10-B	93	33055	60	50	3000													

PICK UP AND RETURN TO STORAGE THE FOLLOWING:

LOCATED IN _____ BLDG., _____ FLOOR.

Code	Lot	Net	No. of Packages	Total Net Weight	Whse. Loc.

*Each Supervisor must explain weight differences on reverse side.

PRODUCTION CONTROL COPY
 OPERATING FILE COPY
 WAREHOUSE FILE COPY
 RAW MATERIAL FILE COPY
 PRODUCTION CONTROL FILE COPY

- WHITE
 - YELLOW
 - GREEN
 - BLUE
 - PINK

PLACED IN LOCATION BY: OPER. # _____ DATE _____ SUPVR. _____



