

CG 04 CODE KO-786-D PKG PROCESS APPROVED BY:
 NOV 3, 1982 L2H90 5084* () KO-786-D (P) FWP 10/04/82
 (DATE) (LOT) (EST WGT) COMTYP JOBNAME: 04KO786DMP
 TIME: 7:00 A.M. STANDARD HRS. 10.5

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
01	YC-16	98		52488	250	100.00	5	50	250	250
01	YC-10	93		62133	1250	100.00	25	50	1250	1250
01	YC-10	93		62190	1950	100.00	39	50	1950	1950
01	YC-10	93		52504	850	100.00	17	50	850	850

SUBSTANDARD BLEND-BACK FOR S-40: CODE _____, LOT _____, PQ _____
 REQ. NO. (110Y1) NON-BLEEDING

EQUIP MENT	NAME	"KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
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BEFORE USING SV, MAKE SURE THAT N-28-D (HYDRO-CHLORIC ACID) LINE, IF ANY IS BLANKED OFF.
 211 1 RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50%
 & CAUSTIC SOLN) & SET AGITATOR ON HIGH SPEED
 208 2 WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)
 3 DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE)
 RECORD: START 9:40 A.M. LOT 250
 FIN 10:45 A.M. 22204
 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
 WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN
 HOT WATER AT 1800-2200 PSI INTO V-208
 7 RECORD: V-208 VOL. 46" & ADJUST TO 50" (1840G)
 8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY

208 9 RUN 15" (771 G) WATER INTO V-246, START
 & AGITATOR & INSTALL TEMP CHART
 SV 10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.
 RECORD: TIME START 5 A.M. 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 12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349
 & 13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F
 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 22" (1040 G) & STIR 15 MIN
 17 RECORD DENSITY: 1.080 G/ML (1.078-1.081)

SV 18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 36" (3400 G)
 19 RECORD: PH 10.8 & ADJ TO 10.4-10.8 USING N-7-D
 4 DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)
 ASSUME 50%
 SIPHON N-7-D INTO SV & RECORD: PH _____
 20 HEAT TO 190-194°F IN 55-65 MIN & RECORD: 196°F
 & RECORD: 194°F

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EQUIP	MENT	PAGE 2 CG 04 KO-786-D	USE	N-	ACCT
			LBS	CODE	LBS
343	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343			
386	22	METER IN (SULFURIC ACID 60%) FROM V-386		27-D	355
5	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY <u>1.018</u> G/ML (1.018-1.020)			
SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH <u>9.8</u>			
6	26	SET V-343 ACID PUMP AT 72 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 66 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 <u>8:00</u> <u>11:50</u> <u>230</u>			
		V-349 <u>8:00</u> <u>11:55 A.</u> <u>185</u>			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN <u>8:20</u> (47) <u>4P</u> (20) <u>19</u> <u>9.7</u> (9.3-10.0)			
		40 MIN <u>8:40</u> (43) <u>43</u> (17) <u>17</u> <u>9.7</u> (9.3-10.0)			
		1 HR <u>9:00</u> (38) <u>---</u> (15) <u>---</u> <u>9.7</u> (9.3-10.0)			
		2 HR <u>10:00</u> (24) <u>23</u> (7) <u>9</u> <u>9.6</u> (9.3-10.0)			
		3 HR <u>11:00</u> (0) <u>2</u> (0) <u>---</u> <u>9.6</u> (9.3-10.0)			
		FINISH <u>11:45</u> (0) <u>1</u> <u>7.2</u> 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	150	7-D	75
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	TURN OFF STEAM			
	35	RUN IN LIQUID ALUM USING BADGER METER	480	115-D	300
	36	FLUSH ALUM LINE WITH WATER.			
	37	RECORD: PH <u>3.3</u> (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & 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 S 33 IN 4-6 MIN & STIR 5 MIN			
	39	RECORD: PH <u>4.2</u> (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH _____			
		ASSUME 77%		27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER			
		ASSUME 50%		7-D	
	40	SIPHON N-7-D INTO SV			
		WHEN SCHEDULED ON TOP OF PAGE 1, DUMP IN SUBSTANDARD TO BE BLENDED BACK.			
		RECORD: CODE _____, LOT _____, # _____			
	41	STOP AGITATOR			
		START FINISH OPERATOR			
		<u>3:PM</u> <u>11:PM</u> <u>54-126</u>			
		<u>11:00PM</u> <u>7:00AM</u> <u>407-408</u>			
		<u>7:00</u> <u>1:15PM</u> <u>362</u>			



