

NOV 8, 1982

L2J50

5179*

 PROCESSES
 () KD-789-D (I) FWP 11/04/82
 COMTYP JOB NAME: 04K0789DMI

 (DATE) (LOT) (EST WGT)
 WAREHOUSE REQUEST NO. 11076

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC016B	93	<u>K2J83</u>	<u>3000</u>	100.00	<u>60</u>	50	<u>3000</u>	<u>3000</u>
	01	YC016B	93	<u>K2H23</u>	<u>1200</u>	100.00	<u>24</u>	50	<u>1200</u>	<u>1200</u>
	01	YC016B	93			100.00		50		
	01	YC016B	93			100.00		50		
	01	YC016B	93			100.00		50		

EQUIP	NAME : 'KROLOR' ORANGE Y	NON-BLEEDING	USE LBS	N-CODE	ACCT LBS
211 & 208	"BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF." 1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED. 2 WEIGH IN DRUM AND POUR IN (SODIUM SILICATE) 3 DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE) RECORD: START <u>6:30 PM</u> FIN <u>8 PM</u> 4 ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD. RECORD PH: <u>11.2</u> (9.0-10.5) 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 HOT WATER AT 2800-3200 PSI INTO V-208 7 RECORD: V-208 VOL. <u>38</u> & ADJUST TO 54" (1890G) 8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY		530	32-D	530
208 & SV	9 RUN 10" (514 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 <u>8:35 PM</u> TOTAL MINUTES <u>120</u> 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 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: <u>1.185</u> G/ML (1.082-1.086)		2545	32-D	2545
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G) 19 RECORD: PH <u>10.9</u> & ADJ TO 11.1-11.3 USING N-7-D (CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1 PART N-7-D) 4 SIPHON N-7-D INTO SV & RECORD: PH <u>11.3</u> ASSUME 50% 20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT <u>190</u> *F & RECORD: <u>190</u> *F. STRIKE MUST START IMMEDIATELY		14	7-D	7

EQUIP	MENT	PAGE 2 CG 04 KO-789-D ✓-246	USE LBS	N- CODE	ACCT LBS
343	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343			
&	22	METER IN (SULFURIC ACID 60%) FROM V-386	354	27-D	390
386		M28, 11014#/GAL, 354 GAL			
5	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.019 G/ML (1.018-1.020)			
		NOTE: THIS PROCESS CALLS FOR N-27-D ON SURFACE.			
		BE SURE HOSE IS NOT IN UNDERSURFACE STRIKE LINE			
SV 6	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.2			
	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 12:30A 4:45A 225			
		V-349 4:00A 210			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 12:50 (49) 4.9 (20) 2.1 9.9 (9.3-10.0)			
		40 MIN 12:10 (45) 4.5 (18) 1.9 9.9 (9.3-10.0)			
		1 HR 11:30 (41) 4.1 (16) 1.6 9.9 (9.3-10.0)			
		2 1/4 HR 2:43 (25) 2.6 (8) 2 8.5 (9.3-10.0)			
		3 1/2 HR 4:03 (9) 1.0 (0) - 8.5 (9.3-10.0)			
		FINISH 4:45 (0) - 8.0 (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	
385	30	ADD 67" (514 G) WATER TO V-385			
7	31	ADD & STIR 2 MIN	330	7-D	165
SV	32	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
8	33	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	34	STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM			
		RECORD: START 4:45			
	35	RUN IN LIQUID ALUM USING BADGER METER	1060	115-D	530
	36	FLUSH ALM LINE WITH WATER			
	37	RECORD: PH 3.3 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH			
		NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION.			
		ASSUME 50%		115-D	
	38	RUN IN N-7-D FROM S31 IN 10-12 MIN & STIR 5 MIN			
	39	RECORD: PH 6.4 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH			
		DILUTE N-7-D 10 TO 1 WITH WATER			
		ASSUME 77%		27-D	
		ASSUME 50%		7-D	
		SIPHON N-7-D INTO SV			
	40	POUR IN (PLASTOLEIN 9746A) & STIR 15 MIN	50	978-A	50
	41	STOP AGITATOR			
		START FINISH OPERATOR			
		3:00pm 11:00pm 320			
		11:00 5:45A 126			





